

Welding Procedure Qualification Record (WPQR)
EN ISO 15614-1

Manufacturer's WPQR No: 10-WPQR-37	NIL reference number: 10-WPQR-37
Manufacturer: Hendriks Precon	Date of welding: 09-12-2010
Address: Veenendaal	Examiner: A. Woudenberg NL (IWT 0147)
WPS number: 091210-1	Weld record: 10-WR-37

	Range of qualification	
	As welded	Qualification Range
Welding Process(es):	135	135
Welding position:	PB	PB
Type of joint and weld:	FW	FW
Parent material group(s) and sub group(s):	1.2	1 -1 ¹⁾
Parent material thickness (mm):	10 mm	5 – 12 mm
Outside pipe diameter (mm):	N.A.	N.A.
Throat thickness (mm):	8 mm	Multi layer no restriction
Single run/ Multi run:	multi layer	multi layer
Filler material designation:	EN ISO 14341-A G42 4M G3Si1	EN ISO 14341-A G42 4M G3Si1
Filler material brand, type:	Sidergas, S6	No restriction
Filler material size(mm):	1,0 mm	No restriction ²⁾
Designation of Shielding gas/flux:	EN 14175 : M21	EN 14175 : M21
Composition of Shielding gas:	85% Argon - 15% CO ₂	Maximum % CO ₂ = 16,5%
Designation of Backing gas:	N.A.	N.A.
Composition of Backing gas:	N.A.	N.A.
Type of welding current and polarity:	DC-EP	DC-EP
Mode of metal transfer:	Spray	Spray
Heat input KJ/mm (In acc. with EN 1011-1) :	Minimum 0.879 KJ / mm	≥ 0,66 KJ / mm
Preheat temperature (C°) min.:	20	10
Interpass temperature (C°) max.:	190	190
Post-Heating:	N.A.	N.A.
Post-weld Heat-Treatment:	N.A.	N.A.
Other information:	¹⁾ Covers the equal or lower yield strength of the same group. ²⁾ If the requirements of heat-input are satisfied.	

Welding Procedure Qualification Record (WPQR)
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Manufacturer's WPQR No: 10-WPQR-38	NIL reference number: 10-WPQR-38
Manufacturer: Hendriks Precon	Date of welding: 09-12-2010
Address: Veenendaal	Examiner: A. Woudenberg NL (IWT 0147)
WPS number: 091210-2	Weld record: 10-WR-38

	Range of qualification	
	As welded	Qualification Range
Welding Process(es):	135	135
Welding position:	PB	PB
Type of joint and weld:	FW	FW
Parent material group(s) and sub group(s):	1.2	1 -1 ¹⁾
Parent material thickness (mm):	25 mm	12.5 – 30 mm
Outside pipe diameter (mm):	N.A.	N.A.
Throat thickness (mm):	Multi layer 10 mm	Multi layer no restriction
Single run/ Multi run:	multi layer	multi layer
Filler material designation:	EN ISO 14341-A G42 4M G3Si1	EN ISO 14341-A G42 4M G3Si1
Filler material brand, type:	Sidergas, S6	No restriction
Filler material size(mm):	1,0 mm	No restriction ²⁾
Designation of Shielding gas/flux:	EN 14175 : M21	EN 14175 : M21
Composition of Shielding gas:	85% Argon - 15% CO ₂	Maximum % CO ₂ = 16,5%
Designation of Backing gas:	N.A.	N.A.
Composition of Backing gas:	N.A.	N.A.
Type of welding current and polarity:	DC-EP	DC-EP
Mode of metal transfer:	Spray	Spray
Heat input KJ/mm (In acc. with EN 1011-1) :	Minimum 0.879 KJ / mm	≥ 0,879 KJ / mm
Preheat temperature (C°) min.:	20	10
Interpass temperature (C°) max.:	181	181
Post-Heating:	N.A.	N.A.
Post-weld Heat-Treatment:	N.A.	N.A.
Other information:	¹⁾ Covers the equal or lower yield strength of the same group. ²⁾ If the requirements of heat-input are satisfied.	