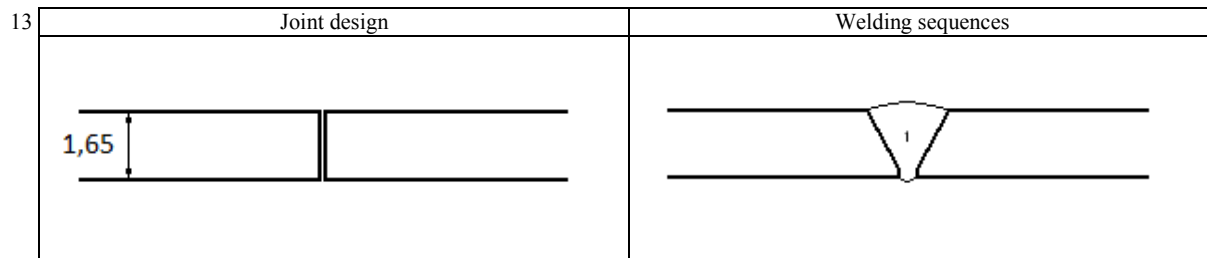




RECORD OF WELD TEST

3 Manufacturer's pWPS No: - Examining body: Vincotte nv
 4 Manufacturer's WPQR No: WPQR ISO_SS-Orb-2 Reference No.: AUD/34/60708504/00/EN/004
 5 Manufacturer: ELMECH Date of welding: 05/10/2018
 6 Location: ELMECH te Opglabeek
 7 Welder's name: Jeroen Engels & Paul Pinxten Method of preparation and cleaning: Grinding & brushing
 8 Parent material specification: 316L
 9
 10 Mode of metal transfer: - Material thickness (mm): 1,65
 11 Joint type and weld: buttweld Outside pipe diameter (mm): 38,1
 12 WELD PREPARATION DETAILS (sketch)* Welding position: KL000



14 WELDING DETAILS see program 38.1 Pg 01 Number 209

15	Run	Welding Process	Size of Filler Material	Current A	Voltage V	Type of current/ Polarity	Wire Feed / Travel Speed* mm/min	Heat input* KJ/mm	Metal transfer
	1								

16 Filler material designation and make: /

18 Any special baking or drying: According operating manual filler metal Other information*:
 19 Gas / Flux: shielding: II : Weaving (maximum width of run): see program
 backing: II Oscillation: amplitude, frequency, dwell time: see program
 20 Gas flow rate: shielding: 11-13 l/min
 21 backing: 4-8 l/min
 22 Tungsten electrode : ISO 6848 WL15 Pulse welding details: see program
 23 Details of back gouging/backing: grinding Distance contact tube/workpiece: see program
 24 Preheating temperature: roomtemperature Plasma welding details: -
 25 Interpass temperature: / Torch angle: -
 Post-heating: na

26 POST WELD HEAT TREATMENT: ~~with~~ / without

27 Time, temperature, method: -

28 Heating and cooling rates*: -

29 The above test piece was welded in the presence of: Vincote nv

Name and signature
Vincotte nv

Examining body
(CEOC Member Organisation)

30

31

*) If required

Inspecteur
 0473/19 34 10

3 4 0 0 4 0 0

1 **TEST RESULTS**

2 Manufacturer's WPQR No.: WPQR ISO_SS-Orb-2 Page 3 of 3

3
4
5 Visual examination: acceptable
6 Penetrant*/Magnetic Particle test*: acceptable

Examining body: Vinçotte nv
Reference No.: AUD/34/60708504/00/EN/005
Radiography*: acceptable
Ultrasonic examination*: na

7 TENSILE TESTS Temperature: RT

Type / N°	Re N/ mm2	Rm N/mm2	Elongation %	Reduction of area %	Fracture location	Remarks
Requirement		485 min				
53002-1		599			Heat affected zone	Ductile
53002-2		599			Heat affected zone	Ductile

10 BEND TESTS Former diameter: 4xt mm

Type/N°	Bend angle	Elongation*	Result
53002-3	180°	/	acceptable
53002-4	180°	/	acceptable
53002-5	180°	/	acceptable
53002-6	180°	/	acceptable

Fillet Fracture Test*: na
Macro/Micro examination*: 53002-7 : acceptable

13 IMPACT TESTS* / Requirement: /

Notch location / Direction	Temp °C	Values (J) / Lateral expansion (mm)			Average	Remarks
		1	2	3		

15 HARDNESS TESTS*: PE Location Location of Measurements (Sketch)*

20 OTHER TESTS:

21 REMARKS:

22 Test carried out in accordance with the requirements of: EN ISO 15614-1:2017 level 2
23 Laboratory report reference No.: AIB5729112925530-02 (Element)
24 Test results were acceptable / ~~not acceptable~~
25 Test carried out in the presence of Vinçotte nv

Name and signature
Vinçotte nv

Examining body
(CEOC Member Organisation)

26
27
*) If required


 Eric JANS
 Inspecteur
 0473/19 34 10