

WELDING PROCEDURE APPROVAL TEST CERTIFICATE

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3 *Manufacturer's Welding Procedure*
 4 *Reference No.* 2/89
 5 *Manufacturer:* A S L R FABRICATIONS LTD
 6 *Address:* OPAL WAY
 STONE BUSINESS PARK
 STONE
 STAFFS
 ST150SS

Inspecting Authority ZC/WP/110664
Reference No. SS42527650/3

7 *Code / Testing Standard:* BS EN ISO 15614-1 2004+A1 2008
 8 *Date of Welding:* 07/09/2011
 9 **RANGE OF QUALIFICATION**
 10 *Welding Process:* P MECH MAG(135)
 11 *Joint Type:* BUTT WELD(1) FILLET WELD(2)
 12 *Parent Metal Groups Sub Groups:* 1.1 Re<=195N/mm²
 13 *Parent Metal Thickness (mm):* 3mm-9mm
Weld Metal Thickness (mm): 3mm-9mm
Throat Thickness (mm): NO RESTRICTION(3mm-5.4mm MATERIAL THICKNESS)
Single run / Multi run: MULTI RUN
 14 *Pipe Outside Diameter (mm):* >=30.15mm
 15 *Filler Metal Type / Designation:* EN 440 G3 Si1
Filler Material Make: NO RESTRICTION
Filler Material Size: NO RESTRICTION
 16 *Designation of Gas / Flux:* ARGON+20% CO² EN ISO 14175 M21
Designation of Backing Gas: NOT APPLICABLE
 17 *Type of Welding Current / Polarity:* DC+VE
Mode of Metal Transfer: GLOBULAR/SPRAY
Heat Input: NO RESTRICTION
 18 *Welding Position(s):* ALL EXCEPT VERTICAL DOWN
 19 *Preheat Temperature:* 5°C MIN
Post-Heating: NONE
 20 *Post Weld Heat Treatment:* NONE
 21 **OTHER INFORMATION** SEE BS EN ISO 15614-1 2004+A1 2008
 1) ss,nb,mb,bs,gg,ng
 2) SEE CLAUSE 8.4.3a

22 *Certified that test welds were prepared, welded and tested satisfactorily in accordance with the requirements of the code / testing standard indicated above.*

23 *Location:* BIRMINGHAM
Date of Issue: 07/09/2011

Name and Signature
 C DUFFELL 
Inspecting Authority SAFed/CEOC Member Company
 (CEOC Member Organization)
 ZURICH ENGINEERING
 ZURICH Laboratory Services
 212 Great Bridge Street
 Walsley, Birmingham B70 0DE
 Tel: 0121 520 5868

Übersetzung des vorgedruckten
 Formblatt-Textes auf der Rückseite

Translation of printed test
 on the reverse side

*Note: This is a Welding Procedure Qualification Record and is applicable to the named manufacturer alone.
 This qualification is not a Standard Welding Procedure and may not be reproduced in whole or part and used as such.*