



9430

WELDER QUALIFICATION TEST CERTIFICATE (WQTC)

DESIGNATION ISO 9606-1, Manual 142, T, BW, 8.1, nm, DC-VE, t1.65, s1.65, D50.8, PC, ssgb, ml

Page 1 of 1

Manufacturer's Welding Procedure No.

Certificate No. ISO/WQ009159 Rev 0

Welder's Name:

Project No. IC-3189

Identification:

Method of Identification:

Date and Place of Birth:

Employer:

STAINLESS FITTINGS LTD

Code / Testing Standard:

BS EN ISO 9606-1:2017


Job Knowledge:

Not Tested

Weld Test Details		Range of Qualification
Welding Process(es)	Manual TIG (142)	Manual 142
Transfer mode	N/A	-
Plate or Pipe	Pipe (P)	P, T
Type of Joint / Weld	Butt Joint / Butt Weld (BW)	BW
Material Group / Sub-Group	8.1	8 only
Filler Material group(s)	N/A	-
Welding Consumable(s)	N/A Autogenous	-
Shielding Gas / Flux	EN ISO 145175-11-Ar	With Shield
Auxiliaries	N/A	-
Type of current and polarity	DC-VE	-
Material Thickness (mm)	1.65mm	-
Weld Metal Thickness (mm)	1.65mm	1.65mm - 3.3mm
Pipe Outside Diameter (mm)	50.8mm	=>25.4mm
Welding Position	Horizontal (PC)	PA, PC
Weld Details (Backing / Gouging)	Single sided gas backed	-
Single layer / Multi layer	ssgb	ssgb, ssmb, bs
	Multi Layer (ml)	-

Supplementary fillet weld test (completed in conjunction with a butt weld qualification): N/A

Additional information is available on attached sheet / or welding procedure Specification No:

Type of Test	Performed and		Name and Signature
	Acceptable	Not Required	
Visual	ACCEPTABLE	-	 Examining Body WQ Inspection and Certification Ltd Date of Issue: Location: Qualification Valid Until:
Radiography	ACCEPTABLE	-	
Magnetic Particle	-	NOT REQUIRED	
Penetrant	-	NOT REQUIRED	
Macro	-	NOT REQUIRED	
Fracture	-	NOT REQUIRED	
Bend	-	NOT REQUIRED	
Additional Tests *	-	NOT REQUIRED	

Revalidation 9.3 a) Valid until: 16/02/2026 Revalidation 9.3 b) Valid until: N/A Revalidation 9.3 c) Valid until: N/A

Revalidation of qualification by Examining Body [refer to 9.3 b), c)]

Confirmation of the validity by employer/welding coordinator/examiner for the following 6 months [refer to 9.2]

Date	Signature	Position or Title	Date	Signature	Position or Title

Test result: RT003572



Appointed
Notified
Body under
the PED
N^o 0037

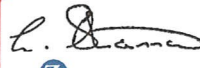


Qualification Test Certificate for Welding Operators or Weld Setters

1
2 Manufacturer's Welding Procedure: Inspecting Authority: ZE/WQOP/LS/000037 Page 1 of 1
3 Reference No. Reference No. LS20-0286
4 Name of Welding Operator / Setter:
5 Identification:
6 Method of Identification:
7 Date and Place of Birth:
8 Employer: Stainless Fittings
9 Code / Testing Standard: BS EN ISO 14732:2013
10 Functional Knowledge Test: Acceptable
11 Job Knowledge: Not Tested
12

	Weld Test Details	Range of Qualification
13		
14	Welding Process(es) Welding Equipment Welding Unit Joint Type	Fully Mechanised Orbital Pulsed TIG (142) AMI M217 Power Source AMI 08-4000 Enclosed Head Single Sided Butt Weld
15		Fully Mechanised Orbital Pulsed 142 No Restriction No Restriction No Restriction
16	Details for Mechanised Welding	
17	Direct / Remote Visual Control	Direct Visual Control
18	Automatic Joint Tracking	Without
19	Welding Position	PK
20	Single Run / Multi Run	Single Run Only
21	Material Backing	With, Without
22	Consumable Insert	With, Without

Additional information is available on attached sheet and /or welding specification No: OB4

25	The qualification is based on: <input type="checkbox"/> Welding Procedure Test (see 4.1a) <input type="checkbox"/> Pre-Production Test (see 4.1b) <input checked="" type="checkbox"/> Standard Test Piece (see 4.1c) <input type="checkbox"/> Production test or production sample testing (see 4.1d)	 Zurich Engineering Unit 3 Steel Park Trading Estate, Wednesfield WV11 3BF Tel: 0800 026 1504 ZURICH LAB 12 SAFed/CEOC Member Company
26		
27		
28		

Date of welding test piece:

Validity of qualification until:

Revalidation 5.3a) Revalidation 5.3b) Revalidation 5.3c)

32 Revalidation of qualification by inspection body [refer to 5.3b), 5.3c)]			Confirmation of the validity by employer/welding coordinator /examiner for the following 6 months [refer to clause 5]		
Date	Signature	Position or Title	Date	Signature	Position or Title
33	Not Applicable	Not Applicable			
34					
35					
36					