



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.: **1IC - 4506**

Rev. 0

Manufacturer:	LUKYTECH s.r.o.	I No.:	04024478
Adresa:	Sokolovská 2888/9, Předměstí 746 01 Opava, Česká republika		
RANGE OF QUALIFICATION			
Standard:	ČSN EN ISO 15614-1	Level 1 <input checked="" type="checkbox"/>	Level 2 <input checked="" type="checkbox"/>
Addit. requirements:	WPQR No.: 1P- 4506		
Parent Material(s)			
Specification according to standard:		S355MC / 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 - 24,0 mm	D > 500 mm or D > 150 mm for welding in PA position with rotation.	-	No restriction
Welding process(es) (EN ISO 4063)			
Process:	135	Degree of mechanization:	partly mechanized
Deposited metal thickness:		max. 24,0 mm	
Welding positions (EN ISO 6947): all positions except PG, PJ and J-L045			
Type of joint and weld			
Multi run			
Butt joint on plate		T-butt joint	Fillet weld
one-sided	double-sided	one-sided	double-sided
backing	no backing	gouging (mechanically)	no gouging
YES	YES	YES	YES
Butt joint on tube/pipe		Fillet weld	on
one-sided	double-sided	one-sided	double-sided
backing	no backing	gouging (mechanically)	no gouging
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: G42 4 M20 3Si1
B	Shielding Gas	STRAGON C8	EN ISO 14175 - M20
Other welding process specifications			
Weld zone	Welding process	Index FM	Current / polarity
Root	135	A+B	DC/+
Filling runs	135	A+B	DC/+
Welding process information:		135: 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. 200°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: 08.09.2020

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 - 4506

Inspection results apply only to the subject of inspection. This document may be reproduced only as a whole.