



PQA

PROJECT QUALITY ASSURANCE



NICON INDUSTRIES A/S

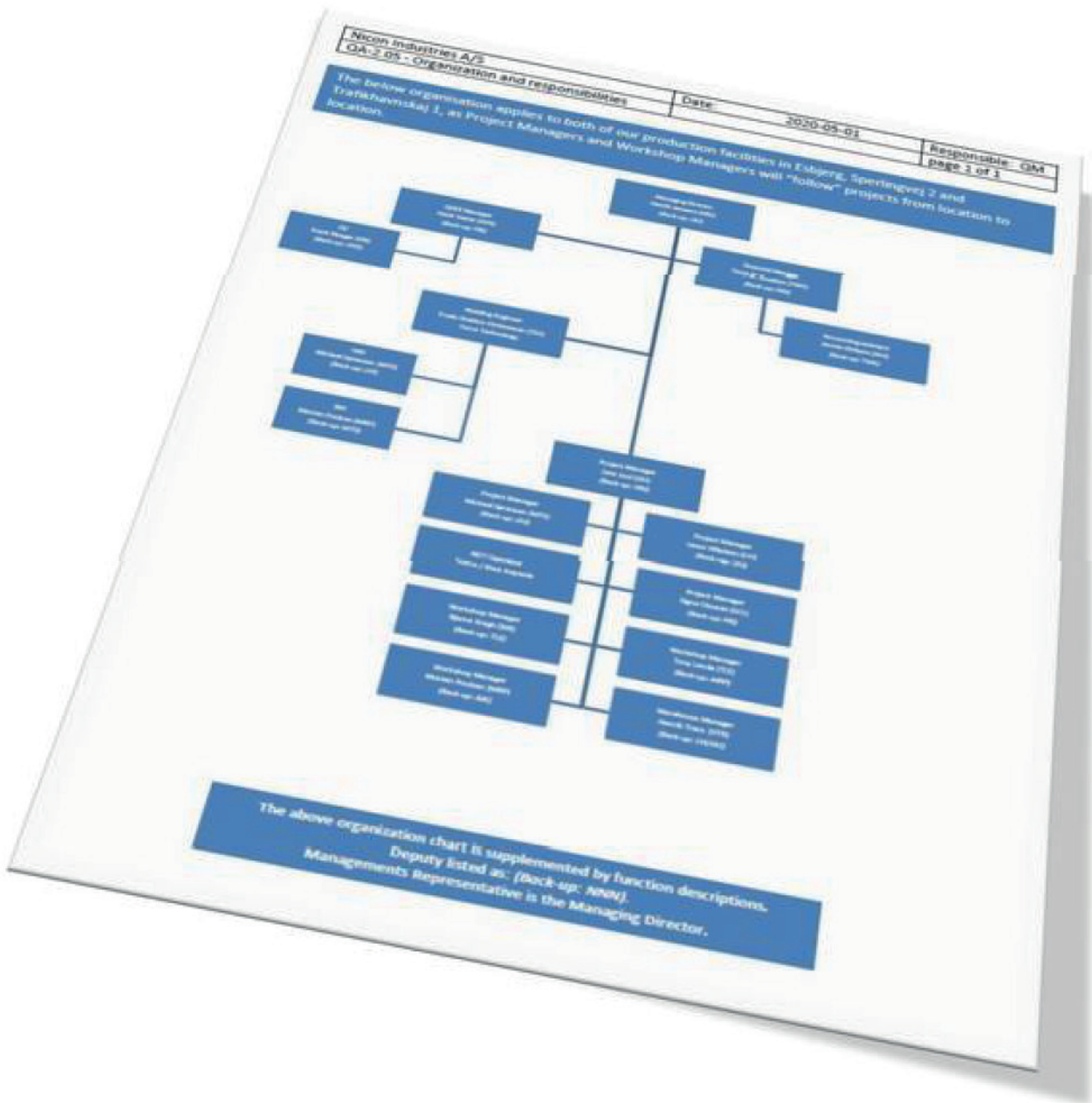
www.nicon-industries.com · +45 9623 0012

