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**Date:** 2021-04-27  
**Our reference:** A0902497  
**Your reference:**

### Approval letter for welding procedure approval:

The following document is stamped and given the status as shown below

Drawing No.	Rev.	Type	Title	Status
-	-	WPQR	WPQR_141 1.2-34 FW PF 1-3 - DNV Ref A0902497 V3_TD.PDF	Approved

Dear Mr. Düsing,

your WPQR 141 1.2-34 FW PH has been approved in accordance with DNV GL Ru Ship Part 2 Chapter 4 Section 5.13 and DIN EN ISO 15614-6 with following range of approval:

Parameter	Welded	Range of approval
Base Material	S355J2H / CuNi10Fe1MN	S255J2H / W34
Thickness [mm]	5,6 / 2	3-12 / 1-4
Product Form	Tube	Tube
Process	141	141
Gas	I1	I1
Position	PH	all
Seam Type	Fillet weld (FW), ml gb	Fillet weld (FW), ml gb
Built Up	Multilayer	Multilayer
Filler Metal	UTP 387	UTP 387
Current	DC -	DC -
Heat Input [kJ/cm]	17,87 – 22,35	17,87 – 22,35 ±25%
Pre Heating [°C]	10	≥ 10
Max. Interpass Temperature [°C]	120	≤ 120
Post Weld Heat Treatment	--	--

Sincerely  
for DNV GL SE

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