

## WPQR, WPAR records and other welding procedure qualifications

Symbol form.: WE12-WPQR

Issue: 6

Data: 28/06/2016

### Aluminum

Pos.	Process	Examining unit and number	Technical conditions/ Standards	Type of joint	Base material	Group as per EN 15608	Thickness range	Type of material; plate/pipe	Welding position	WPS number
1	<b>131 MIG</b>	DNV AL/131/F01/FWS	DNV-OS-C401	<b>FW (fillet)</b> sl (single-pass)	6082	22-23	<b>1,5-4</b>	Plate	PA;PB;PF	MIG/AL/FW 01
2		DNV AL/131/F02/FWM	PN-EN ISO 15614-2; DNV-OS-C401; Norsok M 102	<b>FW (fillet)</b> ml (multi-pass)	6082	22-23	<b>3+20</b>	Plate	PA;PB;PF	MIG/AL/FW 02
3		TUV-Nord	PN-EN ISO 15614-2	<b>BW (butt)</b> ml (multi-pass)	6082	22-23	<b>3+20</b>	Plate	PA	W04_M23_PBW
4		TUV-Nord	PN-EN ISO 15614-2	<b>BW (butt)</b> ml (multi-pass)	6082	22-23	<b>3+20</b>	Plate	PF	W05_M23_PBW
5		TUV-Nord	PN-EN ISO 15614-2	<b>BW (butt)</b> <b>FW (fillet)</b> ml (multi-pass)	6082	22-23	<b>&gt;= 20</b>	Plate	PC	pW12M22PBW
6	<b>141 TIG</b>	TUV-Nord	PN-EN ISO 15614-2	<b>BW (butt)</b> ml (multi-pass)	6082	22-23	<b>3+10</b>	Plate /Pipe	PA, PB, PC,PF	W01_T23_TBW
7		TUV-Nord	PN-EN ISO 15614-2	<b>FW (fillet)</b> sl (single-pass)	6082	22-23	<b>3+10</b>	Plate	PB	W03_T23_PFW

### Production Welding Test

1	<b>141 TIG</b> - with automatic wire feeding	UDT; H29/2010 - PWT	Welding by overlaying - pre-production welding test; PN-EN ISO 15613:2000	<b>surfacing by welding</b> t=29 layer inside the pipe	Cev<=045	11.1	<b>20; Ø219</b>	P; D>=500		H29/2010
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