

# Welder Approval Test Certificate

## Cert - Nr. : 897/14



DESIGNATION	: EN ISO 9606-1:2013 141 T BW FM1 S s3,91 D60,30 H-L045 ss nb		
Welding Procedure Specification Ref. No. :	895/14	Inspecting Authority	TÜV HELLAS (TUVNORD) S.A.
		Order Nr. :	02.01.537
Welder's Name	: DAGARIS ELEFThERIOS		
Identification	: L1		
Method of Identification	: IDENTITY CARD / X566629		
Date and place of birth (if required)	: -		
Employer	: ARTINOX A. RODOPOULOS – TH. RODOPOULOS O.E		
Code / Testing Standard	: EN ISO 9606-1:2013		
Date of welding	: 07/04/14		



Job Knowledge : Acceptable / not tested (delete as necessary)

	Weld test details	Range of qualification
Welding process(es)	141	141
Transfer Mode	-	-
Plate or pipe	T (PIPE)	T (PIPE) P (PLATE)
Joint type	TBW	ALL BUTT WELDS IN PLATES AND PIPES (NOT FILLET WELDS) INCLUDING BRANCH WELDS WITH AN ANGLE >=60 DEG.
Parent metal group(s)	SEAMLESS STEEL PIPE A333 GR. 6 / GROUP 11.1	1.1, 1.2, 1.3, 1.4, 11
Filler material group(s)	FM1	FM1, FM2
Filler material type/size/designation	EN ISO 636-AW4Si1 ESAB OK TIGROD 12.64	S,M
Shielding Gas (flow rate) / flux-	ARGON 99,996 % / I1 - EN ISO 14175	SIMILLAR TYPE of INERT GAS EN ISO 14175
Material thickness [mm]	3,91 mm.	3 mm. TO 7,82 MM.
Deposited Thickness [mm]	3,91 mm.	3 mm. TO 7,82 MM.
Outside pipe diameter [mm]	60,30 mm.	30,15 mm. AND ABOVE
Welding positions	H-L045	ALL POSITIONS EXCEPT VERTICAL DOWN FOR PLATES AND PIPES
Auxiliaries	-	-
Weld details	ss nb	ss nb - ss mb - bs - ss gb - ss fb
Multi-layer / Single layer		

Supplementary fillet weld test (completed in conjunction with butt weld qualification): Acceptable / Not Acceptable / Not Applicable

Type of test	Performed with acceptable results / Report No.:		Not Tested
Visual	√	ACCEPTED	-
Radiography	√	ACCEPTED RT/A/14/061	-
Fracture test		-	X
Bend test	√	ACCEPTED – BT/A/14/114	-
Notch Tensile test	√	ACCEPTED – TT/A/14/113	-
Macro	√	ACCEPTED – MC/A/14/115	-
Magnetic particle testing	√	ACCEPTED – MT/A/14/019	-

Name and Signature : K. ANGELAKOS  
 Inspection Authority : TÜV HELLAS (TUVNORD)  
 Date of issue : 30/04/14  
 Location : ATHENS



N/A: NOT APPLICABLE

Revalidation 9.3 a)	√	Valid until 06/04/17 via a new welding test according to ISO 9606-1	Revalidation 9.3 b)	Valid until	Revalidation 9.3 c)	Valid until
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PROLONGATION FOR APPROVAL BY INSPECTING AUTHORITY			PROLONGATION FOR APPROVAL BY EMPLOYER/SUPERVISOR [every 6 months]		
Date	Signature	Position or Title	Date	Signature	Position or Title