quality on time

QUALITY MANAGEMENT CERTIFICATES



PROJECT ORGANIZATION



PROJECT RELATED INSTRUCTIONS

09.04.2019
 -date: 01.12.2018

029173

CE

NICON INDUSTRIES
quality on time

Project Name: 3192500 - HLF

Material OVERVIEW - PLATES

Nicon ID no.	Material	Sequential No.	Plate Thickness	Heat no.	File name
HLF-4	1	1-8	10 mm	273939 8480	28401
HLF-10	1	1-2	12 mm	V84523 8196	30321
HLF-3	1	1-4	20 mm	17403728 WL13561120	29172
HLF-5	1	1-4	30 mm	285498 8289	30349
HLF-6	1	1-4	30 mm	285498 8289	30349
HLF-7	1	1-4	30 mm	285498 8289	30349
HLF-9	1	1-22	30 mm	285498 8289	30349
HLF-11	1	1-4	30 mm	285498 8289	30349
HLF-12	1	1-4	30 mm	285498 8289	30349
HLF-15	1	1-4	30 mm	285498 8289	30349
HLF-16	1	1-4	30 mm	285498 8289	30349
HLF-17-1	1	1-2	30 mm	1993 6131	30349
HLF-18	1	1-4	30 mm	1993 6131	30349
HLF-19	1	1-4	30 mm	1993 6131	30349
HLF-20	1	1-4	30 mm	1993 6131	30349
HLF-8	1	1-4	30 mm	285498 8289	30929
HLF-13	1	1-4	30 mm	285498 8289	30929
HLF-14	1	1-4	30 mm	V85555 8635	30349
HLF-1	1	1-2	80 mm	17303878 WL4521000G	30827
HLF-2	1	1-2	100 mm	236422 50757	29173
			100 mm	236422 50757	15232
					15232

Rev. No.: 1

Registration:
 The tolerance checks on our products/orders are registered in the project folder on the fileserver.

INSPECTION AND TEST PLAN

NICON INDUSTRIES
quality on time

Inspection and test plan

Item	Description	Inspection	Test	Remarks
1	Material	✓	✓	
2	Dimensions	✓	✓	
3	Surface	✓	✓	
4	Heat treatment	✓	✓	
5	Mechanical properties	✓	✓	
6	Chemical composition	✓	✓	
7	Welding	✓	✓	
8	Paint	✓	✓	
9	Assembly	✓	✓	
10	Final inspection	✓	✓	

MATERIAL CERTIFICATES


MATERIAL CERTIFICATES - PLATES

[illegible]

MATERIAL CERTIFICATES - PROFILES

[illegible]

MATERIAL CERTIFICATES - WELDING WIRES

INSPECTION CERTIFICATE													
Order No				ELGA Order No									
Product Elgacore DWA 55L 1,2 SKG PSP				Specification AWS/ASME SFA 5.29: E 81T1-K2M ISO 17632-A: T 46 6 1,5Ni P M 1 H5				Inspection certificate according to EN 10204 3.1					
Batch No AV0243				Data sheet rev. 13									
Part No 95612112													
All-weld metal chemical composition, wt. %. For solid wires; wire analysis													
C	Si	Mn	P	S	Cr	Ni	Mo	Cu	V	Nb			
0,070	0,34	1,22	0,005	0,010	0,01	1,50	0,01	0,02	0,02	0,010			
Mechanical properties - All-weld metal													
Yield Strength, MPa	Tensile Strength, MPa	Elongation, AS%	Impact value average, J	Test temp, °C									
587	648	23	113	-60									
<p>We hereby certify that the material described above has been tested and complies with the terms of the order contract.</p> <p>Mechanical properties from actual testing.</p> <p><i>Lisa Eriksson</i> Lisa Eriksson, QC Manager DATE: 110615</p>													

WELDING WIRES - DECLARATION OF CONFORMITY

VERIFICATION STATEMENT

This is to verify:
That the Flux Cored Wire/Gas combination
with trade name
ELGACORE DWA 55L/H21
Distributed by
Eiga AB
PARTILE, Sweden
is found to comply with
Det Norske Veritas' Rules for Classification PT.2
with this approval

Grade
Current
Approved diameter
Positions
Remarks

V Y40MS(H5)
DC(+)
1.0 mm - 1.2 mm
All
Also for NV 2-4 and NV 4-4

This Statement is valid until 2019-08-09.
Issued at Høvik on 2015-08-10
DNV GL local station: Gothenburg
Approval Engineer: Maxim Bobrov

For DNV GL
Hanne Anita Hjerpetjønn
Head of Section

This Verification Statement is valid provided the manufacturer's approval is maintained.

