



CAVITECH DENİZCİLİK
CAVITECH DENİZCİLİK LTD. ŞTİ.
SERVICE MAINTENANCE ROYAL
www.cavitechdenizcilik.com.tr

WPQR

WPQR No:
CVT-200620-PQR-
04 (PD)

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WELDING PROCEDURE QUALIFICATION RECORD

Shipyards : CAVITECH DENİZCİLİK LTD. ŞTİ.

Address : Site Mah. Atay Cad. New Loca A Blok No:7 K.-1 D.7
34760 Ümraniye - İSTANBUL

Reference : BV Rules on Material and Welding for the Classification of Marine Units,
NR216, Ch 5, Sec 4, Approval of Welding Procedures

Further to the welding of the standardized test pieces carried out in the shipyard at CAVITECH DENİZCİLİK LTD. ŞTİ. on 14.09.2020 in presence of Mr. HAKAN TIRYAKI Bureau Veritas Surveyor,

We certify that shipyard welding procedure detailed in page 2/4 of this record has given satisfactory results in accordance with the requirements of above reference.

Date of Issue: 14.01.2021

Prepared by Shipyards Representative

Name: VOLKAN DEMİRCİ

Signature . CAVITECH DENİZCİLİK LIMITED ŞİRKETİ
Stamp Site Mah. Atay Cad. New Loca A Blok
No:7 K.-1 D.7 Ümraniye / İSTANBUL
Tel : +90 216 303 300 40 08
Alemdag No: 203 030 6007

Endorsed by BV Surveyor

Name:.....

Signature:.....
BV Stamp





CAVITECH DENİZCİLİK
 OYUNCAKLIK YIKIYICI ÇÖZÜMLERİ
 SERVICE MAINTENANCE REPAIR
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1 DETAILS OF WELD TEST

Method of preparation	:GRINDING	Parent material spec	: S355J2+N	Part 1	Part 2
Cleaning	:BRUSHING	Heat Nr	: 73001034 - 73001090		
Joint type	:Fillet weld	Material thickness	: 20 mm	20 mm	

Weld Preparation Details

Joint design	Welding sequences

Welding Details

Run number	1	2-3	4-6				
Welding process	136	136	136				
Welding position	PD	PD	PD				
Autom. Welding							
.nr. of heads	-	-	-				
.weaving	-	-	-				
Filler metal:wire (W) or electrode (E)	W	W	W				
.Designation	MAGMAWELD						
.Grade	A T46 2 P C 1						
.Description	FCW 11 (D300 PRE) (VAC)						
.Diameter	1,2 mm	1,2 mm	1,2 mm				
Shielding:Flux (F) or gas (G)	G	G	G				
.Power flux							
.description	-	-	-				
.type and trade name	-	-	-				
.Gas flux	%100 CO ₂						
.description	GEBZE GAZ						
.type and trade name							
.Backing							
.flow rate (l/mn)	-	-	-				
.Shielding	14						
.flow rate (l/mn)							
.Plasma	-	-	-				
Tungsten electrode: type/size	-	-	-				
Type of current	DC	DC	DC				
Electrode or wire polarity	(+)	(+)	(+)				
Current (A)	220	220	220				
Voltage (V)	28	28	28				
Travel speed S (cm/min)	3,50	3,80	5,00				
Wire feed speed (m/min)	10	10	10				
Heat input (kJ/mm) = [k x V x A x 0,8] / S	1,41	1,30	0,99				
Interpass temperature in °C (min/max)	MIN 230 °C / MAX 250°C						
Welding equipment							
.trade mark							
.type							

Pre heat No Yes

Temperature°C. min 20°C

Holding Time.....

Post heating No Yes

Temperature°C

Holding Time.....

Post Weld Heat treatment No Yes

Temperature°C.....

Holding Time.....

Welder or welding operator ALI ŞAHİN





CAVITECH DENİZCİLİK

CAVITATION RISK CLEANING SOLUTIONS
SERVICE AND MAINTENANCE EXPERTS

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2 TEST RESULTS

2.1

NON-DESTRUCTIVE TESTS	PERFORMED BY	REPORT Nr. / DATE	RESULT
Visual examination	PROBO MUAYENE VE BELGELENDİRME A.Ş.	VT-20-261	Satisfactory
Dye penetrant / Magnetic particle	DEKRA Kalite Kont. Hiz. A. Ş.	PT-20-231	Satisfactory
Radiographic examination	None	None	None
Ultrasonic examination	None	None	None

2.2 TENSILE TESTS

Performed by _____ Report Nr. / DATE: _____
Requirements :

TYPE / Nr.	Re (N / mm ²)	Rm(N / mm ²)	A %	Z %	FRACTURE LOCATION	REMARKS

2.3 BEND TESTS

Performed by _____ Report Nr. / DATE _____

TYPE / Nr.	PUNCH DIA./BEND. ANGLE	SPECIMEN SECTION	RESULT

2.4 IMPACT TESTS

Performed by _____ Report Nr. / DATE _____
Type : _____ Size : _____
Requirements :

SPECIMEN POSITION / NOTCH LOCATION	TEMPERATURE	INDIVIDUAL VALUES			AVERAGE	REMARKS
		1	2	3		

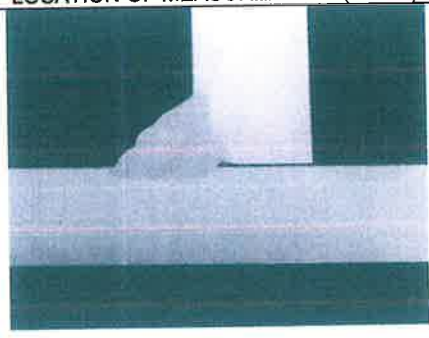


	CAVITECH DENİZCİLİK <small>CAVITATION FREE CLEANING SOLUTIONS SERVICE MAINTENANCE REPAIR</small> www.cavitechdenizcilik.com.tr	<h1>WPQR</h1>	WPQR Nr CVT-200620-PQR-04 (PD) 777ITB20 Page 4 of 4
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2.5 HARDNESS TEST

Performed by.. DEKRA Kalite Kont. Hiz. A. Ş.
Requirements : Bureau Veritas NR 216

Report Nr. / DATE DKR/2020/0627 /01.07.2020

LOCATION OF MEASUREMENTS(sketch)	INDENTATION ROW	RESULTS
	A LINE (BASE MTAL)	191-196-194
	A LINE (ITAB)	236-237-(244-239-237)
	A LINE (WELD METAL)	221-221-229
	ALINE (ITAB)	(230-229-232)-186-200
	A LINE (BASE METAL)	201-196-198

2.6 MACROGRAPHIC EXAMINATION

Performed by.. DEKRA Kalite Kont. Hiz. A. Ş.
Observations : Lack of fusion have not been observed in weld zone, weld zone is homogeneous

Report Nr. / DATE DKR/2020/0627 /01.07.2020

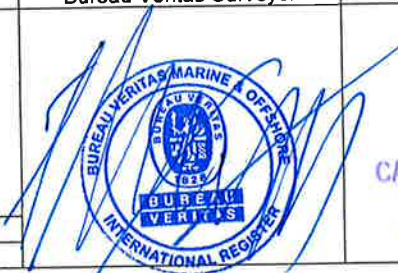


2.7 MICROGRAPHIC EXAMINATION

Performed by.....
Observations :

Report Nr. / DATE.....

