

WELDER'S QUALIFICATION TEST CERTIFICATE IN ACCORDANCE WITH EN ISO 9606-1:2017
CERTIFICAT DE CALIFICARE A SUDORULUI IN CONFORMITATE CU EN ISO 9606-1:2017

DESIGNATION(S): **EN ISO 9606-1 135 P BW FM1 S s12 PA ss nb**
NOTARE(I): **EN ISO 9606-1 135 P FW FM1 S t12 PB sl (supplementary fillet weld test / proba suplimentara de colt)**



WPS Reference No.: **WMN-01a; WMN-01a FW**
Nr. WPS de referinta:

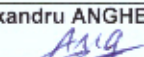

Welder's name / Nume sudor: **MARC Nicolae**
Identification / Identificare: **AX 570122 / WMN 03**
Method of identification / Metoda de identificare: **ID card & welder stamp / Carte identitate si poanson sudor**
Date and place of birth / Data si locul nasterii: **30.08.1967 – Alba-Iulia, jud. Alba, Romania**
Employer / Angajator: **S.C. WAGONS MAINTENANCE S.R.L. – Alba-Iulia, Romania**
Code/testing standard / Cod / Standard de Testare: **EN ISO 9606-1: 2017**
Job knowledge / Cunostinte profesionale: **Acceptable / Acceptabil Not tested / Neverificat**
Test piece welding date / Data sudarii probei: **28.02.2019**

Welding Variables / Variabile de sudare	Test Piece Details / Detalii Proba Test	Range of qualification / Domeniul de calificare
Welding process(es) / Procedeul(ele) de sudare (4.2, 5.2):	135	135, 138(M)
Transfer mode / Mod de transfer (5.2):	Short-circuit / Scurtcircuit	All / Toate
Product type (plate or pipe) / Tip produs (tabla sau teava) (5.3):	P	P; T
Type of weld / Tipul imbinarii (5.4):	BW & FW (see / vezi 5.4.e)	BW; FW
Weld details / Detalii privind sudarea probei (5.9):	BW : ss nb	ss nb; ss mb; bs; ss gb; ss fb
Multi-layer/single-layer / Multistrat / un singur strat (5.9):	BW : ml; FW : sl	sl; ml
Parent material group(s)/subgroups / Grupa(ele)/subgrupa(ele) materialului de baza (5.5.1 & 10):	1.2	---
Filler material group(s) / Grupa(ele) materialului de adaos (5.5):	FM1	FM1; FM2
Filler material designation (type) / Notare material de adaos (tip) (5.6):	EN ISO 14341-A: G 42 4 M21 3Si1 (S)	S, M
Shielding gas / Gaz de protectie (10):	EN ISO 14175: M21-ArC-18	---
Auxiliaries / Materiale auxiliare :	---	---
Type of current and polarity / Tip curent si polaritate (10):	CC+	---
Material thickness / Grosime material de baza (mm) (5.7):	12	---
Deposited thickness / Grosime metal depus (mm) (5.7):	12	≥ 3
Outside pipe diameter / Diametrul exterior teava (mm) (5.3, 5.7):	Fixed pipe / Teava fixa: --- Rotating pipe / Teava rotita: ---	≥ 500 ≥ 75
Welding position / Pozitia de sudare (5.8):	BW (pipe): --- FW (pipe): --- BW (plate): PA FW (plate): PB (see / vezi 5.4.e)	PA PA; PB PA PA; PB
Branch:	---	---

Supplementary fillet weld test completed in conjunction with a butt weld test as per 5.4. e) / Proba de colt suplimentara executata impreuna cu o proba cap la cap in conformitate cu 5.4.e): **Acceptable / Acceptabil**
Not acceptable / Neacceptabil

Type of test / Tipul testelor (6.4)	Performed and accepted (Report no.) / Efectuate si acceptate (Raport nr.)	Not required / Nu este cerut
Visual testing / Examinare vizuala	X (296, 298 / 28.02.2019)	
Radiographic testing / Examinare radiografica		X
Ultrasonic testing / Examinare ultrasonica	X (4322 / 28.02.2019)	
Bend test / Incercarea la indoire		X
Fracture test / Incercarea la rupere	X (4069 / 01.03.2019)	
Macroscopic examination / Examinarea macroscopica		X
Other tests / Alte teste*		X

*Append separate sheet if required / A se anexa o pagina separata daca este cazul: **N/A**

Date of issue / Data emiterii	Place of issue / Locul emiterii	Examiner name & signature / Nume si semnatura examinator	Approved by / Aprobat de	Revalidation method / Metoda de revalidare	Valid until / Valabil pana la (1)
04.03.2019	Bucuresti Romania	Alexandru ANGHELUTA 	Eduard PESCARU Business Manager 	9.3 a)	27.02.2022

FPCS-01.01