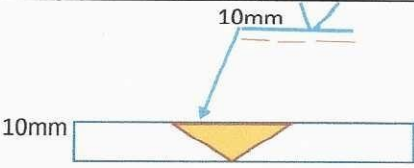
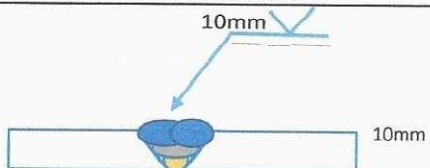
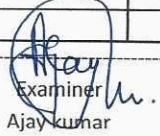


WELDING PROCEDURE SPECIFICATION (WPS)

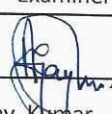
As per ISO 15609-1:2019

Welding procedure specification	JP/WPS/02	Method of preparation and cleaning:	Wire brushing/Grinding					
WPQR No.:	JP/WPQR/02	Parent material specification:	ISO TR 15608: Gr 1.2 (S355J2)					
Manufacturer:	Jayam Precision No.19, Vijayalakshmi layout, Manancherri, Pallavaram Main Road, Kundrathur, Chennai- 600069	Material thickness (mm):	10+10					
Mode of metal transfer	Spray	Outside pipe diameter (mm):	-					
Joint type and weld type:	Butt Joint and Groove weld	Welding Position:	PA					
Weld preparation details (Sketch)*:								
Joint design		Welding sequences						
								
Welding details								
Run	Welding process	Size of filler material	Current A	Voltage V	Type of current / polarity	Wire feed speed, mm/min	Run out length/ Travels speed mm/sec	Heat input*kJ/mm
Root	MAG-135	0.8mm	180 - 220	18 - 22	DCEP	4.0 - 5.0	3.22	1.20
1	MAG-135	0.8mm	200- 250	20 - 25	DCEP	4.2 - 5.5	2.92	1.71
2	MAG-135	0.8mm	200- 250	20 - 25	DCEP	4.2 - 5.5	3.89	1.29
Filler material designation and make:			EN ISO 14341-A, AWS A 5.18 : ER 70S-6 and make: RASI					
Any special baking or drying:			-			Other information, *e.g.:		-
Designation Gas/flux:	Shielding	ISO 14175-M21 (100% CO ₂)				Weaving(maximum width of run):		2-3 mm
	Backing	-						
Gas flow rate:	Shielding	15-18 LPM						-
	Backing	-						
Tungsten electrode type/size:			-			Pulse welding details:		-
Details of back gauging/backing:			-			Distance contact tube/workpiece:		5-8mm
Preheat temperature:			Room Temperature			Plasma welding details:		-
Interpass Temperature:			-			Torch angle:		80°-90°
Post heating			-					
Pre-heat maintenance temperature:			-					
Post-weld heat treatment and or Ageing::			-					
(Time, temperature, method: heating and cooling rates*):			-					
Manufacturer (Name,date and signature)			Date :10-08-2022			 Examiner Ajay Kumar		
*If required			International Welding Technologist (IWT), ISO 9712- L2(VT,PT)					

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 ISO 9712 Level-II (PT)

WELDING PROCEDURE QUALIFICATION RECORD (WPQR)

Welding procedure qualification- Test certificate (ISO 15614-1:2019)

Manufacturer's WPQR no.:	JP/WPQR/02	Examiner
Manufacturer:	Jayam Precision	
Address:	No.19, Vijayalakshmi layout, Manancherri, Pallavaram Main Road, Kundrathur, Chennai- 600069	Ajay Kumar
Code /testing standard:	EN ISO 15614 -1:2019	International Welding Technologist-IWT,ISO 9712-L2(VT,PT)
Level:	2	
Date of welding	02-07-2022	