2.8 OTHER EXAMINATIONS OR TESTS

.....
.....
.....

Annexed Documents Identification		Name and Signature of Bureau Veritas Surveyor	Name and Signature of Shipyard Representative
Visual Examination Penetrant Examination Hardness test report Macrographic Test Rep. Fracture Test Rep.	VT-20-261 PT-20-245 DKR/2020/0627 DKR/2020/0627 DKR/2020/0627	 	VOLKAN DEMİRCİ  CAVITECH DENİZCİLİK LIMITED ŞİRKETİ Site Mh. Atılım Cd. New Loca A Blok No:7 K:-1 Ümraniye / İSTANBUL Tel: +90 530 300 40 08 Atemdaş V.D.:203 030 6007



CAVITECH DENİZCİLİK

CONTAINER WARE CLEANING SOLUTIONS
SERVICE MAINTENANCE SYSTEM

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WELDING PROCEDURE QUALIFICATION RECORD

Shipyards : CAVITECH DENİZCİLİK LTD. ŞTİ.

Address : Site Mah. Atay Cad. New Loca A Blok No:7 K.-1 D.7
34760 Ümraniye - İSTANBUL

Reference : BV Rules on Material and Welding for the Classification of Marine Units,
NR216, Ch 5, Sec 4, Approval of Welding Procedures

Further to the welding of the standardized test pieces carried out in the shipyard at CAVITECH DENİZCİLİK LTD. ŞTİ. on 14.09.2020 in presence of Mr. HAKAN TİRYAKİ Bureau Veritas Surveyor,

We certify that shipyard welding procedure detailed in page 2/4 of this record has given satisfactory results in accordance with the requirements of above reference.

Date of Issue: 14.01.2021

Prepared by Shipyards Representative

Name: VOLKAN DEMİRCİ

Signature ... CAVITECH DENİZCİLİK LIMITED ŞİRKETİ
Site Mah. Atay Cad. New Loca A Blok
No:7 K.-1 D.7 Ümraniye / İSTANBUL
Tel : 0212 30 300 40 08
Atımdağ Y.D. 203 030 6007

Stamp

Endorsed by BV Surveyor

Name:.....

Signature:.....
BV Stamp





CAVITECH DENİZCİLİK

CAVITATION-FRUIT CLEANING SOLUTIONS
SERVICE MAINTENANCE REPAIR
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1 DETAILS OF WELD TEST

Method of preparation : GRINDING
Cleaning : BRUSHING
Joint type : Fillet weld

Part 1 Part 2
Parent material spec : S355J2+N S355J2+N
Heat Nr : 730010784 - 730010790
Material thickness : 20 mm 20 mm

Weld Preparation Details

Joint design	Welding sequences

Welding Details

Run number	1						
Welding process	136						
Welding position	PD						
Autom. Welding .nr. of heads	-						
.weaving	-						
Filler metal:wire (W) or electrode (E)	W						
.Designation		MAGMAWELD					
.Grade		A T46 2 P C 1					
.Description		FCW 11 (D300 PRE) (VAC)					
.Diameter	1,2 mm						
Shielding:Flux (F) or gas (G)	G						
.Power flux .description	-						
.type and trade name	-						
.Gas flux .description	%100 CO ₂						
.type and trade name	GEBZE						
.Backing .flow rate (l/mn)	-						
.Shielding .flow rate (l/mn)	14						
.Plasma	-						
Tungsten electrode: type/size	-						
Type of current	DC						
Electrode or wire polarity	(+)						
Current (A)	220						
Voltage (V)	28						
Travel speed S (cm/min)	3,50						
Wire feed speed (m/min)	10						
Heat input (kJ/mm) = [k x V x A x 0,8] / S	1,41						
Interpass temperature in °C (min/max)		MIN 230 °C / MAX 250°C					
Welding equipment .trade mark							
.type							

Pre heat No Yes

Temperature°C. min 20°C

Holding Time.....

Post heating No Yes

Temperature°C

Holding Time.....

Post Weld Heat treatment No Yes

Temperature°C.....

Holding Time.....

Welder or welding operator ALI ŞAHİN





CAVITECH DENİZCİLİK
CAVITATION AND CRACKING SOLUTIONS
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2 TEST RESULTS

2.1

NON-DESTRUCTIVE TESTS	PERFORMED BY	REPORT Nr. / DATE	RESULT
Visual examination	PROBO MUAYENE VE BELGELENDİRME A.Ş.	VT-20-262	Satisfactory
Penetrant / Magnetic particle	DEKRA Kalite Kont. Hiz. A. Ş.	PT-20-232	Satisfactory
Radiographic examination	None	None	None
Ultrasonic examination	None	None	None

2.2 TENSILE TESTS

Performed by: Report Nr. / DATE:

Requirements :

TYPE / Nr.	Re (N / mm ²)	Rm(N / mm ²)	A %	Z %	FRACTURE LOCATION	REMARKS

2.3 BEND TESTS

Performed by DEKRA Kalite Kont. Hiz. A. Ş. Report Nr. / DATE

TYPE / Nr.	PUNCH DIA./BEND. ANGLE	SPECIMEN SECTION	RESULT

2.4 IMPACT TESTS

Performed by: Report Nr. / DATE:

Type : Size : Requirements :

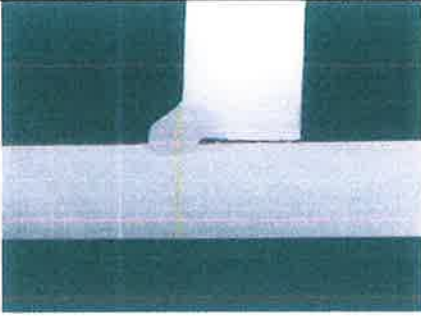
SPECIMEN POSITION / NOTCH LOCATION	TEMPERATURE	INDIVIDUAL VALUES			AVARAGE	REMARKS
		1	2	3		



2.5 HARDNESS TEST

Performed by: DEKRA Kalite Kont. Hiz. A. Ş.
 Requirements : Bureau Veritas NR 216

Report Nr. / DATE DKR/2020/0628 /01.07.2020

LOCATION OF MEASUREMENTS(sketch)	INDENTATION ROW	RESULTS
	A LINE (BASE MTAL)	199-199-201
	A LINE (ITAB)	190-191-(242-246-249)
	A LINE (WELD METAL)	244-241-237
	ALINE (ITAB)	(231-231-223)-185-192
	A LINE (BASE METAL)	190-289-187

2.6 MACROGRAPHIC EXAMINATION

Performed by: DEKRA Kalite Kont. Hiz. A. Ş.
 Observations : Lack of fusion have not been observed in weld zone, weld zone is homogeneous

Report Nr. / DATE DKR/2020/0628 /01.07.2020



2.7 MICROGRAPHIC EXAMINATION

Performed by:
 Observations :

Report Nr. / DATE:.....

