



# Welding Procedure Qualification Record

## (PQR) ASME IX

### Chemicals & Power

Company Name **RVS Industrië Mosman BV**  
 Procedure Qualification Record No. **260608/1** Date **03 March 2009**  
 WPS No. **260608/1**  
 Welding Process(es) **GTAW**  
 Types (Manual, Automatic, Semi-Auto. ) **Manual**

**Joints (QW-402)**



Groove Design for Test Coupon  
 (For combination qualifications, the deposited weld metal thickness shall be recorded for each filler metal or process used.)

Base Metals (QW-403)  
 Material Spec. **TP304L**  
 Type or Grade **A-312**  
 P.No. **8** to P-No. **8**  
 Thickness of Test Coupon **3,65**  
 Diameter of Test Coupon **60,3**  
 Other

Postweld Heat Treatment (QW-407)  
 Temperature -  
 Time -  
 Other

Gas (QW-408)

	Percent Composition		Flow Rate
	Gas(es)	(Mixture)	
Shielding	<b>Argon I1</b>	<b>99,995</b>	<b>12</b>
Trailing			
Backing	<b>Formeer</b>	<b>5/10</b>	<b>8</b>

Filler Metals (QW-404)  
 SFA Specification **5.95 304L**  
 AWS Classification **ER308L**  
 Filler Metal F-No. **6**  
 Weld Metal Analysis A-No. **1**  
 Size of Filler Metal **2,0 mm**  
 Other **metal transfer: manual**

Electrical Characteristics (QW-409)  
 Current **DC**  
 Polarity -  
 Amps. **60** Volts **14**  
 Tungsten Electrode Size **2,4**  
 Other

Weld Metal Thickness **4,0**  
 Position (QW-405)  
 Position of Groove **6G**  
 Weld Progression (Uphill, Downhill) **uphill**  
 Other

Technique (QW-410)  
 Travel Speed **3**  
 String or Weave Bead **string**  
 Oscillation  
 Multipass or Single Pass (per side) **multipass**  
 Single or Multiple Electrodes **single**  
 Other

Preheat (QW-406)  
 Preheat Temp. **10°C**  
 Interpass Temp **150°C**  
 Other

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				Tensile Test (QW-150)		PQR No.	260608/1
Specimen No.	Width mm	Thickness mm	Area mm <sup>2</sup>	Ultimate Total Load kN	Ultimate Unit Stress MPa	Type of Failure & Location	
1	19,0	3,0			598	weld	
2	19,0	3,0			644	weld	
						req. >485	

**Guided- Bend Tests (QW-160)**

Type and Figure No.	Results
root bend 4xt 180	Acceptable
root bend 4xt 180	Acceptable
face bend 4xt 180	Acceptable
face bend 4xt 180	Acceptable

**Toughness Tests (QW-170)**

Specimen No.	Notch Location	Specimen Size mm	Test Temp. °C	Impact Value J	% Shear	Mils	Drop Weight Break (Y/N)

**Comments:**

**Fillet-Weld Test (QW-180)**

Result- Satisfactory:      Yes       No       Penetration into Parent Metal:      Yes       No

Macro - Results

**Other Tests**

Type of Test      **Visual, radiographic, acceptable**

Deposit Analysis

Other

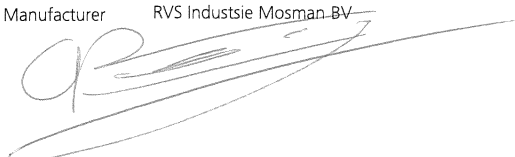
Welder's Name      **M.M.J. Tijans**      Clock No.      -      Stamp No.      **104065175**

Test Conducted By:      **Stork FDO/Lloyds Register**      Laboratory Test No:      **MOO09-04147ASME**

We certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME Code.

Date Issued:      **16 July 2012**

Manufacturer's Representative  
 Manufacturer      **RVS Industrie Mosman BV**



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W.G. Kuster

W.G. Kuster       Witnessed     Reviewed     Examined

Surveyor to Lloyd's Register Nederland B.V.



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