Particulars	Test piece	Range of Qualification
Test piece		
Product form:	Plate	Plate
Welding process(es):	MAG-135	
	Welding processes used	
	No.1	No.2
Process	MAG-135	-
Deposited metal thickness(mm):		
Type of joint and weld:	Butt Joint and Groove weld	Butt Joint and Groove weld
Parent material group(s) and sub-group(s):	ISO TR 15608: Gr 1.2 (S355J2)	ISO TR 15608: Gr 1.1-1.1& 1.2 -1.2
Parent material thickness (mm):	10.0	3.0 - 20.0
Throat thickness(mm)	-	-
Single layer/multi-run	ml	sl, ml
Outside pipe diameter (mm)	-	-
Filler material designation :	EN ISO 14341-A, AWS A5.18 : ER70S-6	EN ISO 14341-A, AWS A5.18 : ER70S-6
Filler material make:	RASI	Compatible
Filler material size:	0.8	Compatible
Designation of shielding gas/flux:	ISO 14175-C1 (100% CO ₂)	ISO 14175-C1 (100% CO ₂)
Designation of backing gas:	-	-
Type of welding current and polarity:	DCEP	DCEP
Transfer mode:	-	-
Heat input: KJ/mm	1.71	1.71±25%
Welding positions:	PA	All positions except PG and JL045
Preheat temperature:	Room Temperature	Compatible
Interpass Temperature:	-	-
Post heating	-	-
Post-weld heat treatment:	-	-
Other information	-	-

We confirm that the statements in this record are correct and that the test pieces were prepared, welded, tested and have fulfilled the requirements in accordance with ISO 15614-1:2019

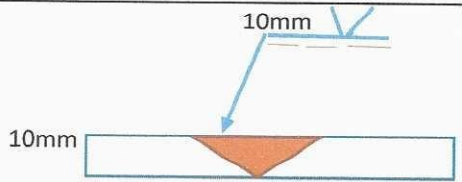
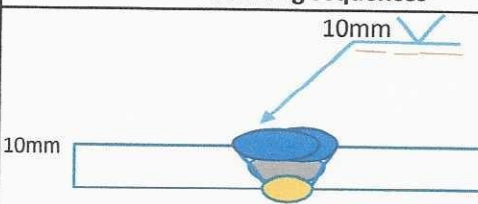
Location	Date of issue	
Chennai	10-08-2022	International Welding Technologist (IWT), ISO 9712- L2(VT,PT)

Ajay Kumar
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 ISO 9712 Level-II (PT)

RECORD OF WELD TEST

Location:	Chennai	Examiner	
Manufacturer's WPS no.:	JP/WPS/02	Ajay Kumar	
Manufacturer's WPQR no.:	JP/WPQR/02	International Welding Technologist (IWT)	
Manufacturer:	Jayam Precision No.19, Vijayalakshmi layout, Manancherri, Pallavaram Main Road, Kundrathur, Chennai- 600069	Method of preparation and cleaning:	Wire brushing/Grinding
Welder's/operator's name:	J. SAKTHIVEL	Parent material specification:	ISO TR 15608: Gr 1.2 (S355J2)
Joint type and weld:	Butt Joint and Groove weld	Material thickness (mm):	10+10
		Outside pipe diameter (mm):	-
		Welding Position:	PA

Weld preparation details (Sketch)*:

Joint design 	Welding sequences 
--	--

Welding details

Run	Welding process	Size of filler material	Current A	Voltage V	Type of current / polarity	Wire feed speed, metre/min	Run out length/ Travels speed mm/sec	Heat input*, KJ/mm
1	MIG-135	0.8mm	130-140	22-24	DCEP	-	1.60	1.68
Filler material designation and make:			EN ISO 14341-A, AWS A 5.18 : ER 70S-6 and make: RASI CO2					
Any special baking or drying:			-			Other information, *e.g.:		-
Gas/flux- shielding			ISO 14175-M21 (100% CO2)			Weaving(maximum width of run):		3 mm
Backing:			-			Oscillation: amplitude, frequency, dwell time		-
Gas flow rate- shielding			18 LPM			Pulse welding details:		-
Backing:			-			Distance contact tube/workpiece:		5 mm
Tungsten electrode type/size:			-			Plasma welding details:		-
Details of back gauging/backing:			-			Torch angle:		85°
Preheat temperature:			ambient shop floor temperature					
Interpass Temperature:			-					
Post heating			-					
Post-weld heat treatment(PWHT):			-					
(Time, temperature, method):			-					
heating and cooling rates*):			-					

Manufacturer
(Name, date and signature)

Date: 02-07-2022

Examiner

Ajay Kumar

*If required

International Welding Technologist (IWT), ISO 9712- L2(VT,PT)

Ajay Kumar
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 ISO 9712 Level-II (PT)