2.8 OTHER EXAMINATIONS OR TESTS

.....

Annexed Documents Identification		Name and Signature of Bureau Veritas Surveyor	Name and Signature of Shipyard Representative
Visual Examination Penetrant Examination Hardness test report Macrographic Test Rep. Fracture Test Rep.	VT-20-262 PT-20-245 DKR/2020/0628 DKR/2020/0628 DKR/2020/0628		VOLKAN DEMIRCI 



CAVITECH DENİZCİLİK

CAVITECH DENİZCİLİK LTD. ŞTİ.

SERVICE MAINTENANCE REPAIR

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PQR-06

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WELDING PROCEDURE QUALIFICATION RECORD

Shipyards : CAVITECH DENİZCİLİK LTD. ŞTİ.

Address : Site Mah. Atay Cad. New Loca A Blok No:7 K.-1 D.7
34760 Ümraniye - İSTANBUL

Reference : BV Rules on Material and Welding for the Classification of Marine Units,
NR216, Ch 5, Sec 4, Approval of Welding Procedures

Further to the welding of the standardized test pieces carried out in the shipyard at CAVITECH DENİZCİLİK LTD. ŞTİ. on 14.09.2020 in presence of Mr. HAKAN TIRYAKI Bureau Veritas Surveyor,

We certify that shipyard welding procedure detailed in page 2/4 of this record has given satisfactory results in accordance with the requirements of above reference.

Date of Issue: 14.01.2021

Prepared by Shipyards Representative

Name: VOLKAN DEMİRCİ

Signature : CAVITECH DENİZCİLİK LIMITED ŞİRKETİ
Stamp : Site Mah. Atay Cad. New Loca A Blok
No:7 K:-1 D:7 Ümraniye / İSTANBUL
Tel : +90 30 300 40 08
Atamdag Mah. : 203 030 6007

Endorsed by BV Surveyor

Name:.....

Signature:.....
BY Stamp





CAVITECH DENİZCİLİK
 OXYGEN ARC CLEANING SERVICES
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1 DETAILS OF WELD TEST

Method of preparation	:GRINDING	Parent material spec	: S355J2H	Part1	Part 2
Cleaning	:BRUSHING.	Heat Nr	: 51541 -	51541	S355J2H
Joint type	:V butt joint	Material thickness	: 8 mm	8 mm	8 mm
		Outside diameter	: 88,9mm	88,9 mm	88,9 mm

Weld Preparation Details

Joint design	Welding sequences

Welding Details

	1	2-3	4-5	6-7		
Run number	1	2-3	4-5	6-7		
Welding process	111					
Welding position	H-L045					
Autom. Welding	.nr. of heads	-	-	-	-	
	.weaving	-	-	-	-	
Filler metal: wire (W) or electrode (E)	E					
.Designation	MAGMAWELD					
.Grade	E 42 2 C 21 / E 46 4 B 32 H10					
.Description	E 6010 / E7018-1					
.Diameter	3,25 mm	2,5 mm	2,5 mm	2,5 mm		
Shielding: Flux (F) or gas (G)	-	-	-	-		
.Power flux	.description	-	-	-	-	
	.type and trade name	-	-	-	-	
.Gas flux	.description	-	-	-	-	
	.type and trade name	-	-	-	-	
.Backing	.flow rate (l/mn)	-	-	-	-	
.Shielding	.flow rate (l/mn)	-	-	-	-	
.Plasma		-	-	-	-	
Tungsten electrode: type/size		-	-	-	-	
Type of current	DC					
Electrode or wire polarity	(+) (+)					
Current (A)	70	85	90	90		
Voltage (V)	30	23	23	22		
Travel speed S (cm/min)	0,94	2,18	2,69	2,91		
Wire feed speed (m/min)	-	-	-	-		
Heat input (kJ/mm) = [k x V x A x 0,8] / S	1,79	0,72	0,62	0,54		
Interpass temperature in °C (min/max)	MIN 230 °C / MAX 250°C					
Welding equipment	.trade mark					
	.type					

Pre heat No Yes
 Post heating No Yes
 Post Weld Heat treatment No Yes

Temperature°C. min 20°C

Holding Time.....

Temperature°C

Holding Time.....

Temperature°C.....

Holding Time.....

Welder or welding operator MUSTAFA YILDIRIM



2 TEST RESULTS

2.1

NON-DESTRUCTIVE TESTS	PERFORMED BY	REPORT Nr. / DATE	RESULT
Visual examination	PROBO MUAYENE VE BELGELENDİRME A.Ş.	VT-20-263	Satisfactory
Dye penetrant / Magnetic particle	DEKRA Kalite Kont. Hiz. A. Ş.	PT-20-233 / PT-20-234	Satisfactory
Radiographic examination	DEKRA Kalite Kont. Hiz. A. Ş.	RT-20-541 / RT-20-542	Satisfactory
Ultrasonic examination	None	None	None

2.2 TENSILE TESTS

Performed by DEKRA Kalite Kont. Hiz. A. Ş.
 Requirements : Bureau Veritas NR 216

Report Nr. / DATE: DKR/2020/0629 /01.07.2020

TYPE / Nr.	Re (N / mm ²)	Rm(N / mm ²)	A %	Z %	FRACTURE LOCATION	REMARKS
T1	392,7	579,6	18,9	None	Material	No imperfections
T2	382,3	573,8	10,0	None	Weld	No imperfections

2.3 BEND TESTS

Performed by DEKRA Kalite Kont. Hiz. A. Ş.

