



"Certification Centre" Ltd

SPECIALIST CERTIFICATION CENTRE

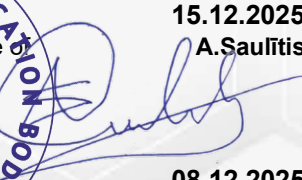
WELDER QUALIFICATION TEST CERTIFICATE

Page 1 of 2

1
 2
 3 Designation (s): **EN ISO 9606-1 136 T BW FM1 B s9.75 D245.0 PC ss mb**
 4 Certificate No: **SC-SSC-M-2025/0775**
 5 Welding Procedure **136**
 6 Specification No:
 7 Welder's name, surname: **Chen Shixing**
 8 Identification: **370830198411085718**
 9 Method of identification: **ID CARD**
 10 Date and place of birth: **19841108.No. 244, Wenming Road, Chentang**
 11 Employer: **Village,Guocang Town, Wenshang County,**
 12 Testing Standard/ Code: **Shandong Province**
 13 Job knowledge: **Shandong Shijie Heavy Industry Co., Ltd**
 14 Extra verification for fillet welds: **EN ISO 9606-1: 2022**
 15 **Acceptable/ not tested** (Delete as necessary)
 16 **Yes / No** (Delete as necessary)



	TEST PIECE	RANGE OF QUALIFICATION
15 Welding process (es)	136	136
16 Product type (plate or pipe)	T	T, P
17 Transfer mode	-	-
18 Type of weld	BW	BW, branch connections with angle $\alpha \geq 60^\circ$
19 Parent material group(s)/subgroups	1.2	-
20 Filler material group(s)	FM1	FM1, FM2
21 Filler material (Designation)	B	B;R,P,V,W,Y, Z
22 Shielding gas	C1	-
23 Auxiliaries	-	-
24 Type of current and polarity	DC/+	DC/+
25 Material thickness [mm]	9.75	-
26 Deposited thickness [mm]	9.75	3.0-19.5
27 Outside pipe diameter [mm]	245.0	≥ 122.5
28 Welding position	PC	PA, PC
29 Weld details	ss mb	ss mb,ss

30	Examining Body:		
31	CERTIFICATION CENTRE Ltd		
32	SPECIALIST CERTIFICATION CENTRE		
33	Location: Aptiekas street 17A, Riga		
34	Date of issue: 15.12.2025		
35	Name, Surname and Signature of: A.Saulitis		
36	Surveyor: 		
37	Date of Welding: 08.12.2025		

38	Revalidation 9.3 a)	Valid until: 07.12.2028	Revalidation 9.3 b)	-	Revalidation 9.3 c)	-
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 39 Prolongation for qualification by examining body for the
 40 following years

Date	Signature	Position or Title

 Confirmation of the validity by employer / welding
 coordinator for the following 6 months

Date	Signature	Position or Title

42 Continued overleaf

Continued overleaf





"Certification Centre" Ltd SPECIALIST CERTIFICATION CENTRE

WELDER QUALIFICATION TEST CERTIFICATE

Page 1 of 2

1
 2
 3 Designation (s): **EN ISO 9606-1 136 T BW FM1 B s5.75 D273.0 PC ss mb**
 4 Certificate No: **SC-SSC-M-2025/0776**
 5 Welding Procedure **136**
 6 Specification No:
 7 Welder's name, surname: **Lu Mingming**
 8 Identification: **37088319920701651X**
 9 Method of identification: **ID CARD**
 10 Date and place of birth: **19920701.No.177, Gao Si Zhi Cun Village, ShiQiang**
 11 Employer: **Town, Zoucheng City, Shandong Province**
 12 Testing Standard/ Code: **Shandong Shijie Heavy Industry Co., Ltd**
 13 Job knowledge: **EN ISO 9606-1: 2022**
 14 Extra verification for fillet welds: **Acceptable/ not tested** (Delete as necessary)
 15 **Yes / No** (Delete as necessary)



	TEST PIECE	RANGE OF QUALIFICATION
15 Welding process (es)	136	136
16 Product type (plate or pipe)	T	T, P
17 Transfer mode	-	-
18 Type of weld	BW	BW, branch connections with angle $\alpha \geq 60^\circ$
19 Parent material group(s)/subgroups	1.2	-
20 Filler material group(s)	FM1	FM1, FM2
21 Filler material (Designation)	B	B; R, P, V, W, Y, Z
22 Shielding gas	C1	-
23 Auxiliaries	-	-
24 Type of current and polarity	DC/+	DC/+
25 Material thickness [mm]	5.75	-
26 Deposited thickness [mm]	5.75	3.0 -11.5
27 Outside pipe diameter [mm]	273	≥ 136.5
28 Welding position	PC	PA, PC
29 Weld details	ss mb	ss mb, ss

