

|                                                  |                                               |                                            |                                                      |
|--------------------------------------------------|-----------------------------------------------|--------------------------------------------|------------------------------------------------------|
| <b>WPS number</b><br>SPA numeris                 | <b>M-SP6</b>                                  | <b>Customer</b> Užsakovas                  |                                                      |
| <b>WPAR number/</b> SPPP numeris                 | <b>12-120853</b>                              | <b>Method of preparation and</b>           |                                                      |
| <b>Location/Vieta</b>                            | <b>Zariju str. 6, Vilnius</b>                 | <b>cleaning/</b> paruošimo ir valymo       | <b>Mechaninis valymas/ Mechanical cleaning</b>       |
| <b>Manufacturer /</b> Gamintojas                 | <b>UAB „RCP Construction“ (JSC)</b>           | būdas                                      |                                                      |
| <b>Welding process /</b> Suvirinimo procesas     | <b>111</b> LST EN ISO 4063:2023               | <b>Parent metal/Pagrindinė madžiaga</b>    | <b>CR ISO 15608- 1grupe 1.1-1.2</b>                  |
| <b>Root welding process/</b> šaknies suvirinimas | <b>111</b> LST EN ISO 4063:2023               | <b>Specification/Specifikacija</b>         | ---                                                  |
| <b>Type of joint /</b> jungties tipas            | <b>BW/FW</b> , LST EN ISO 17659:2004          | <b>Composition/</b> struktūra              | ---                                                  |
| <b>Preparation /</b> Briaunos paruošimas         | <b>Nr.(3.1.1, 1.9.2)</b> LST EN ISO 9692:2013 | <b>Material thickness/Medžiagos storis</b> | Nuo t=tube BW 3-20mm Iki t2= plate 15-60mm<br>FW>5mm |
| <b>Welding position /</b> Suvirinimo padėtis     | <b>All except PG</b> LST EN ISO 6947:2013     | <b>Outside diameter/Išorinis skersmuo</b>  | Nuo d>=50 Iki                                        |

| Welding details/ Suvirinimo parametrai |                     |                                                                 |                           |                              |                                          |                                                             |                                                     |                         |
|----------------------------------------|---------------------|-----------------------------------------------------------------|---------------------------|------------------------------|------------------------------------------|-------------------------------------------------------------|-----------------------------------------------------|-------------------------|
| Run<br>Ėjimai                          | Process<br>Procesas | Size of filler<br>metal mm<br>Pridėtinio<br>metalo<br>Matmuo mm | Curent<br>(Amps)<br>Srovė | Voltage<br>(Volts)<br>Įtampa | Type of curent<br>polarity<br>Poliškumas | Wire feed<br>speed<br>(m/min)<br>Vielos padavimo<br>greitis | Run-out lenght or travel<br>speed* (mm) or (mm/min) | Heat input*<br>(kJ/mm)* |
| 1                                      | 111                 | d 3,2                                                           | 110-140                   | 23-25                        | DC (+)                                   |                                                             | 110                                                 | 1,2-1,5                 |
| 2-n                                    | 111                 | d 3,2-4,0                                                       | 130-160                   | 23-25                        |                                          |                                                             | 120                                                 | 1,3-1,6                 |

| Other information* /Kita informacija*                              |                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                             |
|--------------------------------------------------------------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <b>Weaving (maximum width of run)/Judėjimas(maksimalus plotis)</b> | ---                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |
| <b>Oscillation:amplitude,frequency,dwell time</b>                  | ---                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |
| /Pulsas:amplitudė, dažnis, pauzes trukmė                           | ---                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |
| <b>Pulse welding details/ Pulsinio režimo parametrai</b>           | ---                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |
| <b>Distance contact tube/work piece/Tūtos eiga/darbinė dalis</b>   | ---                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |
| <b>Plasma welding details/Plazminio suvirinimo parametrai</b>      | ---                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                                         |
| <b>Notes/ Pastabos</b>                                             | <p>1.Kokybės lygmuo pagal EN ISO 5817 (žiūrėti GN dokumentą)/ Quality level according to EN ISO 5817. Follow GN (General notes) document.</p> <p>2. Detalės (atramos) sukabinamos 2 vietose.Sukabinimo ilgis 50 mm, aukštis 0,5 S./Details / supports hung in two places. Coupling the length 50mm, height 0.5 S.</p> <p>3. Suvirinimo lankas uždegamas virinimo zonoje./Welding arc must be started in the provided welding zone.</p> <p>4. Suvirinimo pradžios ir pabaigos persidengia 10...15mm..Suvirinimo pradžia ir pabaiga pašlifuoti. Welding beginning and ends must overlap 10...15mm. Welding beginning and ends must be sanded.</p> <p>5.Suvirinimo medžiagų paruošimas: sausos, be riebalų ar korozijos židinių, Welding material preparation:dry, free of rust or grease.</p> |

**Egzaminier or examinning body / Tikrintojas ar tikrinimo istaiga**

| Name /Vardas    |  | Signature /parašas                                                               |  | Name /Vardas |  | Signature /parašas |  |
|-----------------|--|----------------------------------------------------------------------------------|--|--------------|--|--------------------|--|
| Petras Bulvydas |  |  |  |              |  |                    |  |
| Date /Data      |  |                                                                                  |  | Date /Data   |  |                    |  |
| 2025 01 30      |  |                                                                                  |  |              |  |                    |  |