

WELDING PROCEDURE QUALIFICATION RECORD FORM (WPQR)

EN ISO 15614-1:2017

**WELDING PROCEDURE QUALIFICATION TEST CERTIFICATE**

WPS No:	01/25	Examining body:	EUROCERT S.A.
Manufacturer:	ALTANIS BROTHERS O.E.	Reference No:	10.24.0552.01
Address:	ATHENS GREECE	Code / Testing Standard:	EN ISO 15614-1:2017
Level:	2	Date of Welding:	02/06/2025

Range of qualification

Product Form:	PLATE
Welding Process(es):	135
Type of joint:& weld	FW
Parent Metal(s) group:	Group 1.1
Parent Metal Thickness (mm):	2.0 to 4.0 mm
Deposited Metal Thickness (mm):	-
Throat Thickness (mm)	No Restriction
Single run/Multi run	Multi run
Outside Pipe Diameter (mm):	-
Filler Metal Designation:	FM1
Filler Material Make	EN ISO 14341-A: G3Si1, AWS A5.18 ER70S -6
Filler Material Size (mm)	-
Designation of Shielding Gas / Flux:	Ar 98% , CO2 2%
Designation of Backing Gas	-
Type of Welding Current: & Polarity	DC (+)
Transfer Mode:	Short arc
Heat Input	0.69-1.06 kJ/mm
Welding Positions:	PA,PB
Preheat Temperature	-
Interpass Temperature	250oC
Post-Heating	-
Post – Weld Heat Treatment	-
Other Information:	ml

We confirm that the statements in this record are correct and that the test pieces were prepared, welded, tested and have fulfilled the requirements in accordance with ISO 15614-1

Location	Date of Issue	Test Body / Surveyor
METAMORFOSI GREECE	04/06/2025	EUROCERT S.A. P. TERZIS

EUROCERT S.A. 89 Chlois & Lykovriseos str., 144 52, Metamorphosi – Greece
T +30 210 62.52.495, +30 210 62.53.927, F +30 210 62.03.018, M eurocert@otenet.gr



RECORD OF WELD TEST
EN ISO 15614-1:2017

Location: METAMORFOSI, GREECE	Examiner or test body: EUROCERT S.A.
WPS No: 01/25	Method of Preparation and cleaning: GRINDING & BRUSHING
WPQR No: 10.24.0552.01	Parent Material Specification: S235JR
Manufacturer: ALTANIS BROTHERS O.E.	Material Thickness (mm): 2mm
Welders/Operator's Name: THEOCHARAKIS GEORGIOS	Outside Pipe diameter (mm): -
Joint Type: FILLET WELD PLATE	Welding Position: PB

Weld Preparation details (sketch):

Joint Design	Welding Sequences

Welding Details

Run	Processes	Size of Filler Metal	Current A	Voltage V	Type of current / Polarity	Wire Feed Speed mm/min	Travel Speed mm/min	Heat Input kJ/mm	Metal Transfer
1-3	135	1	210-230	25-27	DC (+)	310-325	-	0.81-0.92	Short arc

Filler Metal Classification: EN ISO 14343-A : G 19 9 L Si , AWS A5.9 ER308ML Si, WURTH SG308 L Si

Any Special Baking or Drying: -	
Gas / Flux: -- Shielding: - Ar 98% , CO2 2% Backing: ---	Heating and Cooling Rates: -
Gas Flow Rate -- Shielding: 12 L/min Backing: -	Other Information (If Required): Weaving (Maximum Width of Run):
Tungsten electrode Type / Size: -	Oscillation: Stringer Bead
Details of Back Gouging / Backing: -	Pulse welding details: -
Preheat Temperature: -	Stand off Distance:-
Interpass Temperature: 250°C	Plasma welding details:
Post heating: -	Torch angle: lead
Post Weld Heat Treatment and/or Ageing:-	Nozzle Diameter :-
Time, Temperature, Method:-	Other Information: ml

Manufacturer /Date	Test Body / Surveyor/Date
ALTANIS BROTHERS O.E. 04/06/2025	EUROCERT SA / P. TERZIS 04/06/2025



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TEST RESULTS

Reference No. 10.24.0552.01

Visual Examination: **ACCEPTABLE**

Radiography* -

Penetrant/Magnetic
Particle Test* **ACCEPTABLE – 250531-07**Charpy Test
Report* -

Tensile Test :-

Type/No.	Tensile Strength (Rm) N/mm ²	Yield Strength (Re) N/mm ²	Elongation n (A % on)	Reduction Of Area (Z%)	Fracture Location	Test Temperature (°C)	Remarks
-	-	-	-	-	-	-	-
-	-	-	-	-	-	-	-

Bend Tests :-

Type/No.	Bend Angle	Elongation*	Results
-	-	-	-
-	-	-	-
-	-	-	-
-	-	-	-

Macro Examination: **ACCEPTABLE – 250603-25**

Micro Examination*: -

Impact Tests*: -

Notch Location / Direction	Temp. °C	Values 1 2 3			Average	Remarks
-	-	-	-	-	-	-
-	-	-	-	-	-	-

Hardness Tests :			Location of Measurements (see report)		
Tests carried out in accordance with the requirements of:			EN ISO 15614-1:2017, EN 9015-1		
Laboratory Report Reference No.			T.C.L. Co. - Test & Control Laboratories		
Test results were acceptable/not acceptable					
Test carried out in the presence of			P. TERZIS	04/06/2025	By T.C.L. Co. - Test & Control Laboratories