30

Type of qualification test	Performed and accepted	Not tested
31 Visual testing (BW)	X	-
32 Ultrasonic testing (BW)	X	-
33 Fracture test	-	X
34 Bend test	-	X
35 Notch tensile test	-	X
36 Macroscopic examination	-	X

38 Revalidation 9.3 a)	Valid until: 07.12.2028	Revalidation 9.3 b)	-	Revalidation 9.3 c)	-
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 39 Prolongation for qualification by examining body for the
 40 following years

Date	Signature	Position or Title

42 Continued overleaf

Examining Body:
CERTIFICATION CENTRE Ltd
SPECIALIST CERTIFICATION CENTRE
 Location: **Aptiekas street 17A, Riga**

 Date of issue: **15.12.2025**

 Name, Surname and Signature of: **A.Saulitis**

Surveyor:

 Date of Welding: **08.12.2025**

Confirmation of the validity by employer / welding coordinator for the following 6 months

 Date of issue: **15.12.2025**

 Name, Surname and Signature of: **A.Saulitis**

Surveyor:

 Date of Welding: **08.12.2025**

Confirmation of the validity by employer / welding coordinator for the following 6 months

 Date of issue: **15.12.2025**

 Name, Surname and Signature of: **A.Saulitis**

Surveyor:

 Date of Welding: **08.12.2025**

Confirmation of the validity by employer / welding coordinator for the following 6 months

 Date of issue: **15.12.2025**

 Name, Surname and Signature of: **A.Saulitis**

Surveyor:

 Date of Welding: **08.12.2025**

Confirmation of the validity by employer / welding coordinator for the following 6 months

 Date of issue: **15.12.2025**

 Name, Surname and Signature of: **A.Saulitis**

Surveyor:



1. WELDING PROCEDURE QUALIFICATION RECORD FORM (WPQR)**2. WELDING PROCEDURE QUALIFICATION – TEST CERTIFICATE**

3. Manufacturer's WPQR No.:	WPQR-9597	Examiner or examining body:	
4. Manufacturer:	Shandong Shijie Heavy Industry Co., Ltd		Certificaton centre Ltd.
5. Address:	11th Industrial Park, Huangtun Street, High tech Zone, Jining City, Shandong Province		
6.		Reference No. :	WTEST2025120801
7. Date of Welding:	08.12.2025		
8. Code/Testing Standard:	EN ISO 15614-1+A1:2020 Level 2		
9. RANGE OF QUALIFICATION			
10. Welding Process(es):	136 (MAG) according to EN ISO 4063		
11. Type of joint and weld:	BW		
12. Parent material group(s) and	Group No.1 (carbon steel with specified minimum yield strength 275 N/mm² < ReH ≤ 360 N/mm²)		
13. sub group(s):	with sub group No. 1.2 according to CEN ISO/TR 15608		
14. Parent Material Thickness for Butt Welds (mm):	t_{9.75}: 3mm - 19.5mm		
15. Parent Material Thickness for Fillet Welds (mm):	----		
16. Throat Thickness (mm):	NA		
17. Single run/Multi run:	Multi run weld		
18. Outside Pipe Diameter (mm):	≥122.5		
19. Filler Material Designation:	ISO 17632-B, T492T1-1C1A		
20. Filler Material Size:	input range must satisfied		
21. Filler Material Make:	No restriction		
22. Mode of Metal Transfer:	Short metal transfer		
23. Designation of Shielding Gas/Flux:	C1 according to EN ISO 14175		
24. Designation of Backing Gas:	---		
25. Type of Welding Current and Polarity:	DC/+		
26. Welding Positions:	Positions PA and PC according to LVS EN ISO 6947		
27. Preheat Temperature:	Min. +5° according to LVS EN 1011-2		
28. Interpass Temperature:	Max. +280° according to LVS EN 1011-2		
29. Post-Weld Heat-Treatment:	---		
30. Other Information:	Heat input: full: 0.43-1.42		
31. Certified that test welds prepared, welded and tested satisfactorily in accordance with the requirements of the code/testing standard indicated above.			

32. Location: **Jining City, Shandong Province** Date of issue: **15.12.2025**

33. Examiner or examining body:

34. Name and signature

35.