TEST RESULTS

Manufacturer's WPQR no.:	JP/WPQR/02	Examiner
Visual:	JP/VT-PT - 02	 Ajay Kumar
Penetrant/magnetic particle testing*:	JP/VT-PT - 02	
Radiographic testing*		International Welding Technologist-IWT, ISO 9712-L2(PT)
Ultrasonic testing*	NA	
Temperature :	NA	

Tensile Tests:

Type/no.	Re (Mpa)	UTS,Rm(Mpa)	A % on	Z %	Fracture location	Remarks
T1	-	522	-	-	Base	Satisfactory
T2	-	524	-	-	Base	Satisfactory

Bend Test:

			Former diameter : 4T
Type/no.	Bend angle	Elongation*	Results
Face Bend, FB-1	180	-	Satisfactory
Face Bend, FB-2	180	-	Satisfactory
Root Bend, RB-1	180	-	Satisfactory
Root Bend, RB-2	180	-	Satisfactory

Macroscopic examination

[illegible]

Impact test*:

Type:		Size:10x7.5			Requirements:27J	
Notch Location/direction	Temp ° C	Values			Average	Remarks
		1	2	3		
Base Metal	-20	132	122	120	125	Satisfactory
HAZ	-20	148	150	142	147	Satisfactory
Weld	-20	166	158	170	165	Satisfactory

Hardness Test*(type/load): HV10		Satisfactory
Parent metal:		124, 134, 132
HAZ:		159, 166, 170
Weld metal:		198, 202, 190
Other tests:	---	
Remarks:	---	
Tests carried out in accordance with the requirements of		ISO 15614-1: 2019
Laboratory report reference no.:		Mentioned in respective place
Test results were acceptable/not acceptable		Acceptable
Test carried out in the presence of		Examiner

* If required

Ajay kumar

International Welding Technologist (IWT), ISO 9712- L2(VT, PT)

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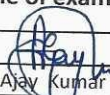
WELDER'S QUALIFICATION TEST CERTIFICATE

WELDER'S CERTIFICATE (As per ISO 9606-1:2017)

Designation (s):	ISO 9606-1 135 P BW FM1 S t10.0 PA ss nb ml		
WPS - Reference :	JP/WPS/02	Examiner	
Welder's name:	J. SAKTHIVEL		
Identification	JP/WPQ/02	Ajay Kumar	
Method of identification:	ID Card	International Welding Technologist	
Employer:	Jayam Precision No.19, Vijayalakshmi layout, Manancherri, Pallavaram Main Road, Kundrathur, Chennai- 600069	Ajay Kumar B.E (Metallurgy), M.Tech (NDT) IIW Certified-International Welding Technologist (Diploma No: IN/IWT/51500785) ASNT Level-II (RT,UT,MT,PT&VT) ISO 9712 Level-II (PT)	
Code /testing standard:	ISO 9606-1 :2017		
Job knowledge:	Acceptable		
Date of welding	02-07-2022		



	Test Piece	Range of Qualification
Welding process(es):	MAG-135	MAG-135
Transfer mode	Spray Mode	Spray Mode
Product type (plate or pipe)	Plate- P	Plate- P
Type of weld:	Butt Joint and Groove weld	Butt Joint and Groove weld
Parent material group(s)	ISO TR 15608: Gr 1.2 (S355J2)	Equivalent
Filler material group(s)	FM1	FM1, FM2
Filler material (Designation)	EN ISO 14341-A, AWS A5.18 : ER70S-6	EN ISO 14341-A, AWS A5.18 : ER70S-6
Shielding gas	ISO 14175-M21 (100% CO2)	ISO 14175-M21 (100% CO2)
Auxiliaries	-	-
Type of current and polarity	DCEP	DCEP
Material thickness (mm)	10.0	3.0 - 20.0
Deposited thickness (mm)	-	-
Outside pipe diameter (mm)	-	-
Welding position	PA	PA
Weld details	ss nb	ssnb, ssmb, bs, ssgb, ssfb
Multi layer / single layer	ml	sl, ml

