

WELDING & TESTING LAB

Duly approved by the Govt. of India, NABL as per ISO /IEC 17025: 2017 for mechanical Test of Weld & Parent-Metals

A DIVISION OF 'INSTITUTE OF WELDING & TESTING TECHNOLOGY' DIN EN ISO 9001:2015 CERTIFIED INSTITUTE

An organization for Welding-Consultancy, Training, Inspection & Testing-Services



303/304/305, New Laxmi Industrial Estate Premises Co-operative Society Ltd., Penkar Pada Road, off W. E. Highway, Near Dahisar Cheknaka, Mira Road (East), Village - Mahajanwadi, MBMC, Thane District - 401 107, INDIA.

Tel.: 022 2089 7969 • Mobile: +91 98922 63850 • E-mail: satish.sawant53@gmail.com • Website: www.weldingtesting.org

TEST REPORT

MANUFACTURE: - M/s. VIJAY ENGINEERING WORK	T.R.NO : - TC654422000000117F	
B - 28 , FOCAL POINT EXTENSION,	DATE OF TESTING :- 22.12.2022	
JALANDHAR, PUNJAB - 144004	DATE OF COMPLETION : - 22.12.2022	
WPQR NO. : - VEW ISO 15614 – 1 135 P FW 1.3 t 20.0 PB sl 2022 07	Ref : E-mail or Verbal: - Verbal,- Date: - 14.12.2022	
SIZE: - 20.0 to 20.0 mm Plate	PARENT METAL: - IS 2062	
PURPOSE OF EXAMINATION: - WPS & PQR	CONSUMABLE: - AWS / A 5.18 ER 70 S - 6	
TEST SPECIMEN: - M1 / M2	TEST REPORT IN ACCORDANCE WITH: - EN ISO 17639	
WELDER NAME : - GURWINDERJEET SINGH	WELDING POSITION: - PB	
PUNCH ON JOB: - SAMPLE NO 11	TYPE OF JOINT: - T JOINT	
MACROSCOPIC ETCHANT:- Nitric Acid & Water (25:75) %	POST-WELD HEAT TREATMENT AND OR AGEING TREATMENT:- NA	
SAMPLE DRAWN BY: - CUSTOMER	PERSON AUTHORISING THE REPORT :- SATISH SAWANT	
TESTING: - MACRO	PAGE NO.: - 01 of 01	

MACRO TEST: As per EN ISO 17639:2022

SR.NO.	IMPERFECTIONS	IN ACCORDANCE WITH ISO 6520 - 1 QUALITY LEVEL- B [ISO 5817-2014]	MACRO EXAMINATION WITHOUT ETCHING	MACRO EXAMINATION WITH ETCHING
1	CRACKS	100		NOT FOUND
2	CRATER CRACKS	104	- 11	NOT FOUND
3	SURFACE PORE	2017	- 44	NOT FOUND
4	EXCESS WELD METAL	502 & 503 BW/FW	- /5/6	NOT FOUND
5	INCLUSIONS	300/301/302 & 303	- /	NOT FOUND
6	LACK OF FUSION	401/4011/4012 & 4013	-/	NOT FOUND
7	LACK OF PENETRATION	402	A	NOT FOUND
8	UNDERCUT	5011 & 5012		NOT FOUND
9	EXCESS PENETRATION	504		NOT FOUND
10	POROSITY	2011/12/13 & 14		NOT FOUND

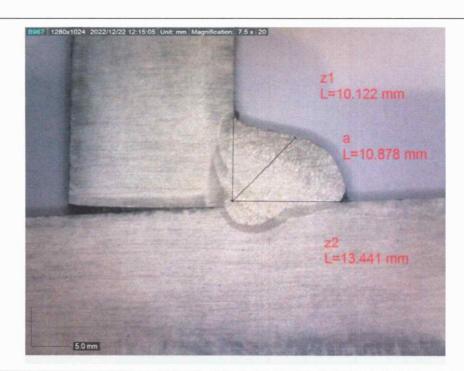
TESTED BY

FOR WELDING & TESTING LAB AUTHORISED SIGNATORY

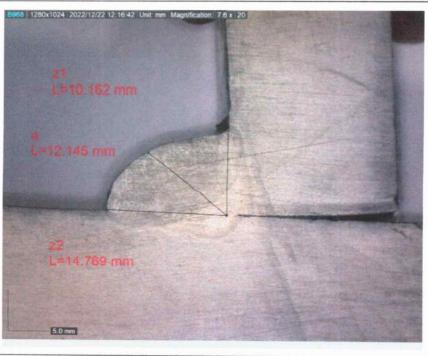
..... End of Report

WPQR NO. :-	T.R.NO :- TC654422000000117F
VEW ISO 15614 - 1 135 P FW 1.3 t 20.0 PB sl 2022 07	DATE OF TESTING :- 22.12.2022
SIZE: - 20.0 to 20.0 mm Plate	PARENT METAL:- IS 2062
WELDER NAME :- GURWINDERJEET SINGH	CONSUMABLE:- AWS / A 5.18 ER 70 S - 6

MACRO PHOTOS



M2



GEOMETRICAL DISCRIPTION

MACRO TEST	z1	z2	a	Р
M1	10.1	13.4	10.8	ROOT FUSION
M2	10.1	14.7	12.1	ROOT FUSION

z1 & z2 = Leg Length	a = Throat	p = Penetration
		p renewation