WELDING PROCEDURE QUALIFICATION RECORD FORM (WPQR)

EN ISO 15614-1:2017

WELDING PROCEDURE QUALIFICATION TEST CERTIFICATE

WPS No:	01/26	Examining body:	EUROCERT S.A.
Manufacturer:	KS CONSTRUCTION GROUP IKE	Reference No:	10.24.0601.01
Address:	VEROIA , GREECE	Code / Testing Standard:	EN ISO 15614-1:2017
Level:	2	Date of Welding:	22/12/2025

Range of qualification

Product Form:	PIPE
Welding Process(es):	142
Type of joint:& weld	Full and Partial Penetration BUTT WELDS, branch connections with an angle a≥600, FILLET WELDS
Parent Metal(s) group:	8.1 steels in the same sub-group and any lower sub-group within the same group
Parent Metal Thickness (mm):	1 to 4
Deposited Metal Thickness (mm):	Max 4
Throat Thickness (mm)	-
Single run/Multi run	Single run
Outside Pipe Diameter (mm):	>57.15
Filler Metal Designation:	-
Filler Material Make	-
Filler Material Size (mm)	-
Designation of Shielding Gas / Flux:	EN 14175 I1
Designation of Backing Gas	EN 14175 I1
Type of Welding Current: & Polarity	DC (-)
Transfer Mode:	-
Heat Input	-
Welding Positions:	All welding Positions
Preheat Temperature	-
Interpass Temperature	-
Post-Heating	-
Post – Weld Heat Treatment	-
Other Information:	-

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

Location	Date of Issue	Test Body / Surveyor
METAMORFOSI GREECE	08/01/2026	EUROCERT S.A/ P. TERZIS

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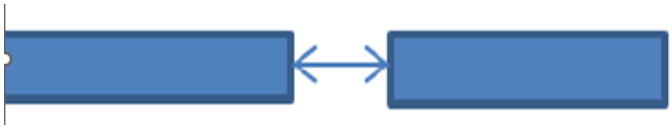
RECORD OF WELD TEST
EN ISO 15614-1:2017

Location: VEROIA , GREECE	Examiner or test body: EUROCERT S.A.
WPS No: 01/26	Method of Preparation and cleaning: Cutting and Grinding
WPQR No: 10.24.0601.01	Parent Material Specification: AISI 304L , 1.4307-EN 10217-7
Manufacturer: KS CONSTRUCTION GROUP IKE	Material Thickness (mm): 2
Welders/ ~~Operator's~~ Name: KELESIDIS STAVROS	Outside Pipe diameter (mm): 114.3
Joint Type: BUTT WELD	Welding Position: HL-045

Weld Preparation details (sketch):

Joint Design	Welding Sequences
	

Welding Details

Run	Process	Size of Filler Metal	Current A	Voltage V	Type of current / Polarity	Wire Feed Speed mm/min	Travel Speed mm/min	Heat Input kJ/mm	Metal Tranfer
1	142	-	65-22	9,1-7,4	DC (-)	-	263,8	0,09-0,03	-

Filler Metal Classification: -

Any Special Baking or Drying: -	
Gas / Flux: – Shielding: EN 14175 I1 Backing: EN 14175 I1	Heating and Cooling Rates: -
Gas Flow Rate – Shielding: 10-11 lt/min Backing: 8-9 lt/min	Other Information (If Required): ss nb, sl, Orbital Welding Polysoude-EWM Weaving (Maximum Width of Run):
Tungsten electrode Type / Size: -	Oscillation:
Details of Back Gouging / Backing: GAS BACKING	Pulse welding details: -
Preheat Temperature: -	Stand off Distance:-
Interpass Temperature: -	Plasma welding details:
Post heating: -	Torch angle: 90
Post Weld Heat Treatment and/or Ageing:-	Nozzle Diameter :18 mm
Time, Temperature, Method:-	

Manufacturer /Date	Test Body / Surveyor/Date
KS CONSTRUCTION GROUP IKE / 08/01/2026	EUROCERT SA/ P.TERZIS / 08/01/2026

TEST RESULTS

Reference No. 10.24.0601.01

Visual Examination: **ACCEPTABLE – VT/T/25/307** Radiography* **ACCEPTABLE – RT/T/25/451**

Penetrant/~~Magnetic~~ Particle Test* **ACCEPTABLE LPT/T/25/261** Ultrasonic Test * **-**

Tensile Test ACCEPTED – TT/T/25/030

Type/No.	Tensile Strength (Rm) N/mm²	Yield Strength (Re) N/mm²	Elongation n (A % on)	Reduction Of Area (Z%)	Fracture Location	Test Temperature (ºC)	Remarks
WT1A	545,17				BM	21 C	
WT1B	538,98				BM	21 C	

Bend Tests ACCEPTABLE - BT/T/25/046

Type/No.	Bend Angle	Elongation*	Results
FBB1	180o		ACCEPTABLE
FBB2	180o		ACCEPTABLE
RBB1	180o		ACCEPTABLE
RBB2	180o		ACCEPTABLE

Macro Examination: **ACCEPTABLE Macro/T/25/227**

Micro Examination*:

Impact Tests* -

Notch Location / Direction	Temp. ºC	Values 1 2 3			Average	Remarks

Hardness Tests: - Location of Measurements (see report)

Tests carried out in accordance with the requirements of EN ISO 15614-1:2017

Laboratory Report Reference No. **T.C.L. Co. - Test & Control Laboratories**

Test results were acceptable/~~not acceptable~~

Test carried out in the presence of	A. DIPSAKIS	08/01/2025	By **T.C.L. Co. - Test & Control Laboratories**

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