RECORD OF WELD TEST

36. Location: **11th Industrial Park, Huangtun Street,
High tech Zone, Jining City, Shandong
Province**

37. Mfr's pWPS No: **SDSJ-WPS-01**

38. Manufacturer's WPQR No: **WPQR-9597**

39. Manufacturer: **Shandong Shijie Heavy Industry Co.,
Ltd**

40. Welder's Name: **Chen Shixing**

41. Joint Type: **BW**

42. Welding Position: **PC**

43. Welding process: **136**

Examiner or examining body:

Certificaton centre Ltd.

Method of Preparation and Cleaning:

Machining

Parent Material Specification:

Q335B(GB/T 1591), Material group No. 1.2

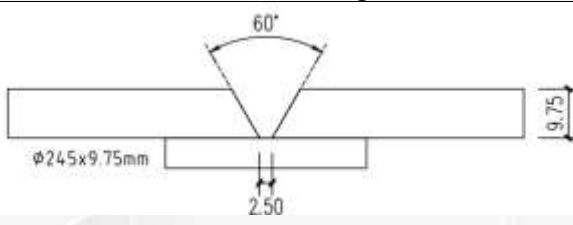
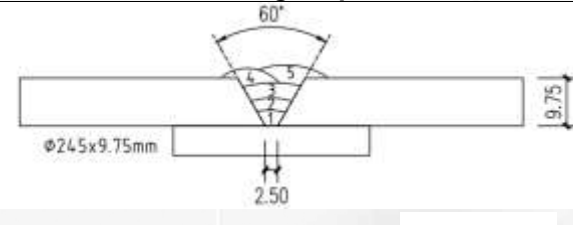
Material Thickness (mm):

9.75 mm

Outside Pipe Diameter (mm):

245.0 mm

44. Weld Preparation Details (Sketch)* :

Joint Design	Welding Sequences
	

46. Welding Details:

Run/ transfer	Welding Process	Size of Filler Material	Current A	Voltage V	Type of current/ Polarity	Wire Feed Speed [m/min]	Travel Speed* [mm/min]	Heat input*
1	136/PC,PA	1.2	120-150	22.4-25.2	DC+	2.0-2.5	200-300	0.43-0.91
2-3	136/PC,PA	1.2	180-210	25.4-28.7	DC+	2.0-2.5	250-300	0.73-1.16
4	136/PC,PA	1.2	160-200	24.4-29.5	DC+	2.0-2.5	200-300	0.62-1.42

48. Filler Material for Root Run:

49. Designation: **ISO 17632-B, T492T1-1C1A**

50. Trademark: **Tianjin jinqiao**

51. Any Special Baking or Drying: **_____**

52. Gas/Flux: **_____**

53. Shielding: **99.99%CO₂**

54. Backing: **with**

55. Gas Flow Rate: **_____**

56. Shielding: **10.0 – 20.0 (L/min)**

57. Backing: **_____**

58. Tungsten Electrode Type/Size: **_____**

59. Details of Back Gouging/Backing: **ss, mb**

60. Preheat Temperature: **min. +5°**

61. Interpass Temperature: **max. +280°**

62. Post-Weld Heat Treatment: **_____**

63. **Without**

64. Time, Temperature, Method: **_____**

65. Heating and Cooling Rates*: **_____**

66. * If required

67. Manufacturer: **Shandong Shijie Heavy Industry Co., Ltd**

Other information* e.g.:

Weaving (maximum width of run): **_____**

Oscillation : amplitude, frequency, dwell time: **_____**

Number of wire electrodes: **1 piece**

Distance contact tube/ workpiece: **15.0 – 18.0 mm**

Ferrule diameter: **18.0 mm**

Torch angle: **5° – 15°**

The lowest temperature prior to welding without
pre-heating °C: **5**

Filler Material for Interpass and Face Runs:

Designation: **ISO 17632-B, T492T1-1C1A**

Trademark: **Tianjin jinqiao**

Any Special Baking or Drying: **_____**

Examiner or examining body:

Name, date and signature

68.

TEST RESULTS

69.

70.

Examiner or examining body:

71. Manufacturer's

72. WPQR

WPQR-9597
Certificaton centre Ltd.

No:

73. Temperature:

+20 °C

Reference No.:

WTEST2025120801

74.

Radiography*:

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75.

