

TWI Certification Ltd
 Granta Park, Gt Abington, Cambridge, UK
ISO 9606 - Welder Qualification Test Certificate (WPQ)
 Welderqual



EN DESIGNATION

Designation	EN ISO 9606-1, 135, P, FW, FM1, t10, PB
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Welder's name	Fred Antwi Wiafe	Test date	19/07/2019
ID Number	FAW	WPQ record number	CSCS-163
Date of birth	01/06/1982	Standard test number	-
Stamp number	-	WPS record number	PWPS-FW-001
Company name	Private	Qualification code	EN ISO 9606-1: 2017
Division	-	Examining body	Code-A-Weld
Job knowledge	Acceptable	Reference no.	9X3932
Revalidation method	9.3(a) Retest in 3 years	Revalidation date	19/07/2022

BASE METALS

	Product form	Specification (type or grade)	Grp-no.	Size	Sch.	Thick. mm	Dia. mm
Type	Plate	EN 10025-2 (S275JR)	1.1	-	-	10	-
Welded to:	Plate	EN 10025-2 (S275JR)	1.1	-	-	10	-
Joint type	Fillet						

VARIABLES

VARIABLES	ACTUAL VALUES	RANGE QUALIFIED
Type of weld joint	Plate - Fillet	Fillet welds
Base metal	1.1 to 1.1	-

BASE METAL THICKNESS

	Butt	Fillet	Butt	Fillet
Plate thickness mm	-	10.0	-	3.0 min
Pipe/tube thickness mm	-	-	-	3.0 min
Pipe diameter mm	-	-	-	See process variables

PROCESS VARIABLES

PROCESS VARIABLES	ACTUAL VALUES	RANGE QUALIFIED
Welding process	135: MAG (solid)	135/138 MAG (Solid/Metal core)
Type	Semi-automatic	Semi-automatic
Backing	-	-
Filler metal type/designation	ISO 14341	S & M
Filler metal group	FM1	FM1, FM2
Number of layers deposited	sl - single	sl Only
Weld deposit thickness mm	0	-
Transfer mode	Spray	Spray only
Weld position (Actual position tested)	PB	-
		PA, PB (F,H)
		PA, PB (F,H)(D>=75)
		Any
		Any
Shielding gas/flux	ISO14175-M24	
Current type/polarity	DC+	

TESTS

Type of test	Acceptance criteria	Result	Comments
Visual testing per Table 13 and ISO 17637	EN ISO 5817	Acceptable	see - EN ISO 5817
Fracture Test per Table 13 and ISO 9017	EN ISO 5817	Acceptable	see - EN ISO 5817

Notes

CERTIFICATION

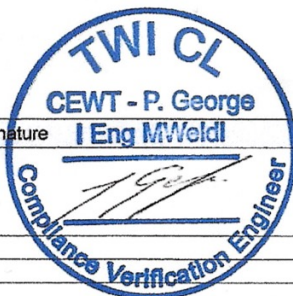
Tests conducted by	N Hitchens	Laboratory test number	0326
Mechanical tests by	Code-A-Weld Laboratory	Test file number	9X3932

We certify that the statements in this record are correct and that the test welds were prepared, welded and tested in accordance with the requirements of the relevant ISO standard.



Welding Engineer

Name	Signature
Paul George	
Date	
05/08/2019	



Certification Officer

Name	Signature
Samantha Darling	
Date	
02/08/2019	



code a weld
Welding Certification since 1932

ID: 736027

**FRED ANTWI WIAFE - Private
Approved Welder**

Standard EN ISO 9606-1:2017

Expiry Date: 19 07 2022

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