Type of test		Performed and accepted		Not Tested	Name of examiner	
Visual testing		Yes		-	 Ajay Kumar International Welding Technologist-IWT, Ajay Kumar B.E (Metallurgy), M.Tech (NDT) IIW Certified-International Welding Technologist (Diploma No: IN/IWT/51500785) ASNT Level-II (RT,UT,MT,PT&VT) ISO 9712 Level II (PT)	
Radiography testing		-		Yes		
Fracture test		-		Yes		
Bend test		Yes		-		
Notch tensile testing		-		Yes		
Macroscopic examination		-		Yes		
Place :	Chennai	Date of issue:	31.05.2022			
Revalidation		Valid until	Revalidation	Valid until	Revalidation	Valid until
		-	9.3 b)	02-07-2024	9.2	02-01-2023

WELDER'S QUALIFICATION TEST CERTIFICATE

WELDER'S CERTIFICATE (As per ISO 9606-1:2017)

Designation (s):	ISO 9606-1 135 P BW FM1 S t10.0 PA ss nb ml		
WPS - Reference :	JP/WPS/02	Examiner	
Welder's name:	J. SAKTHIVEL		
Identification	JP/WPQ/02	Ajay Kumar	
Method of identification:	ID Card	International Welding Technologist	
Employer:	Jayam Precision No.19, Vijayalakshmi layout, Manancherri, Pallavaram Main Road, Kundrathur, Chennai- 600069		
Code /testing standard:	ISO 9606-1 :2017	Ajay Kumar B.E (Metallurgy), M.Tech (NDT) IIW Certified-International Welding Technologist (Diploma No: IN/IWT/51500785) ASNT Level II (RT,UT,MT,PT&VT) ISO 9712 Level-II (PT)	
Job knowledge:	Acceptable		
Date of welding	02-07-2022		

Revalidation for qualification by examiner for the following 2 years (refer 9.3b)

Confirmation of the validity by examiner for the following 6 months [refer 9.2]

Date	Signature	Position or title
02-01-2023	Ajay kumar	Examiner
02-07-2023	Ajay kumar	Examiner
02-01-2024	Ajay kumar	Examiner
02-07-2024	Ajay kumar	Examiner



Ajay Kumar
B.E (Metallurgy), M.Tech (NDT)
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(Diploma No: IN/IWT/51500785)
ASNT Level II (RT,UT,MT,PT&VT)
ISO 9712 Level-II (PT)

VISUAL TEST (VT) AND PENETRANT TEST (PT) REPORT

Company Name JAYAM PRECISION No.19, Vijayalakshmi layout, Manancherri, Pallavaram Main Road, Kundarthur, Chennai- 600069		VT/PT Report No.: JP/VT-PT/02	
Job Description/Weld Coupon details Butt joint - Groove weld		Welder's Name : J. SAKTHIVEL	
Date of Inspection 04-07-2022		WPS NO. JP/WPS/02	
VT:ACCEPTANCE STANDARD ISO 5817: Level -B : Quality Levels for Imperfections; PT: Prepared according to - ISO 3452-1			
Sl.No	Imperfection	Ref No.	NDT Inspections remarks
1	Crack surface	ISO 6520-1	VT
2	Crater Crack	1.1 100	OK
3	Internal Crack	1.2 104	OK
4	Macro Cracks	2.1 100	--
5	Haz Crack	2.2 1001	--
6	Toe Crack	1.1 100	--
7	Surface Porosity	1.1 100	OK
8	Root Porosity	1.3 2017	OK
9	Gas Pore Internal	1.18 516	--
10	Internal Uniformly Porosity	2.3 2011	--
11	Internal Clustered	2.3 2012	--
12	Linear Porosity	2.4 2013	--
13	Elongated Cavity	2.5 2014	OK
14	Worm Holes	2.6 2015	--
15	End Crater	2.6 2016	--
16	Crater Pipe Internal	1.4 2025	OK
17	Lack of Fusion	2.8 2024	--
18	Micro Lack of Fusion	1.5 401	--
19	Incomplete Fusion	1.5 401	--
20	Lack of Side Wall Fusion	2.12 401	--
21	Lack of Inter run Fusion	2.12 4012	--
22	Lack of Root Fusion	2.12 4013	--
23	Incomplete Root Penetration	1.6 4021	--
24	Lack of Penetration	2.13 402	--
25	Continuous Undercut	1.7 5011	OK
26	Intermittent Undercut	1.7 5012	OK