Form code: WELD 1428
© DNV GL 2014. DNV GL and the Norton Graphic are trademarks of DNV GL AS.

Revision: 2015-04
www.dnvgl.com

Page 1 of 1

MATERIAL CERTIFICATES - BOLTS

Inspection Certificate according to EN 10204-3.1

Customer: BECO
Country: Germany
Order Number: 170256585-30.1
Supplier No: 88450
Norm/Drawing No: ISO 4032
Size: M42
Quantity: 2 621 MPCs
Marking: B-8

Report No.
Report Date
Part No.

Material reference:
TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS	REVISION	DATE
8845025	250	M42 X 100mm HEXAGON BOLT GRADE 8.8 DIN 913			

IMPACT TEST

ITEM	TEMP	RESULTS	REVISION	DATE
8845025	-20 °C	100.00 J		

CHEMICAL ANALYSIS

C	SI	S	P	Mn	AL	NI	MO	CU	AS	SE	OTHER
0.0008	0.3500	0.0050	0.0120	0.8100	0.0700	0.0004	0.0000	0.0000	0.0000	0.0000	

Signature: M. Tongue, Technical Director
Signed on behalf of ALCA Fasteners Limited

Signature: Brian Feng
Signed on behalf of WURTH INDUSTRY DENMARK

Comments for supplier specified - please use page 2 and change print area in excel

Decision customer: customers remarks

TO: WURTH INDUSTRY DENMARK
DACHSER DANMARK
VENUSVEJ 32
DK-6000
KOLDING
DENMARK

OUR INVOICE NO 154618

DATE 16-03-18
YOUR ORDER NO 85927606
TEST CERTIFICATE NO. X224

TEST CERT TO EN10204 3.1

ITEM	QTY	DESCRIPTION	REMARKS
------	-----	-------------	---------

MATERIAL CERTIFICATES - LIFTING EQUIPMENT



Peter Hanco A/S
Christies 4
6700 Esbjerg
DK

Test certifikat / Test certificate
Type 3.1 - according to EN 10204

- This certificate is valid for 12 months from the date of issue and is not valid for re-use.
- All test results are valid for 12 months from the date of issue.

Order No.:
UGL 5.12452

Customer order No.:
UGL 5.12452

To the buyer's production department or laboratory manager:
We hereby declare that the following details for the supplied articles:

Certificate No.: 16-000000000-116
Date: 20-07-2019
Customer Ref.: 16-0000000-1

Reference to standard:
EN 10204

Order particulars:

Production, ref.:
UGL 5.12452

Customer reference:
None

Sampling site:
I.A.

Customer location:

Drawing/Technical reference or Mark	Description of goods	Number	Date	Technical factor	WLL kg	MOL kg
16-0000000-116	SHACKLE WLL 12 TON DLR	1	20-07-2019	VISUAL	1200000	600000

CERTEX A/S
Quality department

Therese Højgaard
Certified signatory

Order Certificate or Inspection Certificate is a communication tool EN 10204 (Table 1) is only valid when understood.
This Certificate only provided by purchase and is not without signature of manufacturer with EN 10204 (page 1)





CERTEX Peter Hanco A/S
Christies 4
6700 Esbjerg
Tel.: +45 75 12 45 21
Fax: +45 75 12 45 22
E-mail: salg@certex.dk
www.certex.dk

WPS AND WPQR

[illegible]

[illegible]

Report No.: 110-20500		Our ref.: Auth./test		Date: 03. 05. 2019	
Report Customer: NICON Industries A/S		Certificate: Customer: Site of Examination: FORCE Technology			
Order: = Consultant: =					



NICON INDUSTRIES A/S
quality and care
 EN15614-1, Norsok M101 &
 DNV-QS-C401

Welding Procedure test

WPQR No. NI 37

Object (Dimension, Base material, Process):
 Plate thickness 34 mm
 Unalloyed steel Gr. 1.2
 Process 138 - 136



