



# Český svářečský ústav s.r.o.®

(Czech Welding Institute Ltd.)

Divize inspekce - inspekční orgán č. 4005

Vratimovská 624/11, 718 00 Ostrava – Kunčičky

Czech Republic



## INSPECTION CERTIFICATE

No.: 11C - 4546

Rev. 0

Manufacturer: ŠTERNBERSKÉ STROJÍRNY s.r.o. I No.: 46576169  
 Address: U dráhy 2297/4 785 01 Šternberk

### RANGE OF QUALIFICATION

Standard: ČSN EN ISO 15614-1 Level 1  Level 2  WPQR No.: 1P- 4546  
 Addit. requirements: -

### Parent Material(s)

Specification according to standard: S355J2+N / ČSN EN 10027-1  
 Group(s) and subgroup(s): 1.2 / TNI CEN ISO/TR 15608  
 Other materials: see ČSN EN ISO 15614-1, čl. 8.3.1, tab. 5

Parent material Thickness	Outside pipe / profile diameter*	Branch angle	Throat thickness
BW: 3,0-20,0 mm FW: 3,0-20,0 mm	D > 500 mm or D > 150 mm welded in PA rotated position	-	No restriction

### Welding process(es) (EN ISO 4063)

Process: 135 Degree of mechanization: partly mechanized Deposited metal thickness: max. 20,0 mm  
 Welding positions (EN ISO 6947): PA

### Type of joint and weld

#### Multi run

Butt joint on plate				T-butt joint		Fillet weld on plate	Butt joint on tube/pipe				Fillet weld on tube/pipe
one-sided		double-sided		one-sided	double-sided		one-sided		double-sided		
backing	no backing	gouging	no gouging			one-sided	double-sided	backing	no backing	gouging	no gouging
YES	YES	YES	YES	YES	YES	YES	YES*	YES*	YES*	YES*	YES*

### Filler material(s) (FM)

Index FM	Type	Trade mark	Standard - Classification
A	Welding Wire	OK AristoRod 12.50	EN ISO 14341-A: G 3Si1
B	Shielding Gas	82%Ar, 18%CO <sub>2</sub>	ČSN EN ISO 14175 -M21

### Other welding process specifications

Weld zone	Welding process	Index FM	Current / polarity	Weld Metal Transfer	Heat Input (kJ/mm)
Root	135	A+B	DC/+	D	0,65 - 1,22
Filling runs	135	A+B	DC/+	G, S, P	0,60 - 1,13

Welding process information: See ČSN EN ISO 15614-1, čl. 8.5.2

### Heat conditions

Preheat Temperature (°C)	Interpass Temperature (°C)	Post heating (temp./holding)	Post Weld Heat Treatment (temperature/holding time)
-	max. 198°C	-	-

A welding procedure test according to this document prepared by a manufacturer is valid for welding in workshops or sites when the manufacturer who performed the welding procedure test retains complete responsibility for all welding carried out to it.

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 ISO 15614-1.

Date of issue: 14.10.2020

Location: Ostrava

Stamp and signature:

Approved by: Ing. David Schwarz



The following documents are an integral part of this Inspection Certificate:

Inspection report, WPQR č. 1P - 4546

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## INSPECTION CERTIFICATE

No.: 11C - 4547

Rev. 0

<b>Manufacturer:</b> ŠTERNBERSKÉ STROJÍRNY s.r.o.		I No.: 46576169				
<b>Address:</b> U dráhy 2297/4		785 01 Šternberk				
<b>RANGE OF QUALIFICATION</b>						
<b>Standard:</b> ČSN EN ISO 15614-1		Level 1 <input checked="" type="checkbox"/>	Level 2 <input checked="" type="checkbox"/>			
<b>Addit. requirements:</b>		-				
<b>Parent Material(s)</b>						
Specification according to standard:		S355J2+N / ČSN EN 10027-1				
Group(s) and subgroup(s):		1.2 / TNI CEN ISO/TR 15608				
Other materials:		see ČSN EN ISO 15614-1, čl. 8.3.1, tab. 5				
Parent material Thickness	Outside pipe / profile diameter	Branch angle	Throat thickness			
3,0 - 20,0 mm	-	-	No restriction			
<b>Welding process(es) (EN ISO 4063)</b>						
Process: 135	Degree of mechanization: partly mechanized	Deposited metal thickness: -				
Welding positions (EN ISO 6947): PB						
<b>Type of joint and weld</b>						
Multi run						
Butt joint on plate		T-butt joint	Fillet weld on plate		Butt joint on tube/pipe	Fillet weld on tube/pipe
one-sided	double-sided		one-sided	double-sided		
backing	no backing	gouging	no gouging	one-sided	double-sided	on
NO	NO	NO	NO	NO	NO	NO
<b>Filler material(s) (FM)</b>						
Index FM	Type	Trade mark	Standard - Classification			
A	Welding Wire	OK AristoRod 12.50	EN ISO 14341-A: G 3Si1			
B	Shielding Gas	82%Ar, 18%CO <sub>2</sub>	ČSN EN ISO 14175 -M21			
<b>Other welding process specifications</b>						
Weld zone	Welding process	Index FM	Current / polarity	Weld Metal Transfer	Heat Input (kJ/mm)	
Root	135	A+B	DC/+	G, S, P	0,43	0,63
Filling runs	135	A+B	DC/+	G, S, P	0,43	0,59
Welding process information:		See ČSN EN ISO 15614-1, čl. 8.5.2				
<b>Heat conditions</b>						
Preheat Temperature (°C)	Interpass Temperature (°C)	Post heating (temp./holding)	Post Weld Heat Treatment (temperature/holding time)			
-	205°C	-	-			

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Date of issue: 09.10.2020

Location: Ostrava

Stamp and signature:



Approved by: Ing. David Schwarz

The following documents are an integral part of this Inspection Certificate:

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