

Welder Approval Test Certificate

Cert - Nr. : 898/14



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 :	TIROVOLAS JOHN		
Identification :	G2		
Method of Identification :	IDENTITY CARD / AI136122		
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/14/060	-
Fracture test	√ -	X
Bend test	√ -	X
Notch Tensile test	√ -	X
Macro	√ -	X

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

Date	Signature	Position or Title

PROLONGATION FOR APPROVAL BY EMPLOYER/SUPERVISOR [every 6 months]

Date	Signature	Position or Title