WELDERS CERTIFICATE

ZERTIFIKAT • CERTIFICATE • CERTIFICADO • CERTIFICAT

Schweißer-Zertifikat



Industrie Service

2. Bescheinigung:

4. WPS-Besug: **ISO 9606-1 135/136 T BW FM3 M/P s5.0/13 D114 H-L045 ss ab**

6. Bezug-Nr. (falls verfügbar):

7. Name des Schweißers: **KONNLEWISCH, Michael**

8. Art der Legierung: **R202011170**

9. Gütezeichen und -art: **Prüfung**

10. Ausgabedatum: **1982-08-20 in Vergangenheit**

11. Versuchs-/Prüfnummer: **DIN EN ISO 9606-1 135/136 T BW FM3 M/P s5.0/13 D114 H-L045 ss ab**

12. Bescheinigung: **ISO 9606-1 135/136 T BW FM3 M/P s5.0/13 D114 H-L045 ss ab**

13. Fachkunde: **ja**

14. Schweißprozess(e): **135-D**

15. Produkt(e) (Werkstoff): **136 (MAG)-D**

16. Material: **T, Rohr**

17. Werkstoffgruppe(n): **FM3**

18. Schweißzusatz(e) (Stoff): **1.7300 (S.2)**

19. Befugnisse: **FM3**

20. Prüfverfahren: **T CMa1 M M 1 (36)**

21. Werkstoff und Prüfung: **M21**

22. Schweißgeschwindigkeit (mm): **FM3**

23. Schweißgeschwindigkeit (mm): **T CMa2 P M 1 (P)**

24. Schweißgeschwindigkeit (mm): **M21**

25. Schweißgeschwindigkeit (mm): **FM3**

26. Schweißgeschwindigkeit (mm): **M21**

27. Zusätzliche Hinweise: **ss ab**

Prüfungsort	Ausgeführt und bestanden	nicht geprüft	
28. Sichtprüfung	X		
29. Durchstrahlungsprüfung			
30. FE-Prüfung			
31. Mäus- / Makroschicht			
32. Bruchprüfung			
33. Biegeprüfung			
34. Zusatzprüfungen*			
35. *) falls notwendig, Angaben auf Zusatzblatt			

36. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

Datum	Unterschrift	Dienststellung oder Titel
14/3-19	<i>Sgn. W.</i>	Stälmester
14/4-19	<i>Sgn. W.</i>	Stälmester
14/3-2020	<i>Heidi Vester</i>	Stälmester

37. Datum der praktischen Prüfung:

Gültigkeitsdatum bis:

14.09.2018

2021-09-13

38. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

Datum	Unterschrift	Dienststellung oder Titel

39. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

Datum	Unterschrift	Dienststellung oder Titel

40. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

Datum	Unterschrift	Dienststellung oder Titel

41. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

Datum	Unterschrift	Dienststellung oder Titel

42. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

Datum	Unterschrift	Dienststellung oder Titel

43. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

Datum	Unterschrift	Dienststellung oder Titel

44. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

Datum	Unterschrift	Dienststellung oder Titel

45. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

Datum	Unterschrift	Dienststellung oder Titel

46. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

Datum	Unterschrift	Dienststellung oder Titel

47. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

Datum	Unterschrift	Dienststellung oder Titel

48. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

Datum	Unterschrift	Dienststellung oder Titel

49. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

Datum	Unterschrift	Dienststellung oder Titel

50. Nach 9.3a. Bestätigung der Gültigkeit durch Schweißfachperson /

Prüfer / Prüfstelle für die folgenden 6 Monate (unter Bezug auf 9.2)

WELDING LOG

[illegible]

NON DESTRUCTIVE TESTING (NDT)

[illegible]

NDT REPORTS

Report No.: 202002 of date: 19-02-2020

FORCE Test No.: 107-2337.0070.0001

Test Report - Non-destructive Testing

CUSTOMER
Nicon Industries Edding A/S, Sønderborg 2, 6750 Edding, Denmark.

CONTRACT
Løse Materialer tilskud, Nicon Industries Edding A/S, Sønderborg 2, 6750 Edding, Denmark.

END USER
Nicon Industries Edding A/S, Sønderborg 2, 6750 Edding, Denmark.

WORKPLACE
Nicon Industries Edding A/S, Sønderborg 2, 6750 Edding, Denmark.

REQUESTION ID:
31200

Inspection Description
Testing for manufacturing defects.

