

WELDING PROCEDURE QUALIFICATION RECORD FORM (WPQR)

CERTIFICATE No.: TUV/9303/24-25/WPQR/CERT-0121

Insp. Authority TUV INDIA PVT. LTD

WPS No: VFH/WPS/M/C/01

WPQR-No.: VFH/PQR/M/C/01

Manufacturer: Vardhman Flexible Hoses

Contract Ref.: 8122551144

Address: F-10 , Faridabad Industrial Town, Sector 57, Faridabad, Haryana 121004

Requirements: BS EN ISO 15614-1:2017+A1:2019 Level 2

	(Test piece) and range of qualification
Welding Process(es) acc. ISO 4063:	(142 TIG Fully mechanized) 142 TIG Fully mechanized
Deposited thickness [mm]	(0.23) 0.46 mm maximum
Type of joint and weld:	(Square edge Butt Weld pipe long seam weld) Square edge Butt Weld pipe long seam weld
Product form:	(Pipe) pipe
Parent material (sub) group(s):	(SA 240 Type 304L, Group No.:8.1 as per EN ISO 15608) 8.1-8.1
Parent Metal thickness t [mm] :	(0.23) 0.115 to 0.46 mm
Throat thickness [mm]:	NA
Single layer / multi layer:	(Single Layer) Single layer
Outside pipe diameter [mm]:	(50) \geq OD 25 mm
Filler Metal Type/Designation:	Without Filler
Filler material make:	NA
Filler material size [mm]	NA
Designation of shielding gas / flux:	EN ISO 14175 - I1
Designation of backing gas :	EN ISO 14175 - I1
Type of Welding Current and polarity:	(DCEN) DCEN
Mode of transfer	NA
Heat input (KJ/mm)	No restriction for heat input
Welding Positions:	(PA) PA
Preheat temperature:	28°C Minimum
Interpass temperature:	NA
Post Weld Heat Treatment:	None
Temperature Limitation:	An evidence of notch impact strength has not been executed.
Special advice for manufacturing	NA
Note: Supplementary testing and repetition based on production tests as per specific standard requirement. If the production is interrupted for more than one year and positive results of quality assurance measures (i. e. production tests) can not be demonstrated the application of the procedure qualification is temporal limited until: NA .	

We Confirm that the statements in this record are correct and that the test pieces were prepared, welded, tested and have fulfilled the requirements in accordance with the requirements of the code / testing standard indicated above.

Place:Pune

Date: 19.03.2025

Enclosure: TUV/9303/24-25/WPQR/TEST-0121


Mr. Pandurang Todakar
 of TUV INDIA PVT. LTD.

TUV INDIA PRIVATE LIMITED
TUV INDIA HOUSE

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