



CERTIFICATE

2. Designation EN ISO 9606-1 141 T BW FM1 S s 4,0 D 89,0 H-L045 ss nb

3. Certification body : Bureau Technical Inspection OÜ
Reference no. :

4. WPS No. : 141-1.1
5. Welder's name :
6. Identification :
7. Method of Identification :
8. Date and place of birth :
9. Employer : MTÜ Keevituskeskus
10. Code / Testing Standard : EN ISO 9606-1: 2017
11. Job knowledge : not tested

Applicable: PED 2014/68/EC

		Weld test details	Range of qualification
13.	Welding process(es)	141	141,142,143,145
13.a	Transfer mode		
14.	Product type (plate or pipe)	T	T; P
15.	Type of weld	BW	BW
16.	Parent material groups(s)	1.1	1 to 11
16.a	Filler material group(s)	FM1	FM1,FM2
17.	Filler material (Designation)	(EN ISO 636-A: W 46 2 W3Si1) S	S, M
18.	Gas/Flux	EN ISO 14175-Z-Ar+NO-0,03 (I1)	-
18.a	Auxiliaries	-	-
19.	Type of current and polariry	DC (-)	-
20.	Material thickness (mm)		
20.a	Deposited thickness (mm)	4,0	3,0 to 8,0
21.	Outside pipe diameter(mm)	89,0	>= 44,5
22.	Welding position (s)	H-L045	PA, PC, PE, PF
23.	Weld details	ss nb	ss nb,ss mb,bs,ss gb
23.a	Single layer/multi layer	ml	sl, ml

Additional information:

Type of test	Performed and accepted	Not required
27. Visual testing	X	
28. Radiographic testing	X	
29. Macroscopic examination		X
30. Fracture testing		X
31. Tensile testing		X
32. Bend testing		X
33. Magnetic Particle		X
34. Hardness testing		X
35. Impact testing		X
36. Liquid penetrate testing		X

37. Confirmation for the certificate by employer/welding coordinator for the following 6 months (EN ISO 9606-1 it. 9.3)

Date	Signature	Position or title

24. Date of welding : 26.10.2018

25. Place : Estonia, Tallinn

26. Validity of approval : 25.10.2021



Detsident

(person, responsible for certification decision)

Date	Signature	Position or title