



# Welding Procedure Qualification Record (PQR)

Qualification: Codes/Standards

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

Date of issue

**28 December 2021**

Office

**Rijeka**

Test place/location shop/site

**Manufacturer's shop on address below**

p WPS\* number and revision

**2/21 Revision 4**

Date of welding

**10 December 2021**

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

**Vertical up -Vu (PF)**

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)/14 (root, fill and cap)/min.**

Gas composition

**18% CO<sub>2</sub>, 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 11,8 °C, Max. interpass 255 °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 acc. EN4063:10), Short circuit transfer mode 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**

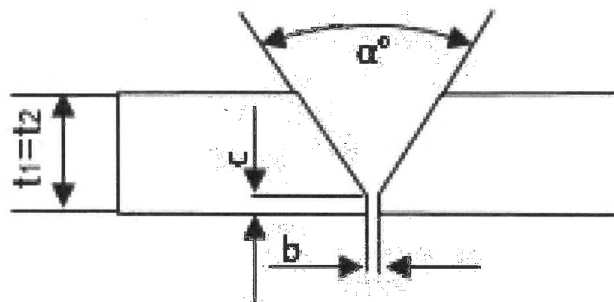
Test joint details (sketch with dimensions) of weld preparation

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

$$c=0 \text{ mm}$$

$$b=3-4 \text{ mm}$$

$$\alpha=60^\circ$$



\*Manufacturer's Preliminary Welding Procedure Specification : 2/21 Revision 4

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