



## Welder Performance Qualification Certificate (WPQ)

Qualification: Codes/Standards

Lloyd's Register Rules for the Manufacture, Testing and Certification of Materials (July 2021)

Designation(s):

Lloyd's Register Rules Part 2: GTAW - FCAW T WQ11 D273 t22 6Gu B

Welding Procedure

Specification Reference No.

WPS LAB 3378

Welder's Name

G. Idasiak

Welder's Signature

Identification:

GI

Method of Identification:

Drivers License

Date and place of birth:

20 January 1979 – Wielun

Employer:

Eerland Shiprepair BV

Job knowledge:

Not Tested

Test piece

Range of qualification



Welding process(es)

GTAW: root and hot pass – FCAW: fill and cap layers

GTAW with or without filler wire Ch 12. Section 5.6.7  
FCAW Ch12. Section 5.6.6

Plate or pipe or other

T (Tube / Pipe)

T (Tube) & P (Plate)

Type of joint/weld

Single V groove Butt weld

Buttweld - Filletweld Ch.12 section 5.6.12

Material group WQ11

WQ11 as per LR Rules part 2 Chapter 12 Table 12.5.2

Material group/sub-group

Solid wire: T-2594

Solid Wire Ch.12 section 5.6.6

Kiswel

EN ISO 14343-A:25 9 4 N L

Filler metal type and consumable or designation

Tubular Rutile Powder Cored Wire: DW-2594  
Kobelco Welding of Europe BV

Flux Cored Wire Ch.12 section 5.6.6

EN ISO 17633-A T 25 9 4 N L P M21 1

Shielding gas

99.996% Ar (According to ISO 14175 Group I1  
82% Ar-18% Co2 (According to ISO 14175 Group M21)

No changes in components allowed Ch12.section 5.6.16  
Changes in components allowed Ch12. section 5.6.16

Auxiliaries (e.g. backing gas, flux)

B (99.996% Ar (According to ISO 14175 Group I1)

A, B, C, D, E & F Ch12.table 12.5.6

Material thickness

22mm

$\geq$  3.0mm

Weld metal thickness

GTAW: Weld metal thickness 6.0mm  
FCAW: Weld metal thickness 16.0mm

GTAW: 3.0mm to 12.0mm Ch 12. Sec. 5.6.5  
FCAW:  $\geq$  3.0mm

Pipe outside diameter

273mm

0.5 x D

Welding positions

6Gu

Buttweld and Filletweld: D, X, Vu, O; Ch 12 table 12.5.7  
LR Rules part 2 Ch.12 section 5.7.4.(b)

Other details

This certificate is valid until 10 June 2024  
prolongation method 5.7.4 (b) is applicable as  
specified on the following pages of this Welder  
Qualification.

Additional information is available on attached sheet and/or welding procedure specification No.  
Test Results (state Satisfactory or Not applicable)

Not applicable

Visual	Satisfactory	Magnetic particle	Not applicable
Liquid penetrant	Satisfactory	Radiographic	Satisfactory
Ultrasonic	Not applicable	Macro examination	Not applicable
Bend	Satisfactory	Fracture	Not applicable
Other	RT report LAB715018611, PT report 715018615 & Destructive test report 1328/2 are accessory to this Welder Performance Qualification Certificate.		

We certify that the above statements are correct and that the test pieces were prepared, welded and tested in accordance with the specified

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