Report Nr. / DATE DKR/2020/0629 /01.07.2020

TYPE / Nr.	PUNCH DIA./BEND. ANGLE	SPECIMEN SECTION	RESULT
FB1	32/180	8X32x300	No Crack
FB2	32/180	8X32x300	No Crack
RB1	132/180	8X32x300	Crack L1 = 5,50 mm L2 = 5,40 mm
RB2	32/180	8X32x300	Crack L1 = 7,50 mm
RB1 (RE TEST)	32/180	8X32x300	No Crack
RB2 (RE TEST)	32/180	8X32x300	No Crack
RB3 (RE TEST)	32/180	8X32x300	No Crack
RB4 (RE TEST)	32/180	8X32x300	No Crack

2.4 IMPACT TESTS

Performed by DEKRA Kalite Kont. Hiz. A. Ş.
 Type : V Charpy

Size : 10x10x55 mm

Report Nr. / DATE DKR/2020/0629 /01.07.2020
 Requirements : Bureau Veritas NR 216

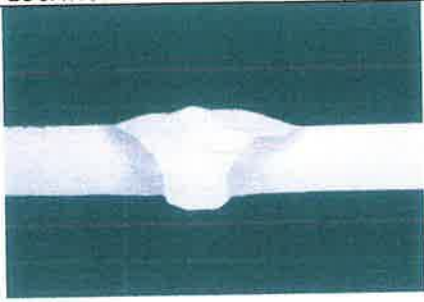
SPECIMEN POSITION / NOTCH LOCATION	TEMPERATURE	INDIVIDUAL VALUES			AVARAGE	REMARKS
		1	2	3		
IT1 IT2 IT3	-20°C	70,59	84,65	91,69	82,31	No imperfections
IT4 IT5 IT6	-20°C	82,19	77,05	78,27	79,17	No imperfections
IT7 IT8 IT9	-20°C	60,88	50,97	68,71	60,18	No imperfections



2.5 HARDNESS TEST

Performed by.. DEKRA Kalite Kont. Hiz. A. Ş.
 Requirements : Bureau Veritas NR 216

Report Nr. / DATE DKR/2020/0629 /01.07.2020

LOCATION OF MEASUREMENTS(sketch)	INDENTATION ROW	RESULTS
	A LINE (BASE METAL)	169-165-165
	A LINE (HAZ)	217-268-(228-235-237)
	A LINE (WELD METAL)	208-215-228
	ALINE (HAZ)	(230-227-225)-248-209
	A LINE (BASE METAL)	171-165-168

2.6 MACROGRAPHIC EXAMINATION

Performed by.. DEKRA Kalite Kont. Hiz. A. Ş.
 Observations : Lack of fusion have not been observed in weld zone, weld zone is homogeneous

Report Nr. / DATE DKR/2020/0629 /01.07.2020



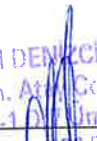
2.7 MICROGRAPHIC EXAMINATION

Performed by.....
 Observations :

Report Nr. / DATE.....

2.8 OTHER EXAMINATIONS OR TESTS

.....

Annexed Documents Identification	Name and Signature of Bureau Veritas Surveyor	Name and Signature of Shipyard Representative																
<table border="0"> <tr> <td>Radiography Examination</td> <td>RT-20-541 / RT-20-542</td> </tr> <tr> <td>Visual Examination</td> <td>VT-20-263</td> </tr> <tr> <td>Penetrant Examination</td> <td>PT-20-233 / PT-20-234</td> </tr> <tr> <td>Bend Test Report</td> <td>DKR/2020/0629</td> </tr> <tr> <td>Tensile Test Report</td> <td>DKR/2020/0629</td> </tr> <tr> <td>Impact test report</td> <td>DKR/2020/0629</td> </tr> <tr> <td>Hardness test report</td> <td>DKR/2020/0629</td> </tr> <tr> <td>Macrographic Test Rep.</td> <td>DKR/2020/0629</td> </tr> </table>	Radiography Examination	RT-20-541 / RT-20-542	Visual Examination	VT-20-263	Penetrant Examination	PT-20-233 / PT-20-234	Bend Test Report	DKR/2020/0629	Tensile Test Report	DKR/2020/0629	Impact test report	DKR/2020/0629	Hardness test report	DKR/2020/0629	Macrographic Test Rep.	DKR/2020/0629	 	<p style="text-align: center;">VOLKAN DEMIRCI</p> <p style="text-align: right;">  CAVITECH DENİZCİLİK LIMITED ŞİRKETİ Site Mh. At. Cd. New Loca A Blok Kat: 7/K-1/100000 İmranlı / İSTANBUL Tel : +90 530 300 40 08 Alameda / D.: 203 030 6007 </p>
Radiography Examination	RT-20-541 / RT-20-542																	
Visual Examination	VT-20-263																	
Penetrant Examination	PT-20-233 / PT-20-234																	
Bend Test Report	DKR/2020/0629																	
Tensile Test Report	DKR/2020/0629																	
Impact test report	DKR/2020/0629																	
Hardness test report	DKR/2020/0629																	
Macrographic Test Rep.	DKR/2020/0629																	



CAVITECH DENİZCİLİK

CAVITATION HULL CLEANING SOLUTIONS
SERVICE MAINTENANCE REPAIR

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WELDING PROCEDURE QUALIFICATION RECORD

Shipyards : CAVITECH DENİZCİLİK LTD. ŞTİ.

Address : Site Mah. Atay Cad. New Loca A Blok No:7 K.-1 D.7
34760 Ümraniye - İSTANBUL

Reference : BV Rules on Material and Welding for the Classification of Marine Units,
NR216, Ch 5, Sec 4, Approval of Welding Procedures

Further to the welding of the standardized test pieces carried out in the shipyard at CAVITECH DENİZCİLİK LTD. ŞTİ. on 14.09.2020 in presence of Mr. HAKAN TIRYAKI Bureau Veritas Surveyor,

We certify that shipyard welding procedure detailed in page 2/4 of this record has given satisfactory results in accordance with the requirements of above reference.

Date of Issue: 14.01.2021

Prepared by Shipyards Representative

Name: VOLKAN DEMİRCİ

Signature
Stamp

CAVITECH DENİZCİLİK LIMITED ŞİRKETİ
Site Mah. Atay Cad. New Loca A Blok
No:7 K:-1 D:7 Ümraniye / İSTANBUL
Tel : +90 530 300 40 08
Alemdag M.D.:203 030 6007

Endorsed by BV Surveyor

Name:.....

Signature:
BV Stamp





CAVITECH DENIZCILIK

CATHODIC WIRE CLEANING SOLUTIONS
SERVICE MAINTENANCE REPAIR

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PQR-01(PF)