Ultrasonic*:

acceptable

76. Visual:

acceptable

Penetrant/Magnetic Particle*:

acceptable

77. Former Diameter (mm):

245

Macroscopic Examination:

acceptable

78. Tensile Tests: **required**

Type/No.	Re N/mm ²	Rm N/mm ²	A %	Z %	Fracture Location	Remarks
Requirement						
Transverse	410	510	-	-	base material	
Transverse	420	495	-	-	base material	

82a. BEND TEST: **required**

Type/No.	Bend Angle	Elongation*	Results
Face bend	180	-	acceptable
Face bend	180	-	acceptable
Root bend	180	-	acceptable
Root bend	180	-	acceptable

88. Impact Test*: **required**

Type: **V (VWT; VHT)**

Size:

Requirements:

Notch Location/Direction	Temp. °C	Values			Average	Remarks
		1	2	3		
Weld seam	0	36	38	41	38.3	
HAZ	0	30	32	33	31	
Base material	0	34	35	34	34.3	

91. Hardness Test* (Type/Load): **acceptable**

Location of Measurements (Sketch*)

92. Type/Load: **HV10 Max 380 HV**

93. Parent

Nr.1-214;2-235;3-232;
Nr.16-222;17-245;18-224;

Metal:

94. HAZ:

Nr.4-222;5-232;6-252;7-254;8-230;9-211;
Nr.19-235;20-246;21-238;22-237;23-236;24-244;

95. Weld

metal:

**Nr.10-160;11-164;12-167;13-165;
14-163;15-176**
**Nr.25-170;26-168;27-176;28-168;
29-165;30-178**

96. Other Tests:

97. Remarks:

98. Tests Carried out in accordance with the requirements of standart: **EN ISO 15614-1+A1:2020 Level 2**

99. Laboratory Report Ref. No.: **VT-206-1; CT-206-1; MT-206-1; MP-206-1**

100. Test results were **acceptable/not acceptable**

(Delete as appropriate)

101. Test carried out in

Examiner or examining body:

102. the presence of:

103. * If required

104.

Name, date and signature

1. WELDING PROCEDURE QUALIFICATION RECORD FORM (WPQR)**2. WELDING PROCEDURE QUALIFICATION – TEST CERTIFICATE**

3. Manufacturer's WPQR No.:	WPQR-9598	Examiner or examining body:	
4. Manufacturer:	Shandong Shijie Heavy Industry Co., Ltd		Certificaton centre Ltd.
5. Address:	11th Industrial Park, Huangtun Street, High tech Zone, Jining City, Shandong Province		
6.		Reference No. :	WTEST2025120802
7. Date of Welding:	08.12.2025		
8. Code/Testing Standard:	EN ISO 15614-1+A1:2020 Level 2		
9. RANGE OF QUALIFICATION			
10. Welding Process(es):	136 (MAG) according to EN ISO 4063		
11. Type of joint and weld:	BW		
12. Parent material group(s) and	Group No.1 (carbon steel with specified minimum yield strength 275 N/mm² < ReH ≤ 360 N/mm²)		
13. sub group(s):	with sub group No. 1.2 according to CEN ISO/TR 15608		
14. Parent Material Thickness for Butt Welds (mm):	t_{5.75}: 3mm - 11.5mm		
15. Parent Material Thickness for Fillet Welds (mm):	----		
16. Throat Thickness (mm):	NA		
17. Single run/Multi run:	Multi run weld		
18. Outside Pipe Diameter (mm):	≥136.5		
19. Filler Material Designation:	ISO 17632-B, T492T1-1C1A		
20. Filler Material Size:	input range must satisfied		
21. Filler Material Make:	No restriction		
22. Mode of Metal Transfer:	Short metal transfer		
23. Designation of Shielding Gas/Flux:	C1 according to EN ISO 14175		
24. Designation of Backing Gas:	---		
25. Type of Welding Current and Polarity:	DC/+		
26. Welding Positions:	Positions PA and PC according to LVS EN ISO 6947		
27. Preheat Temperature:	Min. +5° according to LVS EN 1011-2		
28. Interpass Temperature:	Max. +280° according to LVS EN 1011-2		
29. Post-Weld Heat-Treatment:	---		
30. Other Information:	Heat input: full:0.38-1.16		
31. Certified that test welds prepared, welded and tested satisfactorily in accordance with the requirements of the code/testing standard indicated above.			

32. Location: **Jining City, Shandong Province** Date of issue: **15.12.2025**

33. Examiner or examining body:

34. _____
Name and signature





35.

RECORD OF WELD TEST

36. Location: **11th Industrial Park, Huangtun Street,
High tech Zone, Jining City, Shandong
Province**

37. Mfr's pWPS No: **SDSJ-WPS-02**

38. Manufacturer's WPQR No: **WPQR-9598**

39. Manufacturer: **Shandong Shijie Heavy Industry Co.,
Ltd**

40. Welder's Name: **Lu Mingming**

41. Joint Type: **BW**

42. Welding Position: **PC**

43. Welding process: **136**

Examiner or examining body:

Certificaton centre Ltd.

