

WELDING PROCEDURE APPROVAL TEST CERTIFICATE

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 3 **Manufacturer's Welding Procedure**
 4 **Reference No.** ASLR/AUTO/001
 5 **Manufacturer:** A S L R FABRICATIONS LTD
 6 **Address:** OPAL WAY
 STONE BUSINESS PARK
 STONE
 STAFFS
 ST150SS

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Inspecting Authority ZC/WP/110662
Reference No. SS42527650/1

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:** FULLY MECH MAG(135)
 11 **Joint Type:** PARTIAL PENETRATION BRANCH WELD, FILLET WELD
 12 **Parent Metal Groups / Sub Groups:** 1.1 Re<=195N/mm²
 13 **Parent Metal Thickness (mm):** 3mm-5.2mm WELDED TO 3mm-5.85mm
Weld Metal Thickness (mm): 1.4mm-2.6mm
Throat Thickness (mm): NO RESTRICTION(3mm-4.8mm TO 3mm-5.4mm MATL THKNS)
Single run / Multi run: SINGLE RUN
 14 **Pipe Outside Diameter (mm):** >=30.15mm
 15 **Filler Metal Type / Designation:** EN ISO 14343-A G3 Si1
Filler Material Make: NO RESTRICTION
Filler Material Size: NO RESTRICTION
 16 **Designation of Gas / Flux:** ARGON+7%CO²+2.5%O² EN ISO 14175 M24
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

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: 15/09/2011

ZURICH
 Name and Signature
 C DUFFELL
SAFed/CEOC Member Company
Inspecting Authority Zurich Laboratory Services
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 Traduction des rubriques Imprimées au verso

Übersetzung des vorgedruckten Formblatt-Textes auf der Rückseite
 Translation of printed test on the reverse side