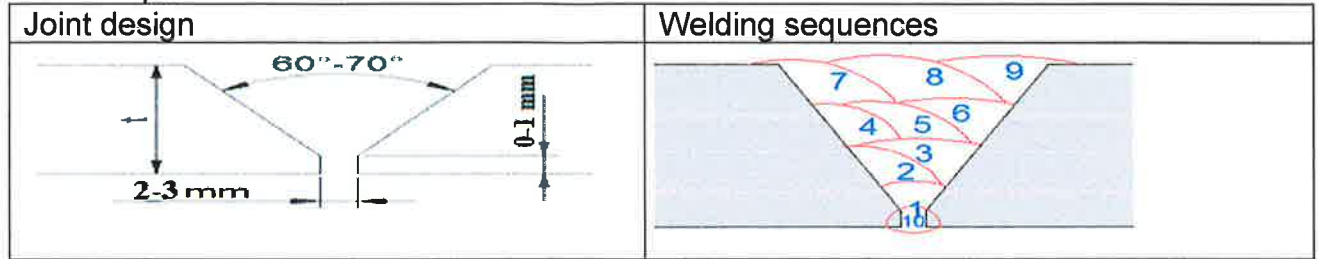
777ITB20
Page 2 of 4

1 DETAILS OF WELD TEST

Method of preparation	:GRINDING	Parent material spec	: S355J2+N	Part 1	Part 2
Cleaning	:BRUSHING	Heat Nr	: 730010034 - 730010818		
Joint type	:V butt joint	Material thickness	: 20 mm	20 mm	

with back gouging

Weld Preparation Details



Welding Details

Run number	1	2-3	4-6	7-9	10
Welding process	136				
Welding position	PF				
Autom. Welding	.nr. of heads	-	-	-	-
	.weaving	-	-	-	-
Filler metal: wire (W) or electrode (E)	(W)				
.Designation	MAGMAWELD				
.Grade	A T46 2 P C 1				
.Description	FCW 11 (D300 PRE) (VAC)				
.Diameter	1,2 mm				
Shielding: Flux (F) or gas (G)	(G)				
.Power flux	.description	-	-	-	-
	.type and trade name	-	-	-	-
.Gas flux	.description	%100 CO ₂			
	.type and trade name	GEBZE GAZ			
.Backing	.flow rate (l/mn)	-	-	-	-
.Shielding	.flow rate (l/mn)	-	-	-	-
.Plasma		-	-	-	-
Tungsten electrode: type/size		-	-	-	-
Type of current	DC				
Electrode or wire polarity	(+) (+)				
Current (A)	140	180	180	160	155
Voltage (V)	20	23	24	23	22
Travel speed S (cm/min)	1,07	2,41	1,65	3,04	3,18
Wire feed speed (m/min)	10	10	10	10	10
Heat input (kJ/mm) = [k x V x A x 0,8] / S	2,09	1,37	2,09	0,97	0,86
Interpass temperature in °C (min/max)	MIN 230 °C / MAX 250°C				
Welding equipment	.trade mark				
	.type				

Pre heat No Yes

Temperature°C. min 20°C

Holding Time.....

Post heating No Yes

Temperature°C

Holding Time.....

Post Weld Heat treatment No Yes

Temperature°C.....

Holding Time.....

Welder or welding operator SERDAR KAYIK





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2 TEST RESULTS

2.1

NON-DESTRUCTIVE TESTS	PERFORMED BY	REPORT Nr. / DATE	RESULT
Visual examination	PROBO MUAYENE VE BELGELENDİRME A.Ş.	VT-20-264	Satisfactory
Dye penetrant / Magnetic particle	DEKRA Kalite Kont. Hiz. A. Ş.	PT-20-244	Satisfactory
Radiographic examination	None	None	None
Ultrasonic examination	DEKRA Kalite Kont. Hiz. A. Ş.	UT-20-154-3	Satisfactory

2.2 TENSILE TESTS

Performed by DEKRA Kalite Kont. Hiz. A. Ş.
Requirements : Bureau Veritas NR 216

Report Nr. / DATE: DKR/2020/0648-1 /01.07.2020

TYPE / Nr.	Re (N / mm ²)	Rm(N / mm ²)	A %	Z %	FRACTURE LOCATION	REMARKS
T1	490,9	574,0	21	None	Material	No imperfections
T2	507,3	582,6	20	None	Material	No imperfections

2.3 BEND TESTS

Performed by DEKRA Kalite Kont. Hiz. A. Ş.

Report Nr. / DATE DKR/2020/0648-1/01.07.2020

TYPE / Nr.	PUNCH DIA./BEND. ANGLE	SPECIMEN SECTION	RESULT
SB1	40/180	20x10x300	No Crack
SB2	40/180	20x10x300	No Crack
SB3	40/180	20x10x300	No Crack
SB4	40/180	20x10x300	No Crack

2.4 IMPACT TESTS

Performed by DEKRA Kalite Kont. Hiz. A. Ş.
Type : V Charpy

Size : 10x10x55 mm

Report Nr. / DATE DKR/2020/0648-1/01.07.2020
Requirements : Bureau Veritas NR 216

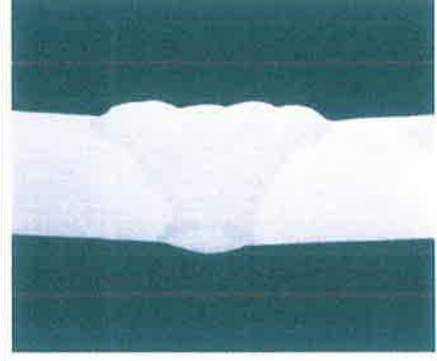
SPECIMEN POSITION / NOTCH LOCATION	TEMPERATURE	INDIVIDUAL VALUES			AVARAGE	REMARKS
		1	2	3		
IT1 IT2 IT3	-20°C	61,33	56,63	63,84	60,60	No imperfections
IT4 IT5 IT6	-20°C	64,99	60,88	96,72	74,19	No imperfections
IT7 IT8 IT9	-20°C	183,28	128,37	215,08	175,57	No imperfections



2.5 HARDNESS TEST

Performed by: DEKRA Kalite Kont. Hiz. A. Ş.
Requierments : Bureau Veritas NR 216

Report Nr. / DATE DKR/2020/0648-1/01.07.2020

LOCATION OF MEASUREMENTS(sketch)	INDENTATION ROW	RESULTS
	A LINE (BASE MTAL)	210-218-212
	A LINE (ITAB)	187-196-(222-225-221)
	A LINE (WELD METAL)	206-229-222
	ALINE (ITAB)	(208-229-234)-186-189
	A LINE (BASE METAL)	199-198-196

2.6 MACROGRAPHIC EXAMINATION

Performed by: DEKRA Kalite Kont. Hiz. A. Ş.
Observations : Lack of fusion have not been observed in weld zone, weld zone is homogeneous

Report Nr. / DATE DKR/2020/0648-1/01.07.2020

2.7 MICROGRAPHIC EXAMINATION


Performed by:

Report Nr. / DATE

Observations :

2.8 OTHER EXAMINATIONS OR TESTS

.....

