



TDS Brno - SMS, s.r.o.

Mariánské nám. 1, 617 00 Brno, Morava, Česká republika (CZ)

I Člen AIO, TDS, CWS ANB (člen EWF, IIW a IAB) I

I Member of AIO, TDS, CWS ANB (member of EWF, IIW and IAB) I

Technická, školicí, zkušební, certifikační a inspekční činnost

Technical, training, testing, certification and inspection activity

Inspecting Authority No. 4040 Accredited by ČIA o.p.s.

301-F02

1. Welding procedure Qualification Record (WPQR) – Test certificate		2. Reference No : 1362 – 2010	3. Leaf : 1 4. Total : 4 5. Check No. 0
6. Firm : Svatavské strojírny s.r.o.		7. Address : Pohraniční stráž 365 35703 Svatava	
8. Inspectin procedure: TOS - 301		9. Date of Welding : 6. 5. 2010	
10. Rules / Testing Standards : ČSN EN ISO 15614-1		Specification and qualification of welding procedures for metallic materials. Welding procedure test – Part 1 : Arc and gas welding of steels and arc welding of nickel and nickel alloys.	
11. Range of – test		– approval	
12. Welding process :	135 (MAG)	135 (MAG) - according to ČSN EN ISO 4063	
13. Stage of mechanization (machinery)	hand	hand - acc. to ČSN EN ISO 15614-1 article 8.4.1	
14. Joint type and weld variety	BW - ČSN EN ISO 9692-1	BW + FW - acc. ČSN EN ISO 15614-1 art. 8.4.3	
15. Dimension of fillet weld [mm]	$a = \text{—}$	$a = \text{unlimited}$ - ČSN EN ISO 15614-1 table 6	
16. Welding position	PA, PF - ČSN EN ISO 6947	all - according to ČSN EN ISO 15614-1 art. 8.4.2	
17. Parent metal mark	S890QL, Group 3.2	ČSN EN ISO 15614-1; CEN ISO/TR 15608	
18. Parent metal thickness [mm]	$t = 10$	$t = 3$ to 20 - acc. to ČSN EN ISO 15614-1 table 6	
19. Pipe outside diameter [mm]	$D = \text{—}$	$D = 500$ and above - ČSN EN ISO 15614-1 art. 8.3.2	
20. Filler metal type	EN ISO 16834: G 8 9 4 M	acc. to ČSN EN ISO 15614-1 art. 8.4.4; art. 8.4.6	
21. Shielding gas / Flux	EN ISO 14175: M21	CO ₂ + max 10% - ČSN EN ISO 15614-1 art. 8.5.2	
22. Type of Welding current / Polarity	DC(+) / indirect	DC(+)/indirect - ČSN EN ISO 15614-1 art. 8.4.7	
23. Angle branch pipe [°]	$\alpha_{\text{odb}} = \text{—}$	$\alpha_{\text{odb}} = \text{—}$ - ČSN EN ISO 15614-1 art. 8.4.3	
24. Heat input [kJ/mm]	$Q = 0,76$	$Q = 0,5$ až 1,5	
25. Metal transfer	dip-transfer	dip-transfer - ČSN EN ISO 15614-1 art. 8.5.2	
26. Preheat temperature [°C]	$T_p = 50$		
27. Interpass temperature [°C]	$T_i = 150$		
28. Post weld heat treatment	After welding - free cooling on air according to product standard or ČSN 050211		
29. Other informations :	Qualification of welder according to ČSN EN 287 - 1		
30. <i>Certified that test welds were prepared, welded and tested in accordance with the requirements of the code, respective testing standards, with satisfactory result.</i>			
31. Location of issue :	Brno	32. Technical Inspecting Authority :	
33. Date of issue :	3. 6. 2010	TDS Brno - SMS, s.r.o.	
		 Ing. Dr. Vladimír Kudělka 34. Name, date and signature	

„Deutsch“ siehe Rückseite.
„Čeština“ viz druhá strana.

