VERWATER

Report number: BR-VI478-136-SS-PD-PF

Test date: 27 January 2025

Report fracture test fillet weld (FW)

Welder's Name	**Sikora Stanislaw Jozef**	Test coupon no.		**BR-VI478-136-SS-PD-PF**
Welder's no.	**VI478**	Welding position		**PD/PF**
Company	**Verwater Tankbouw**	Fillematerial	Proces	**FM5 / 136**
Certificate no.	**LK23163EN-VI478 rev.0**	Material thickness (mm)		**8 mm**
Account of breaks	**4 pieces (2x PD/2xPF)**	Test methos acc. to figure		**10.3a**
Code/Testing Standard:	**Fracture test acc. to EN ISO 9017: 2017 / Visual testing acc. to EN ISO 5817:2014**			
	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 level C	h ≤ 0,1t, but max. 0,5 mm	Acc
503	Excessive convexity level C	h ≤ 1mm+0,15b, but max. 4 mm	Acc
505	Incorrect weld toe	a ≥ 110°	Acc
512	Asymmetry	h ≤ 1,5 mm+0,15a	Acc
5213	Insufficient throat thickness	Not allowed	Acc
5214	Excessed throat thickness level C	h ≤ 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 ≤ 0,2a, but max. 3 mm	Acc
2012	Uniform distr. Pores	Single layer ≤ 1%m, Mjulti-layer ≤ 2%	Acc
2013	Clusterd porosity	≤ 4%	Acc
2013	Single pore in cluster	d ≤ 0,2a, but max. 2 mm	Acc
2014	Linear porosity	Single layer ≤ 2%, Multi-layer ≤ 4%	Acc
2014	Singel pore in cluster	d ≤ 0,2a, but max. 2 mm	Acc
2015/2016	Elongated cavity/worn	h ≤ 0,2a, max. 2mm, l ≤ a, max. 25 mm	Acc
300	Solid inclusion	h ≤ 0,2a, max. 2mm, l ≤ a, max. 25 mm	Acc
304	Metallic inclusion	h ≤ 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