Summary
Objects, tested immediately*

Specific Job Information
A.122A
Manufacturing for Service 152
Order Code: 3149100
Drawing No. 3249100-01 (01-A) Partially penetrated and test

* Available to follow the activity - NDT test results and evaluations under the batch fulfill the quality requirements. The documentation defines the batch. Following it will not be possible to refer to the specific order object and the placement of batch.

NDT Method
Visual (VT)
Magnetic Particle (MT)

Test Specification
EN ISO 17617:2015
EN ISO 17618:2015

TEST RESULT
Object Status
Acceptance criteria fulfilled

Acceptance Criteria	Procedure
EN ISO 17617:2015 - B	
EN ISO 17618:2015 - 20	

Details of the test results can be found in the "TEST RESULT DETAILS" section

Claus Thomsen
Digitally signed by Claus Thomsen
2020-02-19
signature.dh
NDT Inspector (signature)

2 objects

Technical details: NDT information, equipment identification, equipment calibration date and other relevant data, are recorded for each NDT method in the Test Method Details section. This report is only valid when presented in its full length. The electronic version of the Test Report, as specified in "FORCE NDT Charter" is defined as the original. The Test results apply only to the specific tested FORCE Technology - General Conditions in an integral part of our services, unless otherwise by written agreement.

Page 5 of 5 (incl. enclosed pages)

FORCE Technology • NDT Services • Østergade 7 • DK-6715 Sønder N • +45 4327 1650

NDT SURVEYORS CERTIFICATE

EN ISO 9712
NORDTEST
NDT LEVEL 2 CERTIFICATE
Test method: Ultrasonic Testing

Claus Skovby Thomsen
Rundbrygvej 27, 4500 Græst, Denmark
Date of birth: 1978-02-14

Number: 1618-N2-U
Date of first issue: 2015-06-09
Date of renewal: 2015-06-09
Date of expiry: 2020-06-09

The certificate holder fulfills all requirements of EN ISO 9712 and NORDTEST DOC GEN 010, edition 6.

Sector: **Welds + wp. Wrought products**
Supplemental sector: **Up Tubes and Pipes**
Sector limitation: **No limitations**

Initial certification body: **FORCE Certification**
The certificate is valid only with the operating authorization which is based on visual survey and proof of satisfactory work with the actual NDT method, without interruptions totally not more than 1 year, for the whole validity period. The documentation file of the certificate holder shall also include complaints within the scope of the certification competences. The operating authorization shall be renewed annually.

Operating authorization by employee:

Date	Signature	Force Technology Esbjerg	NTD no. DK-006
2015-06-09	Bo Bossen	2015-06-11	
2016-06-09		2016-06-09	
2017-06-09		2017-06-09	
2018-06-09		2018-06-09	
2019-06-09		2019-06-09	
2020-06-09		2020-06-09	

From DANAK's registry of accredited and approved companies

NDT FORCE TECHNOLOGY DANAK ACCREDITATION

DANAK
30 Accreditation for testing

Company: **FORCE Technology**
Inspektions og Prøvning
Park Allé 345
DK-2605 Brøndby
Granted 01 Oct 1976

Contact: Bo Bossen
Phone: +45 26 70 00
Email: bb@force.dk
Homepage: www.force.dk
Expires 31 Dec 2019
Status: **Accredited**

Scope of Accreditation

Testing:
Product:
- Machinery and industrial plants
Test Type:
- Non destructive testing
- Other Tests

The laboratory is accredited for a flexible scope regarding test methods.
List of methods: [Click here](#)