Sl.no	Imperfection	Ref No.	NDT Inspections remarks
27	Shrinkage Groove	ISO 6520-1	VT
28	Shrinkage Cavity	1.8 5013	--
29	Excess weld Metal	2.7 202	--
30	Excessive convexity fillet weld	1.9 502	OK
31	Excess Penetration	1.10 503	OK
32	Incorrect weld Toe	1.11 504	--
33	Overlap	1.12 505	--
34	Sagging	1.13 506	--
35	Incompletely Fillet Groove-Underfill	1.14 509	--
36	Burn through	1.14 511	OK
37	Unequal Leg Length	1.15 510	OK
38	Root Concavity	1.16 512	--
39	Poor restart	1.17 515	--
40	Insufficient Throat	1.19 517	OK
41	Excessive Throat	1.20 5213	OK
42	Stray Arc	1.21 5214	OK
43	Splatter	1.22 601	--
44	Solid Inclusions	1.23 602	OK
a	Copper Inclusions	2.9 300	--
b	Metallic Inclusions other than copper	2.11 3042	--
45	Slag Inclusions	2.10 304	--
46	Flux Inclusions	2.9 301	--
47	Oxide Inclusions	2.9 302	--
48	Linear Misalignment	2.9 303	--
49	Angular Misalignment	3.1 507	--
50	Incorrect root Gap (fillet)	3.2 508	--
		3.3 617	OK

Test Result:- Acceptable ☒ Not Acceptable ☐
Inspected By Ajay Kumar
Ajay Kumar

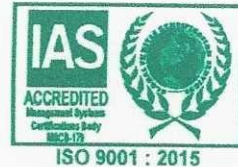


JAI INSPECTION AGENCIES

ISO/ IEC 17025 : 2017 Accredited by NABL

An ISO 9001 : 2015 Organization

(Specialists in X-ray, IR-192 & Co-60 Gamma-ray Radiography, Ultrasonic Inspection, Thickness Gauging, Dye Penetrant Test, Magnetic Particle Test and Stress Relieving)



APPROVED BY: AERB, IIR, BHEL, IRS, DMDE, DGQA, ISRO, VSSC, LPSC, IGCAR, NTPC, NPCIL, EIL, LLOYDS, BV, TPL, TVS, L & T QUEST, HSB

APPROVED BY VENDOR: FOR ASME CERTIFICATION : "PP" STAMP "S" STAMP "U" STAMP

Web : jaiinspectionagencies.com

21, Natesan Nagar, Ayanambakkam, Chennai - 600 095

Phone : 72009 29966

E-mail : jai_ndt@yahoo.com, jai_ndt@jaiinspectionagencies.com

Cell : 94443 76055

RADIOGRAPHIC INSPECTION REPORT

M/s. Jayam Precision No.19, Vijayalakshmi Layout Manancheri, Pallavaram Main Road, Kundrathur, Chennai - 600 069.		Report No. JIA / JP / 001 / G		
		Report Dated : 03.08.2022		
S.F.D	: 20"	Film :	: AGFA D7	
Source	: Ir - 192	Thickness	: 10mm.	
Strength	: 20.00Ci.	Density	: 2 - 3	
Technique	: S W S I	Sensitivity	: 2 - 2T	
Penetrameter	: 10 F E EN	Procedure Spcn.	: EN ISO 17636 - 1	
Lead Screens	: 0.1mm, 0.15mm	Acceptance Std.	: EN ISO 10675-1. EN ISO 5817-B.	
Sl. No.	Description	Segment	Size	Remarks
1	MS - 10 - Tk10mm.	A - B	4 x 16"	Por. - Not Acceptable

NOTE : POR. - POROSITY

for JAI INSPECTION AGENCIES,

T. SARAVANAN
RT.MT.UT. PT-Level-II



BUREAU VERITAS
Certification No.
Ind18.7533U/Q



Chemical & Metallurgical Services

T.S.No.63,A SIDCO Industrial Estate, Ekkaduthangal, Chennai - 600 032, Tamilnadu, INDIA.
Phone : 91-44-2225 3863, 044 - 2225 2944, Mobile : 9445067918
E-Mail : cmslab81@gmail.com / Website : www.cmslab.org



