



# 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 B - 28 , FOCAL POINT EXTENSION, JALANDHAR, PUNJAB - 144004	T.R.NO : - TC6544220000000115F DATE OF TESTING :- 22.12.2022 DATE OF COMPLETION : - 22.12.2022
WPQR NO. : - VEW ISO 15614 - 1 135 P FW 1.3 t 4.5 - 5 PB sl 2022 06	Ref : E-mail or Verbal: - Verbal,- Date: - 14.12.2022
SIZE: - Ø 30.0 thick. 4.5 mm Round Pipe to 5 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 : - RAKESH	WELDING POSITION: - PB
PUNCH ON JOB: - SAMPLE NO. - 9	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	-	NOT FOUND
3	SURFACE PORE	2017	-	NOT FOUND
4	EXCESS WELD METAL	502 & 503 BW/FW	-	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	-	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. :- VIEW ISO 15614 – 1 135 P FW 1.3 t 4.5 - 5 PB sl 2022 06	T.R.NO :- TC6544220000000115F DATE OF TESTING :- 22.12.2022
SIZE: - Ø 30.0 thick. 4.5 mm Round Pipe to 5 mm Plate	PARENT METAL:- IS 2062
WELDER NAME :- RAKESH	CONSUMABLE:- AWS / A 5.18 ER 70 S - 6

MACRO PHOTOS

<b>M1</b>	
<b>M2</b>	

GEOMETRICAL DISCRIPTION

MACRO TEST	z1	z2	a	P
<b>M1</b>	5.9	6.2	4.6	ROOT FUSION
<b>M2</b>	6.0	5.3	4.8	ROOT FUSION

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

IN/IWT/51000396; ASNT-Level III-173702; AWS-02011561