Extended Information

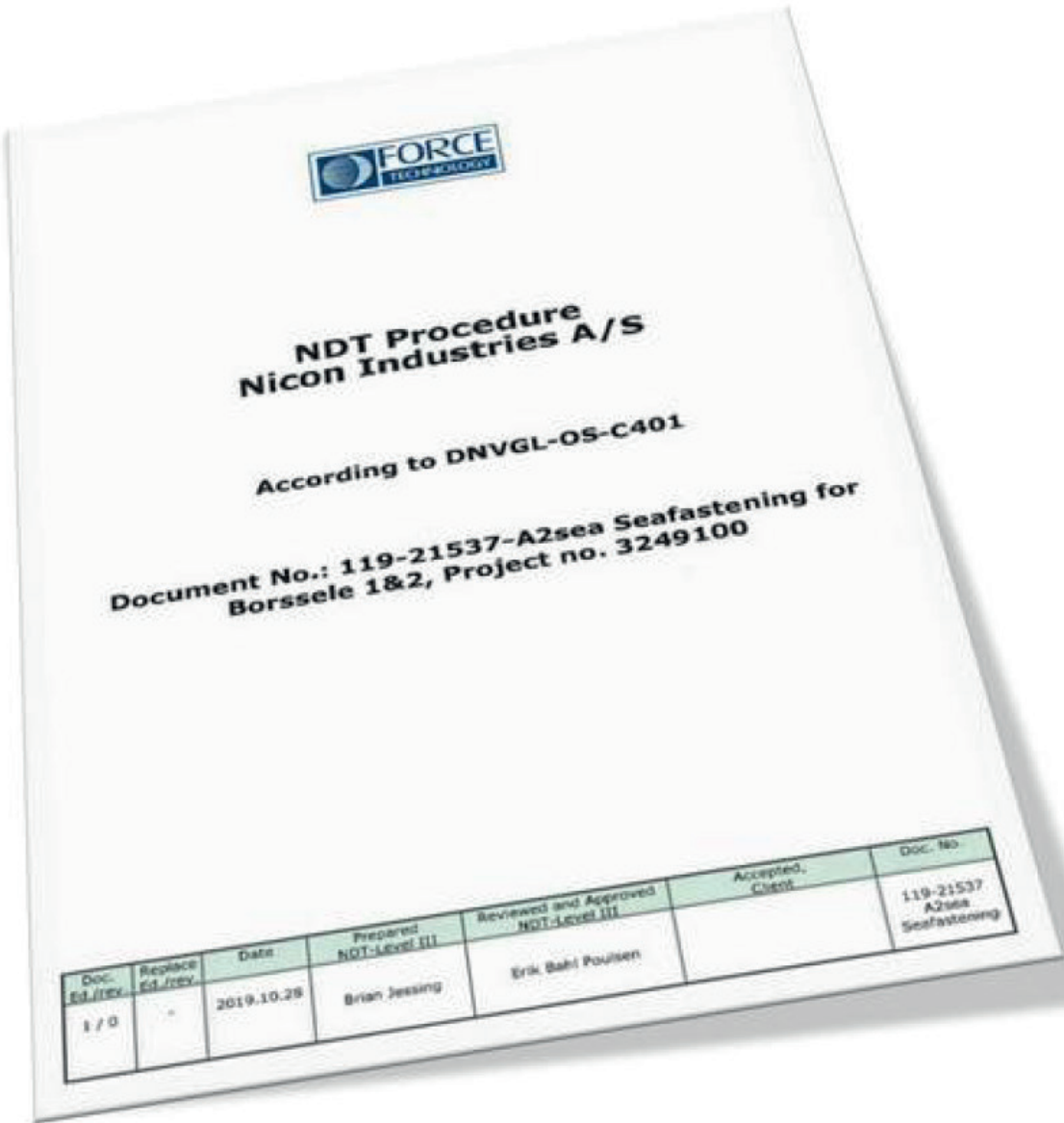
Standard of Accreditation: **DS/EN ISO/IEC 17025:2005**

Comprising Addresses/Departments

Address	Contact	Phone	Email	Homepage
FORCE Technology Niels Jernes Vej 2 - 4 DK-9220 Aalborg Ø	Bo Bossen	+45 26 70 00	bb@force.dk	www.force.dk
FORCE Technology Alsvej 6 DK-5500 Middelfart	Bo Bossen	+45 26 70 00	bb@force.dk	www.force.dk
FORCE Technology Østre Gjesingvej 7 DK-6715 Esbjerg N	Bo Bossen	+45 26 70 00	bb@force.dk	www.force.dk
FORCE Technology Park Allé 345 DK-2605 Brøndby	Bo Bossen	+45 26 70 00	bb@force.dk	www.force.dk