TC-5039

TEST CERTIFICATE

Page: 1 of 3

Test Report No. : CMS/ULR-TC503922000002360F Report Date : 03-08-2022
Party's Name & Address : M/s. Jayam Precision
No. 19, Vijayalakshmi Layout, Manancherri, Pallavaram Main Road,
Kundrathur, Chennai-600069.
Party's Ref : Letter Dated. 02-08-2022.
No. of Samples : 1No Date of Receipt of Sample : 03-08-2022
Nature of Test : Mechanical Test Date of Testing : 03-08-2022
Test Method : EN ISO 4136, EN ISO 5173
Enclosures : Nil

TEST RESULTS

Sample Details

Welding Test
Material Grade: MS S355J2

Welding Process	Thickness	Type of Joint	Welding Position	WPS No.	Welder ID.	Welder Name
MAG-135	10 mm	BW	PA	JP/WPS/02	JP/WPQ/02	J. Sakthivel

MECHANICAL PROPERTIES

Test	Result	Requirement as per Spec. MS 35J2
Tensile Strength (N/mm ²)		
T1	522.875	470-630 MPa
T2	524.384	
Remarks:- The sample was Broken outside the weld.		
Bend test	Observation:	Requirement as per Spec. EN ISO 15614-1-2019
FB-1	No any cracks, No Open	Should be Free from cracks, Open discontinuities, Lack of fusion, No Slag inclusion & No other defect.
FB-2	discontinuities, No Lack of fusion,	
RB-3	No Slag inclusion observed.	
RB-4	Remarks:- Satisfactory	

Remarks:- The above sample conforms to EN ISO 15614-1-2019 in respect to the tested Mechanical Properties.

****END****



Sanjay Kumar Sahu
(Lab. In-charge)
Authorised Signatory

Recognised & Approved Laboratory by Airports Authority of India Ltd., • Steel Authority of India Ltd., • Rail India Technical & Economic Services Ltd.,
• Defence Establishments, • National & International Third Party Inspection Agencies & Many other State & Central Government Establishments.

Note:- This report relates only to the particular Sample submitted for test • Any correction not attested shall invalidate this certificate • Sample will be destroyed after 15 days from the date of issue of certificate unless instructed otherwise • Any complaints about this report should be communicated in writing within 7 days of the issue of this report • This report should not be reproduced wholly or in parts and cannot be used as evidence in a court of law and shall not be used in advertising media without prior permission in writing • Sample descriptions is not verified in all case and is given as described by the customers Samples are not drawn by us unless otherwise stated. • Marks are not covered under NABL scope.

Scope of NABL Accreditation:- Chemical Analysis of Metals & alloys - spectro & Wet analysis. Metallography. Mechanical Tests, Corrosion Tests, Paint testing, Compression test of Concrete cubes, Bricks. Springs. Physical Testing of Rubber, etc.,



BUREAU VERITAS
Certification No.
Ind18.7533U/Q



Chemical & Metallurgical Services

T.B.No.63A BIDCO Industrial Estate, Ekkattukuppam, Chennai - 600 032, Tamilnadu, INDIA.
Phone : 91-44-2226 3863, 044 - 2226 2044, Mobile : 9446067918
E-Mail : cmslab81@gmail.com / Website : www.cmslab.org



TEST CERTIFICATE

Page: 2 of 3

Test Report No. : CMS/ULR-TC/5039220000023601/ Report Date : 03-08-2022
Party's Name & Address : M/s. Jayam Preelason
No. 19, VJhayalakulam Layout, Mannacheri, Pullavaram Main Road,
Kundrathur, Chennai-600069.
Party's Ref : Letter Dated, 02-08-2022.
No. of Samples : 1 No Date of Receipt of Sample : 03-08-2022
Nature of Test : Mechanical Test Date of Testing : 03-08-2022
Test Method : ISO 9015-1
Enclosures : Nil

TEST RESULTS

Sample Details

Welding Test
Material Grade: MS S355J2

Welding Process	Thickness	Type of Joint	Welding Position	WPS No.	Welder ID.	Welder Name
MAG-135	10 mm	BW	PA	JP/WPS/02	JP/WPQ/02	J. Sakthivel

