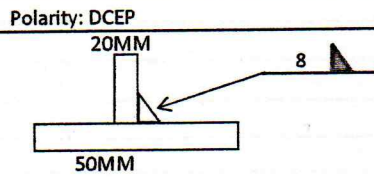


Project: Construction of 6M wide public FOB connecting east and west of Prabhadevi / Parel station across central railway track at Km 07/04-06

Name of Owner: Central Railway  
Record No. : PE/WPQR/MRVC/2023-2024/SAW/001  
Date: 16.10.2024

Name and address of Fabricator: M/s Productive Engineers (I) Pvt. Ltd, Plot-B31, MIDC, Additional Ambarnath, Anand Nagar, Ambarnath  
Welding Procedure Qualification Record ( As per IRS:B1-2001 Appendix-V)

Description of weld joint: Fillet  
Welding procedure specification No: WPSS/AMIL/KKE/PRD/PRL/FOB/SAW-001  
Name of Welder: Shivaji Bachan Singh  
Date of preparation of test piece: 23.09.2024  
Dimensions of test piece: 150X350X20+350X150X50 MM  
Base Metal: IS2062 E250 BR  
Welding Process: SAW  
Welding Position: 1F (Flat)  
Welding Current: DC



12- Weld joint Design details:-

11- Welding Consumables  
11.1 Electrode/Wire: Class: W1 IRSM39  
Dia: 4.0 mm  
Brand: BOND  
11.2- Flux: Class: F1 IRSM39  
Dia: NA  
Brand: BOND  
11.3- Shielding Gas: NA

12- Welding Parameters

Weld pass No.	Electrode wire dia (mm)	Current (amp)	Arc voltage (volt)	Wire feed speed (m/min.)	Travel speed (m/min.)	Electrical stick out (mm)	Shielding gas flow rate (lit/min.)
1	4.00	475-500	28-34	1.4-2.4	0.35-0.45	25-28	NA

13. Preheating and Interpass temperature: Yes

14. Results of Qualification Tests:-

S. No.	TEST	Results
1	Visual Examination	satisfactory
2	Dye penetrant test	satisfactory
3	Macro-examination	Satisfactory (Report No: CT2984 dated 08/10/2024)
4	Fillet weld fracture test	

Note: This WPQR covers for weld thickness from 0.75t to 1.5t

Name: Productive Engineers (I) Pvt. Ltd.

**Project:-** Construction of 6M wide public FOB connecting east and west of Prabhadevi / Parel station across central railway track at Km 07/04-06

**Name of Owner:** Central Railway

Record No. : PE/WPQR/MRVC/2023-2024/GMAW/004

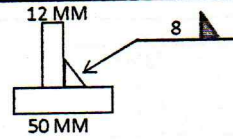
Date: 16.10.2024

**Name and address of Fabricator:** M/s Productive Engineers (I) Pvt. Ltd, Plot-B31, MIDC, Additional Ambarnath, Anand Nagar, Ambarnath  
**Welding Procedure Qualification Record ( As per IRS:B1-2001 Appendix-V)**

- 1- Description of weld joint: Fillet
- 2- Welding procedure specification No: WPSS/AMIL/KKE/PRD/PRL/FOB/GMAW/CO2-004
- 3- Name of Welder: Rajan Kumar Vishwakarma
- 4- Date of preparation of test piece: 23-09-2024
- 5- Dimensions of test piece: 150X350X12+350X150X50MM
- 6- Base Metal: IS2062 E250 BR
- 7- Welding Process: GMAW
- 8- Welding Position: 2F (Horizontal-Vertical)
- 9- Welding Current: DC Polarity: DCEP



10- Weld joint Design details:-



11- Welding Consumables

- 11.1 Electrode/Wire: Class: CLASS 1 IRSM-46  
Dia: 1.2 mm  
Brand: BOND
- 11.2- Flux Class: NA  
Dia: NA  
Brand: NA
- 11.3- Shielding Gas: 100 % CO<sub>2</sub>

12 Welding Parameters

Weld pass No.	Electrode wire dia (mm)	Current (amp)	Arc voltage (volt)	Wire feed speed (m/min.)	Travel speed (mm/min.)	Electrical stick out (mm)	Shielding gas flow rate (lit/min.)
1	1.2	200-375	20-32	4-7	2-3	10-20	12-28
2	1.2	200-375	20-32	4-7	2-3	10-20	12-28
3	1.2	200-375	20-32	4-7	2-3	10-20	12-28

13. Preheating and Interpass temperature: Yes

14. Results of Qualification Test:-

S. No.	TEST	Results
1	Visual Examination	Satisfactory
2	Dye penetrant test	Satisfactory
3	Macro-examination	Satisfactory (Report No: CT1463 dated 08/10/2024)
4	Fillet weld fracture test	

Note: This WPQR covers for weld thickness from 0.75t to 1.5t

Name: Productive Engineers (I) Pvt. Ltd.  
  
