

## Report fracture test fillet weld (FW)

Welder's Name	Sikora Stanislaw Jozef	Test coupon no.	BR-VI478-138-136-CS-PB
Welder's no.	VI478	Welding position	PB
Company	Verwater Tankbouw	Fillematerial	Proces
Certificate no.	A0052719-282	Material thickness (mm)	FM1 / 138-136
Account of breaks	4 pieces (2x 138 en 2x 136)	Test methos acc. to figure	8 mm
Code/Testing Standard:	Fracture test acc. to EN ISO 9017: 2017 / Visual testing acc. to EN ISO 5817:2014		10.3a
	Omschreven in de Verwater instructie voor breekproeven Rev.0		

### Visual inspection after welding:

ISO 6520-1 Ref.no.	Description	Allowed acc. Level B	Conclusion
100	Cracks	Not allowed	Acc
104	Crater crack	Not allowed	Acc
2017	Surface pore	Not allowed	Acc
2025	End crater	Not allowed	Acc
5011	Continous undercut	Not allowed	Acc
5012	Intermittent undercut <sup>level C</sup>	$h \leq 0,1t$ , but max. 0,5 mm	Acc
503	Excessive convexity <sup>level C</sup>	$h \leq 1mm+0,15b$ , but max. 4 mm	Acc
505	Incorrect weld toe	$a \geq 110^\circ$	Acc
512	Asymmetry	$h \leq 1,5 mm+0,15a$	Acc
5213	Insufficient throat thickness	Not allowed	Acc
5214	Excessed throat thickness <sup>level C</sup>	$h \leq 1mm+0,2a$ , but max. 4 mm	Acc
601	Arc strike	Not allowed	Acc
602	Spatter	Depending on corrosion resistance	Acc

### Visual inspection after fracture test:

ISO 6520-1 Ref.no.	Description	Allowed acc. Level B	Conclusion
100	Cracks	Not allowed	Acc
2011	Single gas pore	$d \leq 0,2a$ , but max. 3 mm	Acc
2012	Uniform distr. Pores	Single layer $\leq 1\%$ m, Mmulti-layer $\leq 2\%$	Acc
2013	Clusterd porosity	$\leq 4\%$	Acc
2013	Single pore in cluster	$d \leq 0,2a$ , but max. 2 mm	Acc
2014	Linear porosity	Single layer $\leq 2\%$ , Multi-layer $\leq 4\%$	Acc
2014	Singel pore in cluster	$d \leq 0,2a$ , but max. 2 mm	Acc
2015/2016	Elongated cavity/worn	$h \leq 0,2a$ , max. 2mm, $l \leq a$ , max. 25 mm	Acc
300	Solid inclusion	$h \leq 0,2a$ , max. 2mm, $l \leq a$ , max. 25 mm	Acc
304	Metallic inclusion	$h \leq 0,2a$ but max. 2mm	Acc
3042	Copper inclusion	Not allowed	Acc
401	Lack of fusion	Not allowed	Acc
402	Incomplete penetration	Not allowed	Acc

**Result:** Meets the requirements to EN-ISO-9606-1; 2017 Yes

Method of Identification:

Beoordeeld door: J.Faasse Cert-IWC-S-20200508-10136

VTw-2 cert no.: CERT-VTW2-CV 2021-062



Remarks