MECHANICAL PROPERTIES

Test	Result			Requirement
Impact test Impact Charpy 'V' Notch at Room Temperature at -20 °C sub size (10x7.5mm)	At Weld metal	At HAZ	At Bare metal	27 Joules min
	166 Joules	148 Joules	132 Joules	
	158 Joules	150 Joules	122 Joules	
	170 Joules	142 Joules	120 Joules	
Average:	164.6 Joules	146.6 Joules	124.6 Joules	

Hardness test

Hardness HV 10 kg	At weld metal	At HAZ	At Bare metal	Requirement
	198, 202, 190 = 196.6 Average	159, 166, 170 = 165.0 Average	124, 134, 132 = 130 Average	380 HV max

Remarks:- The above sample conforms to EN ISO 15614-1:2019 grade in respect to the tested Mechanical Properties.

*****END*****



Sanjay Kumar Sahu
(Lab. Incharge)
Authorised Signatory

Recognised & Approved Laboratory by Airports Authority of India Ltd., • Steel Authority of India Ltd., • Rail India Technical & Economic Services Ltd.,
• Defence Establishments, • National & International Third Party Inspection Agencies & Many other State & Central Government Establishments.

Note:- This report relates only to the particular Sample submitted for test. Any correction not attended shall invalidate this certificate. Sample will be destroyed after 15 days from the date of issue of certificate unless instructed otherwise. Any complaints about this report should be communicated in writing within 7 days of the issue of this report. This report should not be reproduced wholly or in parts and cannot be used as evidence in a court of law and shall not be used in advertising media without prior permission in writing. Sample descriptions is not verified in all cases and is given as described by the customers. Samples are not drawn by us unless otherwise stated. # Marks are not covered under NABL scope.

Scope of NABL Accreditation:- Chemical Analysis of Metals & alloys - spectro & Wet analysis, Metallography, Mechanical Tests, Corrosion Tests, Paint testing, Compression test of Concrete cubes, Bricks, Springs, Physical Testing of Rubber, etc.,



BUREAU VERITAS
Certification No.
Ind18.7533U/Q



Chemical & Metallurgical Services

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Phone : 91-44-2225 3863, 044 - 2225 2944, Mobile : 9445067918
E-Mail : cmslab81@gmail.com / Website : www.cmslab.org



TC-5039

TEST CERTIFICATE

Page: 3 of 3

Test Report No. : CMS/ULR-TC503922000002360F
Party's Name & Address : M/s. Jayam Precision
No. 19, Vijayalakshmi Layout, Manancherri, Pallavaram Main Road,
Kundrathur, Chennai-600069.
Party's Ref : Letter Dated. 02-08-2022.
No. of Samples : 1Nos.
Nature of Test : Macro Test
Test Method : ISO 17639
Enclosures : Nil

Report Date : 03-08-2022
Date of Receipt of Sample : 03-08-2022
Date of Testing : 03-08-2022

TEST RESULTS

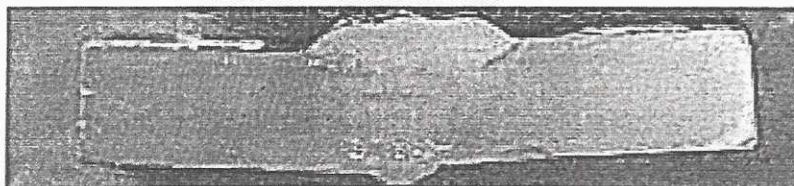
Sample Details

Welding Test

Welding Process	Thickness	Type of Joint	Welding Position	WPS No.	Welder ID.	Welder Name
MAG-135	10 mm	BW	PA	JP/WPS/02	JP/WPQ/02	M.SAKTHIVEL

Material Grade: MS S355J2

Macro Examination



Test	Result	Requirement as per EN ISO 15614-1-2019
Macro Examination:	The weld metal & HAZ surface shows free from cracks & complete fusion. Remarks:- Passes the test	Etchant: HCL+H2O Visual Examination of the cross section of the weld metal & HAZ shall show (i) Free from cracks (ii) Complete fusion

Remarks:- The above sample conforms to EN ISO 15614-1-2019 in respect to the tested Mechanical Properties.

****END****



Sanjay Kumar Sahu
(Lab - Incharge)
Authorised Signatory

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