 Sign: \_\_\_\_\_

M/s/PEEB

**Project:-** Construction of 6M wide public FOB connecting east and west of Prabhadevi / Parel station across central railway track at Km 07/04-06

**Name of Owner:** Central Railway Record No. : PE/WPQR/MRVC/2023-2024/GMAW/003  
Date: 16.10.2024

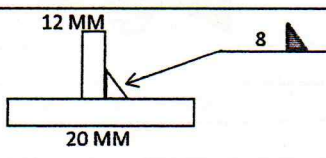
**Name and address of Fabricator:** M/s Productive Engineers (I) Pvt. Ltd, Plot-B31, MIDC, Additional Ambarnath, Anand Nagar, Ambarnath

**Welding Procedure Qualification Record ( As per IRS:B1-2001 Appendix-V)**

1- Description of weld joint: Fillet  
 2- Welding procedure specification No: WPSS/AMIL/KKE/PRD/PRL/FOB/GMAW/CO2-003  
 3- Name of Welder: MAHBOOB ALAM  
 4- Date of preparation of test piece: 23-09-2024  
 5- Dimensions of test piece: 150X350X12+350X150X20MM  
 6- Base Metal: IS2062 E250 BR  
 7- Welding Process: GMAW  
 8- Welding Position: 2F (Horizontal-Vertical)  
 9- Welding Current: DC Polarity: DCEP



10- Weld joint Design details:-



11- Welding Consumables

11.1 Electrode/Wire: Class: CLASS 1 IRSM-46  
Dia: 1.2 mm  
Brand: BOND  
 11.2- Flux Class: NA  
Dia: NA  
Brand: NA  
 11.3- Shielding Gas: 100 % CO<sub>2</sub>

12 Welding Parameters

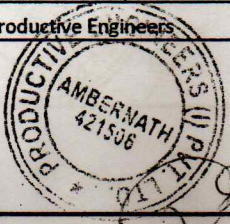

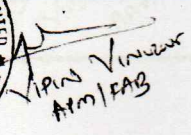
Weld pass No.	Electrode wire dia (mm)	Current (amp)	Arc voltage (volt)	Wire feed speed (m/min.)	Travel speed (mm/min.)	Electrical stick out (mm)	Shielding gas flow rate (lit/min.)
1	1.2	200-375	20-32	4-7	2-3	10-20	12-28
2	1.2	200-375	20-32	4-7	2-3	10-20	12-28
3	1.2	200-375	20-32	4-7	2-3	10-20	12-28

13. Preheating and Interpass temperature: Yes

14. Results of Qualification Test:-

S. No.	TEST	Results
1	Visual Examination	Satisfactory
2	Dye penetrant test	Satisfactory
3	Macro-examination	Satisfactory (Report No: CT1462 dated 08/10/2024)
4	Fillet weld fracture test	

Note: This WPQR covers for weld thickness from 0.75t to 1.5t

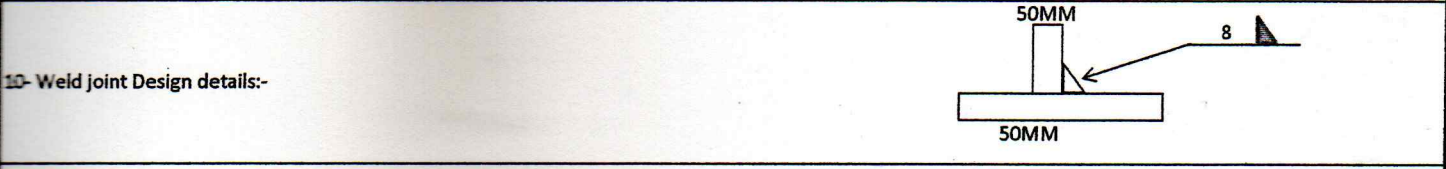
**Name** Productive Engineers 


  
**Sign:** 


**Project:-** Construction of 6M wide public FOB connecting east and west of Prabhadevi / Parel station across central railway track at Km 07/04-06

**Name of Owner:** Central Railway **Record No. : PE/WPQR/MRVC/2023-2024/SAW/002**  
**Date:** 16.10.2024

**Name and address of Fabricator:** M/s Productive Engineers (I) Pvt. Ltd, Plot-B31, MIDC, Additional Ambernath, Anand Nagar, Ambernath  
**Welding Procedure Qualification Record ( As per IRS:B1-2001 Appendix-V)**

- 1- Description of weld joint: Fillet
- 2- Welding procedure specification No: WPSS/AMIL/KKE/PRD/PRL/FOB/SAW-002
- 3- Name of Welder: Gautam Kumar Singh
- 4- Date of preparation of test piece: 23.09.2024
- 5- Dimensions of test piece: 150X350X50+350X150X50 MM
- 6- Base Metal: IS2062 E250 BR
- 7- Welding Process: SAW
- 8- Welding Position: 1F (Flat)
- 9- Welding Current: DC Polarity: DCEP



- 11- Welding Consumables**
- 11.1 Electrode/Wire:** Class: W1 IRSM39  
 Dia: 4.0 mm  
 Brand: BOND
  - 11.2- Flux** Class: F1 IRSM39  
 Dia: NA  
 Brand: BOND
  - 11.3- Shielding Gas:** NA

**12- Welding Parameters**

Weld pass No.	Electrode wire dia (mm)	Current (amp)	Arc voltage (volt)	Wire feed speed (m/min.)	Travel speed (m/min.)	Electrical stick out (mm)	Shielding gas flow rate (lit/min.)
1	4.00	475-500	28-34	1.4-2.4	0.35-0.45	25-28	NA

**13. Preheating and Interpass temperature:** Yes

**14. Results of Qualification Tests:-**

S. No.	TEST	Results
1	Visual Examination	satisfactory
2	Dye penetrant test	satisfactory
3	Macro-examination	Satisfactory (Report No: CT1465 dated 08/10/2024)
4	Fillet weld fracture test	

**Note:** This WPQR covers for weld thickness from 0.75t to 1.5t

**Name:** Productive Engineers

**Sign:**