Method of Preparation and Cleaning:

Machining

Parent Material Specification:

Q335B(GB/T 1591), Material group No. 1.2

Material Thickness (mm):

5.75 mm

Outside Pipe Diameter (mm):

273.0 mm

44. Weld Preparation Details (Sketch)* :

45.	Joint Design	Welding Sequences

46. Welding Details:

47.	Run/ transfer	Welding Process	Size of Filler Material	Current A	Voltage V	Type of current/ Polarity	Wire Feed Speed [m/min]	Travel Speed* [mm/min]	Heat input*
	1	136/PC,PA	1.2	110-140	21.4-24.5	DC+	2.0-2.5	200-300	0.38-0.82
	2	136/PC,PA	1.2	180-210	25.4-28.7	DC+	2.0-2.5	250-300	0.73-1.16

48. Filler Material for Root Run:

49. Designation: **ISO 17632-B, T492T1-1C1A**

50. Trademark: **Tianjin jinqiao**

51. Any Special Baking or Drying: _____

52. Gas/Flux:

53. Shielding: **99.99%CO₂**

54. Backing: **with**

55. Gas Flow Rate:

56. Shielding: **10.0 – 20.0 (L/min)**

57. Backing:

58. Tungsten Electrode Type/Size: _____

59. Details of Back Gouging/Backing: **ss, mb**

60. Preheat Temperature: **min. +5°**

61. Interpass Temperature: **max. +280°**

62. Post-Weld Heat Treatment: _____

63. _____

64. Time, Temperature, Method: _____

65. Heating and Cooling Rates*: _____

66. * If required

67. Manufacturer:

Shandong Shijie Heavy Industry Co., Ltd

68. Name, date and signature

Other information* e.g.:

Weaving (maximum width of run): _____

Oscillation : amplitude, frequency, dwell time: _____

Number of wire electrodes: **1 piece**

Distance contact tube/ workpiece: **15.0 – 18.0 mm**

Ferrule diameter: **18.0 mm**

Torch angle: **5° – 15°**

The lowest temperature prior to welding without
pre-heating °C: **5**

Filler Material for Interpass and Face Runs:

Designation: **ISO 17632-B, T492T1-1C1A**

Trademark: **Tianjin jinqiao**

Any Special Baking or Drying: _____

Examiner or examining body:

Name, date and signature





69. TEST RESULTS

70. Examiner or examining body:

71. Manufacturer's

72. WPQR

WPQR-9598
Certificaton centre Ltd.

No:

73. Temperature:

+20 °C

Reference No.:

WTEST2025120802

74.

Radiography*:

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75.

Ultrasonic*:

acceptable

76. Visual:

acceptable

Penetrant/Magnetic Particle*:

acceptable

77. Former Diameter (mm):

273

Macroscopic Examination:

acceptable

78. Tensile Tests: **required**

Type/No.	Re N/mm ²	Rm N/mm ²	A %	Z %	Fracture Location	Remarks
Requirement						
Transverse	420	505	-	-	base material	
Transverse	390	485	-	-	base material	

82a. BEND TEST: **required**

Type/No.	Bend Angle	Elongation*	Results
Face bend	180	-	acceptable
Face bend	180	-	acceptable
Root bend	180	-	acceptable
Root bend	180	-	acceptable

88. Impact Test*): **required**

Type: **V (VWT; VHT)**

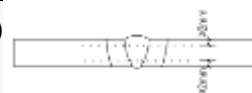
Size:

Requirements:

Notch Location/Direction	Temp. °C	Values			Average	Remarks
		1	2	3		
Weld seam	0	42	40	44	42	
HAZ	0	32	36	35	34.3	
Base material	0	36	37	35	36	

91. Hardness Test* (Type/Load): **acceptable**

Location of Measurements (Sketch*)



92. Type/Load:

HV10 Max 380 HV

93. Parent

Nr.1-200;2-225;3-224;
Nr.1-210;2-233;3-234;

Metal:

94. HAZ:

Nr.4-232;5-228;6-242;7-238;8-235;9-222;
Nr.4-255;5-235;6-252;7-248;8-245;9-235;

95. Weld

metal:

**Nr.10-180;11-184;12-177;13-175;
14-173;15-168**
**Nr.10-177;11-174;12-175;13-176;
14-175;15-166**

96. Other Tests:

97. Remarks:

98. Tests Carried out in accordance with the requirements of standart: **EN ISO 15614-1+A1:2020 Level 2**

99. Laboratory Report Ref. No.: **VT-206-1; CT-206-1; MT-206-1; MP-206-1**

100. Test results were **acceptable/not acceptable**

(Delete as appropriate)

101. Test carried out in

Examiner or examining body:

102. the presence of:

103. * If required

104.

Name, date and signature

