



Welding Procedure Qualification Record (WPQR)
According to EN ISO 15614-1:2004 Code Specification

Manufacturer: "EXPRESS" Β. Παπαλουκάς - Ελ. Θεοχάρης

Address: Megalou Alexandrou 325, Ano Liosia

Date of Welding: 07/10/2015

RANGE OF APPROVAL

Welding Process: 135

Type of Joint and Weld: Fillet Weld (FW)

Parent Metal Group and Sub Group: CEN ISO/TR 15608: Subgroup 1.1

Parent Metal Thickness (mm): 8.0mm

Weld Metal Thickness (mm): N/A

Throat Thickness (mm): From 3 to 6mm

Single run/Multi run: Single run

Pipe Outside Diameter (mm): $D \geq 500$ mm (150mm in the PA position)

Filler Metal Type / Designation / Size: Same mechanical properties and same nominal composition

Designation of Shielding Gas / Flux: EN ISO 14175 M21

Type of Welding Current and Polarity: DC+

Mode of Metal Transfer: Short Circuit

Heat Input: N/A

Welding Positions: No restriction

Preheat Temperature: Ambient (≥ 10 °C)

Interpass Temperature: N/A

Post Weld Heat Treatment: N/A

OTHER INFORMATION (according to para. 8.5):

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

**Location:
Aspropyrgos**

**Date of Issue:
15.10.2015**



Note: Welding Procedure Approval according to EN ISO 15614-1:2004 has been carried out and is applicable to the named manufacturer alone. This approval is not a Standard Welding Procedure to EN ISO 15612 and may not be reproduced in whole or part and used as such.