Annexed Documents Identification	Name and Signature of Bureau Veritas Surveyor	Name and Signature of Shipyard Representative																
<table border="0"> <tr> <td>Ultrasonic Examination</td> <td>UT-20-154-3</td> </tr> <tr> <td>Visual Examination</td> <td>VT-20-264</td> </tr> <tr> <td>Penetrant Examination</td> <td>PT-20-244</td> </tr> <tr> <td>Bend Test Report</td> <td>DKR/2020/0648-1</td> </tr> <tr> <td>Tensile Test Report</td> <td>DKR/2020/0648-1</td> </tr> <tr> <td>Impact test report</td> <td>DKR/2020/0648-1</td> </tr> <tr> <td>Hardness test report</td> <td>DKR/2020/0648-1</td> </tr> <tr> <td>Macrographic Test Rep.</td> <td>DKR/2020/0648-1</td> </tr> </table>	Ultrasonic Examination	UT-20-154-3	Visual Examination	VT-20-264	Penetrant Examination	PT-20-244	Bend Test Report	DKR/2020/0648-1	Tensile Test Report	DKR/2020/0648-1	Impact test report	DKR/2020/0648-1	Hardness test report	DKR/2020/0648-1	Macrographic Test Rep.	DKR/2020/0648-1		<p>VOLKAN DEMİRCİ</p> <p>CAVITECH DENİZCİLİK LIMITED ŞİRKETİ Site Mh. Akay Cd. New Loca A Blok No:7 K:1 Kat:7 Ümraniye / İSTANBUL Tel: +90 216 530 300 40 08 Alemdağ V.D.:203 030 6007</p>
Ultrasonic Examination	UT-20-154-3																	
Visual Examination	VT-20-264																	
Penetrant Examination	PT-20-244																	
Bend Test Report	DKR/2020/0648-1																	
Tensile Test Report	DKR/2020/0648-1																	
Impact test report	DKR/2020/0648-1																	
Hardness test report	DKR/2020/0648-1																	
Macrographic Test Rep.	DKR/2020/0648-1																	



CAVITECH DENİZCİLİK

CAVITECH DENİZCİLİK
SERVICE AUTHORITY
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WELDING PROCEDURE QUALIFICATION RECORD

Shipyards : CAVITECH DENİZCİLİK LTD. ŞTİ.

Address : Site Mah. Atay Cad. New Loca A Blok No:7 K.-1 D.7
34760 Ümraniye - İSTANBUL

Reference : BV Rules on Material and Welding for the Classification of Marine Units,
NR216, Ch 5, Sec 4, Approval of Welding Procedures

Further to the welding of the standardized test pieces carried out in the shipyard at CAVITECH DENİZCİLİK LTD. ŞTİ. on 14.09.2020 in presence of Mr. HAKAN TİRYAKİ Bureau Veritas Surveyor,

We certify that shipyard welding procedure detailed in page 2/4 of this record has given satisfactory results in accordance with the requirements of above reference.

Date of Issue: 14.01.2021

Prepared by Shipyards Representative

Name: VOLKAN DEMİRCİ

Signature
Stamp

CAVITECH DENİZCİLİK LIMITED ŞİRKETİ
Site Mah. Atay Cad. New Loca A Blok
No:7 K:-1 D:7 Ümraniye / İSTANBUL
Tel : +90 530 300 40 08
Alemdağ / No:203 030 6007

Endorsed by BV Surveyor

Name:.....

Signature:.....
BV Stamp





CAVITECH DENİZCİLİK
 CAPTATION-HULL CLEANING SOLUTIONS
 SERVICE MAINTENANCE REPAIR
 www.cavitechdenizcilik.com.tr

WPQR

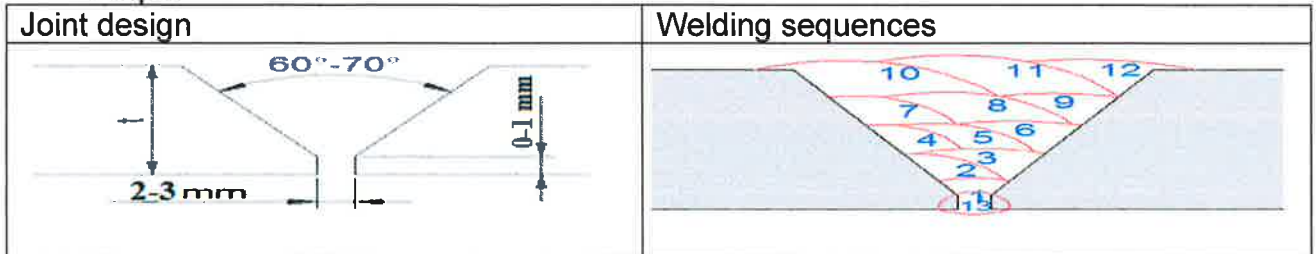
WPQR Nr
 CVT-200620-
 PQR-01(PC)

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1 DETAILS OF WELD TEST

Method of preparation	:GRINDING	Parent material spec	: S355J2+N	Part 1	Part 2
Cleaning	:BRUSHING	Heat Nr	: 730010034 - 7300100784		
Joint type	:V butt joint with back gouging	Material thickness	: 20 mm	20 mm	

Weld Preparation Details



Welding Details

Run number	1	2-3	4-6	7-9	10-12	13
Welding process	136					
Welding position	PC					
Autom. Welding .nr. of heads	-	-	-	-	-	-
.weaving	-	-	-	-	-	-
Filler metal:wire (W) or electrode (E)	W	W	W	W	W	W
.Designation	MAGMAWELD					
.Grade	A T46 2 P C 1					
.Description	FCW 11 (D300 PRE) (VAC)					
.Diameter	1,2 mm	1,2 mm	1,2 mm	1,2 mm	1,2 mm	1,2 mm
Shielding:Flux (F) or gas (G)	G	G	G	G	G	G
.Power flux .description	-	-	-	-	-	-
.type and trade name	-	-	-	-	-	-
.Gas flux .description	%100 CO ₂					
.type and trade name	GEBZE					
.Backing .flow rate (l/mn)	-	-	-	-	-	-
.Shielding .flow rate (l/mn)	14					
.Plasma	-	-	-	-	-	-
Tungsten electrode: type/size	-	-	-	-	-	-
Type of current	DC					
Electrode or wire polarity	(+)					
Current (A)	140	210	210	180	160	150
Voltage (V)	21	28	28	24	23	22
Travel speed S (cm/min)	2,69	5,83	5,83	5,83	5,00	5,00
Wire feed speed (m/min)	8,2	8,4	8,2	8,2	8,4	8,2
Heat input (kJ/mm) = [k x V x A x 0,8] / S	0,87	0,81	0,81	0,59	0,59	0,53
Interpass temperature in °C (min/max)	MIN 230 °C / MAX 250°C					
Welding equipment .trade mark						
.type						

Pre heat No Yes
 Post heating No Yes
 Post Weld Heat treatment No Yes
 Welder or welding operator SERDAR KAYIK

Temperature°C. min 20°C

Holding Time.....

Temperature°C

Holding Time.....

Temperature°C.....

Holding Time.....



