



Welder Performance Qualification Certificate (WPQ)

Qualification: Codes/Standards **Lloyd's Register Rules for the Manufacture, Testing and Certification of Materials (July 2021)**
Designation(s): **Lloyd's Register Rules Part 2: GTAW - FCAW T WQ11 D273 t22 6Gu B**
Welding Procedure
Specification Reference No. **WPS LAB 3378**

Welder's Name **G. Idasiak** Welder's Signature
Identification: **GI**
Method of Identification: **Drivers License**
Date and place of birth: **20 January 1979 – Wielun**
Employer: **Eerland Shiprepair BV**
Job knowledge: **Not Tested**



	Test piece	Range of qualification
Welding process(es)	GTAW: root and hot pass – FCAW: fill and cap layers	GTAW with or without filler wire Ch 12. Section 5.6.7 FCAW Ch12. Section 5.6.6
Plate or pipe or other	T (Tube / Pipe)	T (Tube) & P (Plate)
Type of joint/weld	Single V groove Buttweld Material group WQ11	Buttweld - Filletweld Ch.12 section 5.6.12 WQ11 as per LR Rules part 2 Chapter 12 Table 12.5.2 WQ11, WQ5 & WQ4 austenitic welding consumable compatible with material group WQ 11 is used as per LR Rules part 2 Chapter 12 Table 12.5.3
Material group/sub-group		Solid Wire Ch.12 section 5.6.6
Filler metal type and consumable or designation	Solid wire: T-2594 Kiswel EN ISO 14343-A:25 9 4 N L Tubular Rutile Powder Cored Wire: DW-2594 Kobelco Welding of Europe BV EN ISO 17633-A T 25 9 4 N L P M21 1	Flux Cored Wire Ch.12 section 5.6.6
Shielding gas	99.996% Ar (According to ISO 14175 Group I1 82% Ar-18% Co2 (According to ISO 14175 Group M21)	No changes in components allowed Ch12.section 5.6.16 Changes in components allowed Ch12. section 5.6.16
Auxiliaries (e.g. backing gas, flux)	B (99.996% Ar (According to ISO 14175 Group I1)	A, B, C, D, E & F Ch12.table 12.5.6
Material thickness	22mm	≥ 3.0mm
Weld metal thickness	GTAW: Weld metal thickness 6.0mm FCAW: Weld metal thickness 16.0mm	GTAW: 3.0mm to 12.0mm Ch 12. Sec. 5.6.5 FCAW: ≥ 3.0mm
Pipe outside diameter	273mm	0.5 x D
Welding positions	6Gu	Buttweld and Filletweld: D, X, Vu, O; Ch 12 table 12.5.7 LR Rules part 2 Ch.12 section 5.7.4.(b)
Other details	This certificate is valid until 10 June 2024 prolongation method 5.7.4 (b) is applicable as specified on the following pages of this Welder Qualification.	

Additional information is available on attached sheet and/or welding procedure specification No.
Test Results (state Satisfactory or Not applicable)

Not applicable

Visual	Satisfactory	Magnetic particle	Not applicable
Liquid penetrant	Satisfactory	Radiographic	Satisfactory
Ultrasonic	Not applicable	Macro examination	Not applicable
Bend	Satisfactory	Fracture	Not applicable
Other	RT report LAB715018611, PT report 715018615 & Destructive test report 1328/2 are accessory to this Welder Performance Qualification Certificate.		

We certify that the above statements are correct and that the test pieces were prepared, welded and tested in accordance with the specified

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