



**BUREAU
VERITAS**

MARINE BRANCH

Certificate N°: 5549GDA2019

CERTIFICATE OF APPROVAL OF WELDING PROCEDURE

Manufacturer: POLKONT Sp. z o.o., ul. Stary Rynek 15-21, lok.3,
85 – 105 BYDGOSZCZ

WPQR N°: 5549GDA2019

WPS N°: 135/PK1 rev. 00

Test date: 15.02.2019

RANGE OF APPROVAL

Welding process: 135 (GMAW)

Parent metal acc. ISO/TR 15608: 1.1, 1.2 and 1.4 (S355J2+N – Group 1.2 – Steels with specified minimum yield strength $275\text{N/mm}^2 < R_{eH} \leq 360\text{N/mm}^2$)

Thickness range [mm]: Plate/wall: 1.5 ÷ 6

Welding position: PA (1G, 1F), PB (2F) and PC (2G)

Type of joint: P BW PC, sl

Filler: T-MARS SG2 / G 42 4 C1/M21 3Si1

Heat input [kJ/mm]: 0.26 ÷ 0.44

Preheat temp. [°C] 5°C

Interpass temp. MAX [°C] -

We would like to state hereby that the test pieces were welded and checked according to the requirements of EN ISO 15614-1 (level 2) and the positive results have been achieved.

Date and place of issue:

15.03.2019 GDAŃSK

Surveyor's name, signature and stamp

Jan Dąbkowski



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MARINE BRANCH

Certificate N°: 5550GDA2019

CERTIFICATE OF APPROVAL OF WELDING PROCEDURE

Manufacturer: POLKONT Sp. z o.o., ul. Stary Rynek 15-21, lok.3,
85 – 105 BYDGOSZCZ

WPQR N°: 5550GDA2019

WPS N°: 135/PK2 rev. 00

Test date: 15.02.2019

RANGE OF APPROVAL

Welding process: 135 (GMAW)

**Parent metal acc.
CR ISO 15608:** 1.1, 1.2 and 1.4 (S355J2+N – Group 1.2 – Steels with specified
minimum yield strength $275\text{N/mm}^2 < R_{eH} \leq 360\text{ N/mm}^2$)

Thickness range [mm]: Plate/wall: 1.5 ÷ 6

Welding position: PA (1G, 1F), PB (2F) and PF (3G, 3F)

Type of joint: P BW PF, sl

Filler: T-MARS SG2 / G 42 4 C1/M21 3Si1

Heat input [kJ/mm]: 0.30 ÷ 0.50

Preheat temp. [°C] 5°C

**Interpass temp. MAX
[°C]** -

We would like to state hereby that the test pieces were welded and checked according to the requirements of EN ISO 15614-1 (level 2) and the positive results have been achieved.

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