2 TEST RESULTS

2.1

NON-DESTRUCTIVE TESTS	PERFORMED BY	REPORT Nr. / DATE	RESULT
Visual examination	PROBO MUAYENE VE BELGELENDİRME A.Ş.	VT-20-265	Satisfactory
Dye penetrant / Magnetic particle	DEKRA Kalite Kont. Hiz. A. Ş.	PT-20-245	Satisfactory
Radiographic examination	None	None	None
Ultrasonic examination	DEKRA Kalite Kont. Hiz. A. Ş.	UT-20-154-4	Satisfactory

2.2 TENSILE TESTS

Performed by DEKRA Kalite Kont. Hiz. A. Ş.
 Requirements :

Report Nr. / DATE: DKR/2020/0648-2/01.07.2020

TYPE / Nr.	Re (N / mm ²)	Rm(N / mm ²)	A %	Z %	FRACTURE LOCATION	REMARKS
T1	492,6	598,8	23,0	None	Material	No imperfections
T2	491,7	593,0	22,0	None	Material	No imperfections

2.3 BEND TESTS

Performed by DEKRA Kalite Kont. Hiz. A. Ş.

Report Nr. / DATE DKR/2020/0648-2/01.07.2020

TYPE / Nr.	PUNCH DIA./BEND. ANGLE	SPECIMEN SECTION	RESULT
SB1	40/180	20x10x300	Crack L1=0,20 mm
SB2	40/180	20x10x300	Crack L1=0,50 mm
SB3	40/180	20x10x300	Crack L1=0,10 mm
SB4	40/180	20x10x300	Crack L1=0,60 mm

2.4 IMPACT TESTS

Performed by DEKRA Kalite Kont. Hiz. A. Ş.
 Type : V Charpy

Size : 10x10x55 mm

Report Nr. / DATE DKR/2020/0648-2/01.07.2020
 Requirements :


SPECIMEN POSITION / NOTCH LOCATION	TEMPERATURE	INDIVIDUAL VALUES			AVERAGE	REMARKS
		1	2	3		
IT1 IT2 IT3	-20°C	110,30	134,28	115,56	120,04	No imperfections
IT4 IT5 IT6	-20°C	139,66	177,23	134,82	150,35	No imperfections
IT7 IT8 IT9	-20°C	141,83	183,81	218,19	181,27	No imperfections



2.5 HARDNESS TEST

Performed by: DEKRA Kalite Kont. Hiz. A. Ş.
Requirements : Bureau Veritas NR 216

Report Nr. / DATE DKR/2020/0648-2/01.07.2020

LOCATION OF MEASUREMENTS(sketch)	INDENTATION ROW	RESULTS
	A LINE (BASE METAL)	195-296-202
	A LINE (HAZ)	196-195-(237-257-259)
	A LINE (WELD METAL)	237-233-216-(295-250-234)
	A LINE (HAZ)	(205-250-234)-188-199
	A LINE (BASE METAL)	199-207-201

2.6 MACROGRAPHIC EXAMINATION

Performed by: DEKRA Kalite Kont. Hiz. A. Ş.
Observations : Lack of fusion have not been observed in weld zone, weld zone is homogeneous.

Report Nr. / DATE DKR/2020/0648-2/01.07.2020


2.7 MICROGRAPHIC EXAMINATION

Performed by:
Observations :

Report Nr. / DATE

2.8 OTHER EXAMINATIONS OR TESTS

.....
.....
.....

Annexed Documents Identification		Name and Signature of Bureau Veritas Surveyor	Name and Signature of Shipyard Representative
Ultrasonic Examination	UT-20-154-4		<p>VOLKAN DEMIRCI</p> <p>CAVITECH DENİZCİLİK LIMITED ŞİRKETİ Site Mh. Ata Cd. New Loca A Blok No:7 K:1 D:1 Umraniye / İSTANBUL Tel : +90 530 300 40 08 Alemdag D.:203 030 6007</p>
Visual Examination	VT-20-265		
Penetrant Examination	PT-20-245		
Bend Test Report	DKR/2020/0648-2		
Tensile Test Report	DKR/2020/0648-2		
Impact test report	DKR/2020/0648-2		
Hardness test report Macrographic Test Rep.	DKR/2020/0648-2 DKR/2020/0648-2		



CAVITECH DENİZCİLİK

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PQR-03(PE)
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WELDING PROCEDURE QUALIFICATION RECORD

Shipyards : CAVITECH DENİZCİLİK LTD. ŞTİ.

Address : Site Mah. Atay Cad. New Loca A Blok No:7 K.-1 D.7
34760 Ümraniye - İSTANBUL

Reference : BV Rules on Material and Welding for the Classification of Marine Units,
NR216, Ch 5, Sec 4, Approval of Welding Procedures

Further to the welding of the standardized test pieces carried out in the shipyard at CAVITECH DENİZCİLİK LTD. ŞTİ. on 14.09.2020 in presence of Mr. HAKAN TIRYAKI Bureau Veritas Surveyor,

We certify that shipyard welding procedure detailed in page 2/4 of this record has given satisfactory results in accordance with the requirements of above reference.

Date of Issue: 14.01.2021

Prepared by Shipyards Representative

Name: VOLKAN DEMİCİ

Signature

Stamp

CAVITECH DENİZCİLİK LIMITED ŞİRKETİ
Site Mah. Atay Cad. New Loca A Blok
No:7 K:-1 D. Ümraniye / İSTANBUL
Tel : +90 216 530 300 40 08
Alemdag Yolu D:203 030 6007

Endorsed by BV Surveyor

Name:.....

Signature:.....

BV Stamp





CAVITECH DENİZCİLİK
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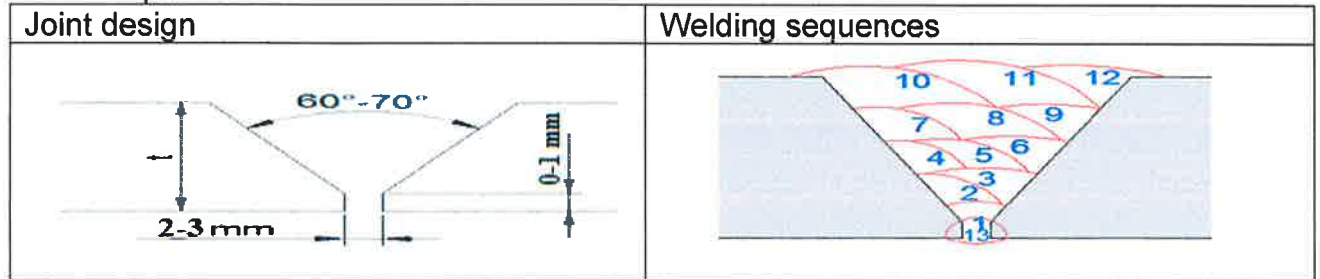
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 PQR-03(PE)
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1 DETAILS OF WELD TEST

