

**REPORT OF A WELDING PROCEDURE QUALIFICATION TEST**  
**Results of examinations**

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Manufacturer's Welding Procedure Insp. Authority: TÜV Teknik Kontrol ve Belgelendirme A.Ş.  
 pWPS-No.: 01 WPQR-No.: 01 Rev No:00  
 Manufacturer: Yurtseven Yedek Parça San. ve Tic A.Ş. File No.: 32352  
 Address: Düzce / Türkiye

Visual examination:	Accept	Radiographic examination*):	Accept
Dye Penetrant examination:	Accept	Ultrasonic examination*):	--

**TENSILE TESTS Accepted**

Pos. / No.	Temp. [°C]	R <sub>e</sub> /R <sub>p0,2/1,0</sub> [N/mm <sup>2</sup> ]	R <sub>m</sub> [N/mm <sup>2</sup> ]	A %	Z %	Fracture Location <sup>1)</sup>	Remarks
Requirement	20	235	--		24		
01	20	242,26	333,41		68,67	Material	Accepted
02	20	239,57	329,61		66,41	Material	Accepted

**BEND TESTS Accepted** Former diameter: 4t

Pos. / No.	Type	Bend angle	Elongation*)	Result
Requirement	Side	180	N/A	Accept
01	Side Bend	180	N/A	Accept
02	Side Bend	180	N/A	Accept
03	Side Bend	180	N/A	Accept
04	Side Bend	180	N/A	Accept

MACRO- / Picture doc.  
 MICRO EXAM.: Accept Encl. no.: 13-T-405

**IMPACT TESTS\*) N/A** Type: KV300/5 x 10 x 55mm

Pos. / Des.	Notch location	Temperature [°C]	Values			Average	Remarks / type of fracture <sup>1)</sup>
			K1	K2	K3		
Requirement							

**HARDNESS TESTS\*) N/A** Picture doc. Enclosure no.:

Type / Load	HV10	Requirement (max)	Final pass	Middle	Root
max. values:	Base material:	380			
	HAZ:	380			
	Weld material:	380			

OTHER TESTS: N/A

REMARKS:

Test carried out in accordance with the requirements of:  
 EN 15614-1 2006

Laboratory report no.: N/A

**Test results were acceptable.**

Gebze, 12.06.2013

Mr. Onur KOSAR  
 Product Testing Expert  
 for Pressure Equipment  
 of TÜV Teknik Kontrol ve Belgelendirme A.Ş.



\*) If required  
 e: acceptable ne: Not acceptable  
<sup>1)</sup> G: Base material / Ü: Transition zone / S: weld <sup>2)</sup> V: ductile fracture / M: mixed fracture / T: brittle fracture / N: no fracture

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Supervision of test welding

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 Manufacturer: Türkseven Yedek Parça San. ve Tic. A.Ş. File No.: 32352  
 Address: Düzce / Türkiye

## DETAILS OF WELDING

Date of welding: 12.06.2013 Location: Türkseven Yedek Parça San. ve Tic. A.Ş.  
 Identification of test piece: H.GÜNAL 135 Welder's name: Hidayet GÜNAL  
 Welding process: 135 Welding position: PA  
 Base material designation 1 P235GH - 1.1 Base material designation 2 P235GH - 1.1  
 Parent Metal Thickness 1 2mm. Parent Metal Thickness 2 2mm.  
 Pipe Outside Diameter 1 N/A Pipe Outside Diameter 2 N/A

## GROOVE PREPARATION

Joint Type: Butt Weld V Type Included angle: 30  
 Face: N/A [mm] Gap: 1mm. [mm]

## WELDING PARAMETER

Bead no. / run	Process	Size of Filler Metal [mm]	Current [A]	Voltage [V]	Type of current / Polarity	Wire feed [m/min]	Travel speed [cm/min]	Heat input [KJ/mm]	Interpass temp. [°C]
Root	135	1	190	23	+	N/A	41	0,51	100
Fill	135	1	220	24	+	N/A	25	1,02	

Standard designation of filler metal G42 3MIC G3Si1  
 Trade name / Manufacturer / datasheet no. GEKA SG2  
 Any Special Baking or Drying None  
 Standard designation of welding flux N/A  
 Trade name / Manufacturer N/A  
 Shielding gas / flow rate - Shielding gas: M24 12 [l/min]  
 Backing gas / flow rate - Backing gas: N/A N/A [l/min]  
 Tungsten Electrode Type / Size N/A  
 Details of Back Gouging / Backing: N/A  
 Preheat Temperature N/A  
**POST WELD HEAT TREATMENT** N/A  
 Time, Temperature, Method N/A  
 Heating and Cooling Rates\* N/A

The test pieces were welded in the presence of:  
 Kocaeli, 12.06.2013

Mr. Onur KOSAR  
 Product Testing Expert  
 for Pressure Equipment  
 of TÜV Teknik Kontrol ve Belgelendirme A.Ş.

