

WELDING PROCEDURE QUALIFICATION RECORD

Ref: ROT 2025.47997 Rev.1

According to rule/standard/code: ISO 15614-7: 2019
 Manufacturer: Technocladding Europe B.V.
 Manufacturer address: Nobelstraat 25, 3846 CE Harderwijk
 Place welded: Harderwijk

Remarks/additional requirements: -

General information

WPS No./Rev No:	25EWI07401	Date of test weld:	16-06-2025
Welding process(es)	523	Single/double side welding	Single side Backing (e.g. gas): --
Welding position:	PA	Preheating temp:	20°C

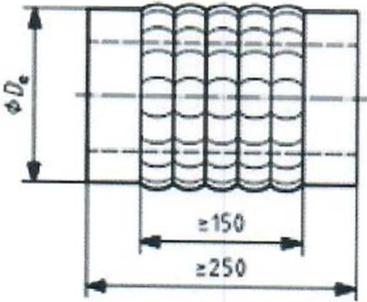
Material specification

Base material 1:	S355J2+N	Base material 2:	--
Delivery condition:	Normalized	Delivery condition:	--
Heat No:	488221	Heat No:	--
Material thickness:	--	Material thickness:	--
Outside diameter:	90	Outside diameter:	--
Additional information: (e.g. C%, C _{eq} , P _{cm})	C= 0.176% C _{eq} = 0.41	Additional information: (e.g. C%, C _{eq} , P _{cm})	--

Welding consumables

Filler metal			Gas	Flux		DNV grade
No.	Manufacturer	Brand name/ Designation		Manufacturer	Brand name/ Designation	
1	Metco	1625F	100% Ar			

Joint preparation (sketch) and welding details

Joint design	Welding sequences
State rolling direction, if applicable	For multiple welding process qualification, the deposited weld metal thickness shall be recorded for each filler metal and process used.
	



Run/layer	Welding Process	Ø filler metal (mm)	Filler metal No.	Flow rate gas (l/min)	Current (A)	Voltage (V)	Type of current/polarity	Travel speed (mm/min)	Forehand/backhand progression	Inter-pass temp. (°C)	Heat input (kJ/mm)
Welding parameters reference to procedure 25EWI07401											

Further information

Name of welder/operator:	J. Miedema	Baking of electrodes:	-
PWHT (Temperature/Time):	-	Heating/Cooling rate:	-

Other (e.g. weaving, groove preparation, gouging, grinding): -



TEST RESULTS

Non-destructive testing

Test Method	Results	Test report No.	Test Method	Results	Test report No.
Visual inspection:	Acceptable	VT25EWI07401	Radiographic test:		
Ultrasonic test:	Acceptable	403745022 (Version 0)	Magnetic particle/ Dye penetrant test:	Acceptable	403745018 (Version 0)

Destructive testing

Tensile test			Test report No:		
Specified YS min:			Specified TS min:		

No.	Dimension	Area (mm ²)	Temp. °C	YS (N/mm ²)	Break load Fm (N)	TS (N/mm ²)	Elongation (%)	Location/ Character of fracture

Bend test			Test report No:		25.1524
Specified degree:			Mandrel diameter:		40 mm

Type	Dimension (W x T)	Result	Type	Dimension (W x T)	Result
Side bend	10 x 15 mm	Acceptable			
Side bend	10 x 15 mm	Acceptable			

Notched bar impact test			Test report No:		
Test temperature:			Minimum requirement:		

Notch location	Result 1 (J)	Result 2 (J)	Result 3 (J)	Average (J)
Weld metal				
Fusion line				
Fusion line + 2 mm				
Fusion line + 5 mm				
Fusion line + 10 mm				



Hardness tests HV 10										Test report No:					25.1524				
Sketch																			
Vickers hardness test HV10 Method: ISO 9015-1										Test date: 13-08-2025					Performed under accreditation RvA L647: WI-B1 Location: On cross section				
Specimen no: 25.1524																			
Location		Base			Fusion line			Weld											
Indent	1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18	19
Traverse	161	169	172	214	276	296	319	309	280	-	-	-	-	-	-	-	-	-	-

Test Method	Results	Test report No.	Test Method	Results	Test report No.
Macro photo			Fracture Test		
Micro photo	Acceptable	25.1524	Chemical Analyses	Acceptable	25.1524

This is to certify:

That the statements in this record are correct and the welds were prepared, welded, heat treated and tested in accordance with the specified rule/code/standard and/or purchaser's specification.

- This Record is approved for application under PED 2014/68/EU by DNV Business Assurance B.V. (CAB 2388, 'beschikking 2021-0000082943; Accredited RvA I319)
- This Record is approved for application under DNV Classification Rules and Offshore Standards
- This Record is not direct ready for application under DNV Classification Rules and Offshore Standards

Survey station: Barendrecht
 Surveyor: H.H.A. Elshof

Place: Barendrecht
 Date: 25-10-2025

for DNV Business Assurance B.V.



I. Šakys
 DNV authorized representative

Note: Assessment for specific application to be performed on the application project itself

In compliance with Dutch legislation, reference is made to DNV document "Reglement behandeling Klachten, Bezwaar en Beroep" for dealing with Complaints, Objections and Appeals. This document is retrievable at DNV Business Assurance B.V.