



Welding Procedure Qualification Record (PQR)

Qualification: Codes/Standards

Rules for Manufacture, Testing and certification of Materials; Lloyd's Register, July 2021

Date of issue

14 February 2022

Office

Rijeka

Test place/location shop/site

Manufacturer's shop on address below

p WPS* number and revision

1/22 Revision 02

Date of welding

26 January 2022

Manufacturer's name

PRO NASA d.o.o.

Manufacturer's address

**Industrijska cesta 1,
1290 Grosuplje,
Slovenia.**

Base Material, Consumable and Welding Details:

Base materials

Grade AH 36 to Grade AH 36 see Note 1)

Welding position

Flat D (PA)

Welding process

See Note 2)

Plate/Pipe Thickness (mm):

12/--

Pipe outside diameter (mm):

N/A

Joint type

BW single sides without backing

Shielding gas/flux flow rate

M21 (EN14175:08)/12-16 (all runs) l/min.

Gas composition

18% CO₂, 82% Ar

Filler material

Solid Wire

Make/type/diameter

ESAB AB/OK Aristorod 12.50 /1,2mm

Composition

See Note 3)

Flux type

N/A

Preheat and interpass temperature (method) and control

None. BM at 12,0 °C, Max. interpass 268 °C, measured by IR thermometer

Postweld heat treatment temperature (method) and control

None

Other information

Note 1) Base material certified to be in accordance with LR Rules for Manufacture, Testing and certification of Materials; Issue 2016
Note 2) Semi-automatic-Solid Wire/Gas shielded welding process (135-D short circuit for root only and 135 - S spray transfer mode acc. EN4063:10) applied. Note 3) EN ISO 14341-A (2011): weld metal:G 38 3C1 3Si1; wire electrode; G 3Si1 is LR approved consumable: DXVuo BF 3YS H15

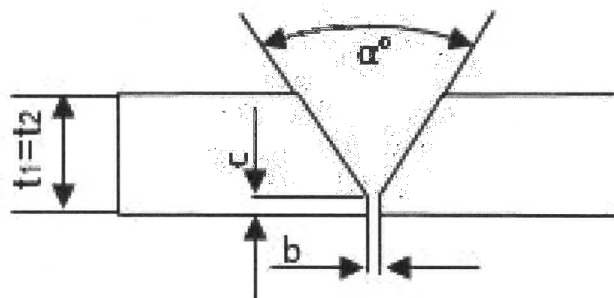
Test joint details (sketch with dimensions) of weld preparation

$$t_1=t_2= 12\text{mm}$$

$$c=1-2 \text{ mm}$$

$$b=2-3 \text{ mm}$$

$$\alpha \geq 50^\circ$$



* *Manufacturer's Preliminary Welding Procedure Specification : 1/22 Revision 02*

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