Method of preparation	:GRINDING	Parent material spec	: S355J2+N	Part1	Part 2
Cleaning	:BRUSHING	Heat Nr	: 730010783 - 73001784		
Joint type	:V butt joint with back gouging	Material thickness	: 20 mm	20 mm	

Weld Preparation Details



Welding Details

Run number	1	2-3	4-6	7-9	10-12	13
Welding process	111	111	111	111	111	111
Welding position	PE	PE	PE	PE	PE	PE
Autom. Welding .nr. of heads	-	-	-	-	-	-
.weaving	-	-	-	-	-	-
Filler metal:wire (W) or electrode (E)	E	E	E	E	E	E
.Designation	MAGMAWELD					
.Grade	E 46 4 B 32 H10					
.Description	E7018-1					
.Diameter	2,5 mm	2,5 mm	3,25 mm	3,25 mm	3,25 mm	3,25 mm
Shielding:Flux (F) or gas (G)	-	-	-	-	-	-
.Power flux .description	-	-	-	-	-	-
.type and trade name	-	-	-	-	-	-
.Gas flux .description	-	-	-	-	-	-
.type and trade name	-	-	-	-	-	-
.Backing .flow rate (l/mn)	-	-	-	-	-	-
.Shielding .flow rate (l/mn)	-	-	-	-	-	-
.Plasma	-	-	-	-	-	-
Tungsten electrode: type/size	-	-	-	-	-	-
Type of current	DC					
Electrode or wire polarity	(+) (+)					
Current (A)	84	84	86	110	110	100
Voltage (V)	26	26	26	28	28	23
Travel speed S (cm/min)	1,12	1,52	1,75	2,33	2,33	2,18
Wire feed speed (m/min)	-	-	-	-	-	-
Heat input (kJ/mm) = [k x V x A x 0,8] / S	1,56	1,15	1,02	2,33	2,33	0,84
Interpass temperature in °C (min/max)	MIN 230 °C / MAX 250°C					
Welding equipment .trade mark						
.type						

Pre heat No Yes

Temperature°C. min 20°C

Holding Time.....

Post heating No Yes

Temperature°C

Holding Time.....

Post Weld Heat treatment No Yes

Temperature°C.....

Holding Time.....

Welder or welding operator MUSTAFA YILDIRIM





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2 TEST RESULTS

2.1

NON-DESTRUCTIVE TESTS	PERFORMED BY	REPORT Nr. / DATE	RESULT
Visual examination	PROBO MUAYENE VE BELGELENDİRME A.Ş.	VT-20-260	Satisfactory
Dye penetrant / Magnetic particle	DEKRA Kalite Kont. Hiz. A. Ş.	PT-20-260	Satisfactory
Radiographic examination	None	None	None
Ultrasonic examination	DEKRA Kalite Kont. Hiz. A. Ş.	UT-20-164	Satisfactory

2.2 TENSILE TESTS

Performed by DEKRA Kalite Kont. Hiz. A. Ş.

Report Nr. / DATE: DKR/2020/0660/01.07.2020

Requirements :

TYPE / Nr.	Re (N / mm ²)	Rm(N / mm ²)	A %	Z %	FRACTURE LOCATION	REMARKS
T1	484,8	557,8	21,0	None	Material	No imperfections
T2	488,2	560,2	22,,0	None	Material	No imperfections

2.3 BEND TESTS

Performed by DEKRA Kalite Kont. Hiz. A. Ş.

Report Nr. / DATE

DKR/2020/0660/01.07.2020

TYPE / Nr.	PUNCH DIA./BEND. ANGLE	SPECIMEN SECTION	RESULT
SB1	40/180	20x10x300	No Crack
SB2	40/180	20x10x300	No Crack
SB3	40/180	20x10x300	No Crack
SB4	40/180	20x10x300	No Crack

2.4 IMPACT TESTS

Performed by DEKRA Kalite Kont. Hiz. A. Ş.

Report Nr. / DATE

DKR/2020/0660/01.07.2020

Type : V Charpy

Size : 10x10x55 mm

Requirements : Bureau Veritas NR 216

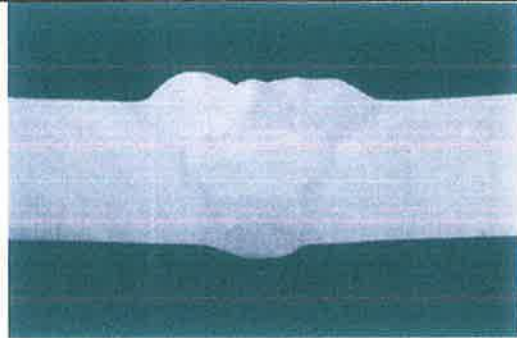
SPECIMEN POSITION / NOTCH LOCATION	TEMPERATURE	INDIVIDUAL VALUES			AVARAGE	REMARKS
		1	2	3		
IT1 IT2 IT3	-20°C	107,66	96,52	118,75	107,64	No imperfections
IT4 IT5 IT6	-20°C	172,20	195,70	217,48	195,12	No imperfections
IT7 IT8 IT9	-20°C	66,84	196,21	203,03	155,36	No imperfections



2.5 HARDNESS TEST

Performed by.. DEKRA Kalite Kont. Hiz. A. Ş.
Requierments :

Report Nr. / DATE DKR/2020/0660/01.07.2020

LOCATION OF MEASUREMENTS(sketch)	INDENTATION ROW	RESULTS
	A LINE (BASE MTAL)	203-197-198
	A LINE (ITAB)	192-171-(187-181-184)
	A LINE (WELD METAL)	191-202-198
	ALINE (ITAB)	(209-217-217)-193-198
	A LINE (BASE METAL)	200-296-205

2.6 MACROGRAPHIC EXAMINATION

Performed by.. DEKRA Kalite Kont. Hiz. A. Ş.
Observations : Lack of fusion have not been observed in weld zone, weld zone is homogeneous

Report Nr. / DATE DKR/2020/0660/01.07.2020



2.7 MICROGRAPHIC EXAMINATION

Performed by.....
Observations :

Report Nr. / DATE.....

2.8 OTHER EXAMINATIONS OR TESTS

.....
.....
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Annexed Documents Identification	Name and Signature of Bureau Veritas Surveyor	Name and Signature of Shipyard Representative
Ultrasonic Examination Visual Examination Penetrant Examination Bend Test Report Tensile Test Report Impact test report Hardness test report Macrographic Test Rep.	UT-20-164 VT-20-260 PT-20-260 DKR/2020/0660 DKR/2020/0660 DKR/2020/0660 DKR/2020/0660 DKR/2020/0660	VOLKAN DEMIRCI   CAVITECH DENİZCİLİK LIMITED ŞİRKETİ Site Mh. Atıf Cd. New Loca A Blok No 7 K.1 D. Katmanlı / İSTANBUL Tel : 0212 530 300 40 08 Alandec. D.:203 030 6097