

WELDING PROCEDURE APPROVAL TEST CERTIFICATE

Page 1 of 3

- 1
 2
 3 **Manufacturer's Welding Procedure**
 4 **Reference No.** ASLR 1/89
 5 **Manufacturer:** A S L R FABRICATIONS LTD
 6 **Address:** OPAL WAY
 STONE BUSINESS PARK
 STONE
 STAFFS
 ST150SS
 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)
Joint Type: SET ON BRANCH WELD(1) FILLET WELD(2)
 12 **Parent Metal Groups .Sub Groups:** 1.1 Re<=195N/mm²
 13 **Parent Metal Thickness (mm):** 3mm-6mm WELDED TO 3mm-9mm
Weld Metal Thickness (mm): 3mm-6mm
Throat Thickness (mm): NO RESTRICTION(3mm-4.8mm TO 3mm-5.4mm MATL THKNS)
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
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
 MINIMUM BRANCH ANGLE 90°

Inspecting Authority ZC/WP/110663
Reference No. SS42527650/2

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
 (CEOC Member Organization) Bridge Street
 ZURICH ENGINEERING, Bromwich B70 0DE
 Tel: 0121 520 5868
 Traduction des rubriques Imprimées
 au verso

Übersetzung des vorgedruckten
 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.