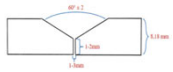
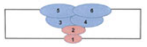
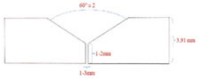
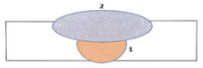
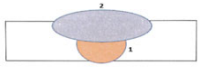
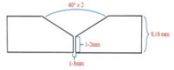
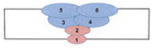
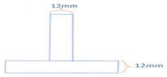
WPQR KAYIT FORMU

(Welding Procedure Qualification Registration Form)

FORM NO: 011 | DOKÜMAN NO: | GÜNCELLEME TARİHİ: : 28.10.2018

WPS NO	LOCATİON	WPQR NO	PROCESS	JOIN TIPI	POSITION	MATERİAL	CONFIRMATIVE	M.THICKNESS (mm)	JOINT DESIGN	WEDING SEQUENCES	FİLLER METAL CLASSIFICATION	TRADE NAME	DETAILS OF BACK GOUGING / BACKING	VOLTAJ	AMPER
1	YALOVA	0001	141+136	BW	HL-045	1,1	BV	D ≥109,55mm			ISO 636-A:09-W3Si1 I1 ISO17632-A:09-T424P C1	HYUNDAİ	-	141: 10&12 136: 24&27	141: 100&120 136: 200&240
2	YALOVA	0002	141	BW	HL-045	1.1	BV	D ≥30.15mm			ISO 636-A:09-W3Si1 S2 TIG 2.4mm	GEKA	-	141: 10&12	141: 80&100
3	YALOVA	0003	141	BW	HL-045	8.1	BV	D ≥57,15mm			ISO 14343-A:10 W Z 19 12 3 L I1	GEKA	-	10&11	80&110
3	YALOVA	0004	136	BW	PA	1,2	BV	3mm ≤ t ≤24mm			ISO17632-A:09-T424P C1	HYUNDAİ	-	24&26	230&260
3	YALOVA	0005	136	FW	PB	1,2	BV	3mm ≤ t ≤24mm			ISO17632-A:09-T424P C1	HYUNDAİ	-	24&26	230&260