From DANAK's registry of accredited and approved companies

NDT PROCEDURE



PARAMETER CHECK

WELDING PARAMETERS										NICON INDUSTRIES quality on time									
Customer: Project: Production site:			3249100 Nicon																
Date	Time	Drawing	Weld no.	Welder no.	WPS	Temp C	Arg	Weld	Length	Time sec.	Speed cm/min	Type of weld	Welding position	Weld input J	Filler material	Filler batch no.	Supervisor		
23-10-2019	13.15	Flange no. 9	6	1418	136 1 30	197*	275	28	360	66	327	PA	Filer	1.13			KMA		
23-10-2019	13.25	Flange no. 2	5	1454	136 1 30	188*	275	27.7	400	70	343	PA	Filer	1.07			KMA		
23-10-2019	13.25	Flange no. 30	5	1436	136 1 30	181*	265	27	460	110	251	PA	Filer	1.37			KMA		
25-10-2019	9.30	Flange no. 2	3	1428	136 1 30	196*	270	27.8	300	89	367	PA	Filer	0.98			KMA		
25-10-2019	9.40	Flange no. 30	2	1428	136 1 X	200*	288	28.9	320	73	263	PA	Cap	0.90			KMA		
28-10-2019	10.45	Flange no. 10	2	1493	136 1 X	195*	290	31.2	380	47	485	PA	Filer	1.04			KMA		
30-10-2019	12.55	Flange no. 11	2	1423	136 1 X	192*	285	29.5	200	31	387	PA	Filer	1.49			KMA		
05-11-2019	8.20	Flange no. 14	2	1418	136 1 X	215*	295	31	310	63	295	PA	Filer	0.96			KMA		
05-11-2019	8.25	Flange no. 14	7	1418	136 1 X	215*	285	30	320	45	427	PA	Filer	1.50			KMA		
05-11-2019	13.30	Flange no. 14	6	1462	136 1 X	217*	285	30	320	45	427	PA	Filer	1.50			KMA		
05-11-2019	13.45	Flange no. 14	3	1436	136 1 X	240*	290	30.2	410	88	280	PA	Filer	1.29			KMA		
20-11-2019	11.15	Flange no. 6	5	1462	136 1 X	195*	290	30	395	73	325	PA	Filer				KMA		

SURFACE TREATMENT

QC Afdeling QC RAPPORT		Koldig Coat ApS Mølevvej 14 – 6700 Esbjerg	
Contractor: KOLDIG COAT APS – 4009		Order no: 34976	Owner: Nicon Industries
Job: NY Top Frame		Return date: 27.04.2020	
Date: 22.04.2020		Control Oil, grease, salts, for minimum min. R2	
High pressure washes with degreasing cleaner followed by rinsing with clean fresh water to remove oil and grease		Control ISO 12944-4	
Paint system: Colour: 1148			
Notes: Chloride test done - conductivity measurement = 1 µS/cm = 4 mg/m³			
Cleaning Grade: Sa, 2,5 ISO 8501-1 Roughness: ISO 8503-1 G coarse 85-130 µm Rz			
Root grade: A		Abrasive: Metallic	
Climate Measurements		ISO 8501-1	
	Air humidity RH%	Air temp. °C	Steel temp. °C
23-04-2020 05:30	28,0	24,3	23,5
23-04-2020 15:54	30,4	22,5	22,6
		Max	Min
		Average	Specified
DFT Thickness		Number of Measurements	
Specified system		500	900,0
		270,0	560,0
			300 µm
APPLICATION OF COATING		23-04 1.coat	23-04 2.coat
Start & Stop	07.00 08.00	17.00 18.00	
Specified DFT	150 µm	150 µm	
Quality no.	47700	47700	
Color no.	Red	Grey	
Batch no. (base)	040010088	040011941	
Batch no. (curing agent)	97702	97702	
Batch no. (curing agent)	040011931	040011931	
Notes:			
Dennis Koldig <i>Dennis Koldig</i> QC Sign Frosin inspector No.10115 level III Date: 27.04.2020			

Id.No: 1213 Page 1 of 1

Edition: 03 – 09.06.2010

Quality Manual (QM)

This document and its contents must not be copied in any form without written permission from Koldig Coat ApS

DIMENSION CONTROL

PLAN VIEW OF SPUDCAN NO. 1

1200 CENTER / CENTER MACHINES BOTTOM FLANGE

INSTALLATION OF WICKETS

SPUDCAN NO. 1 - WICKETS
DIMENSIONAL CONTROL

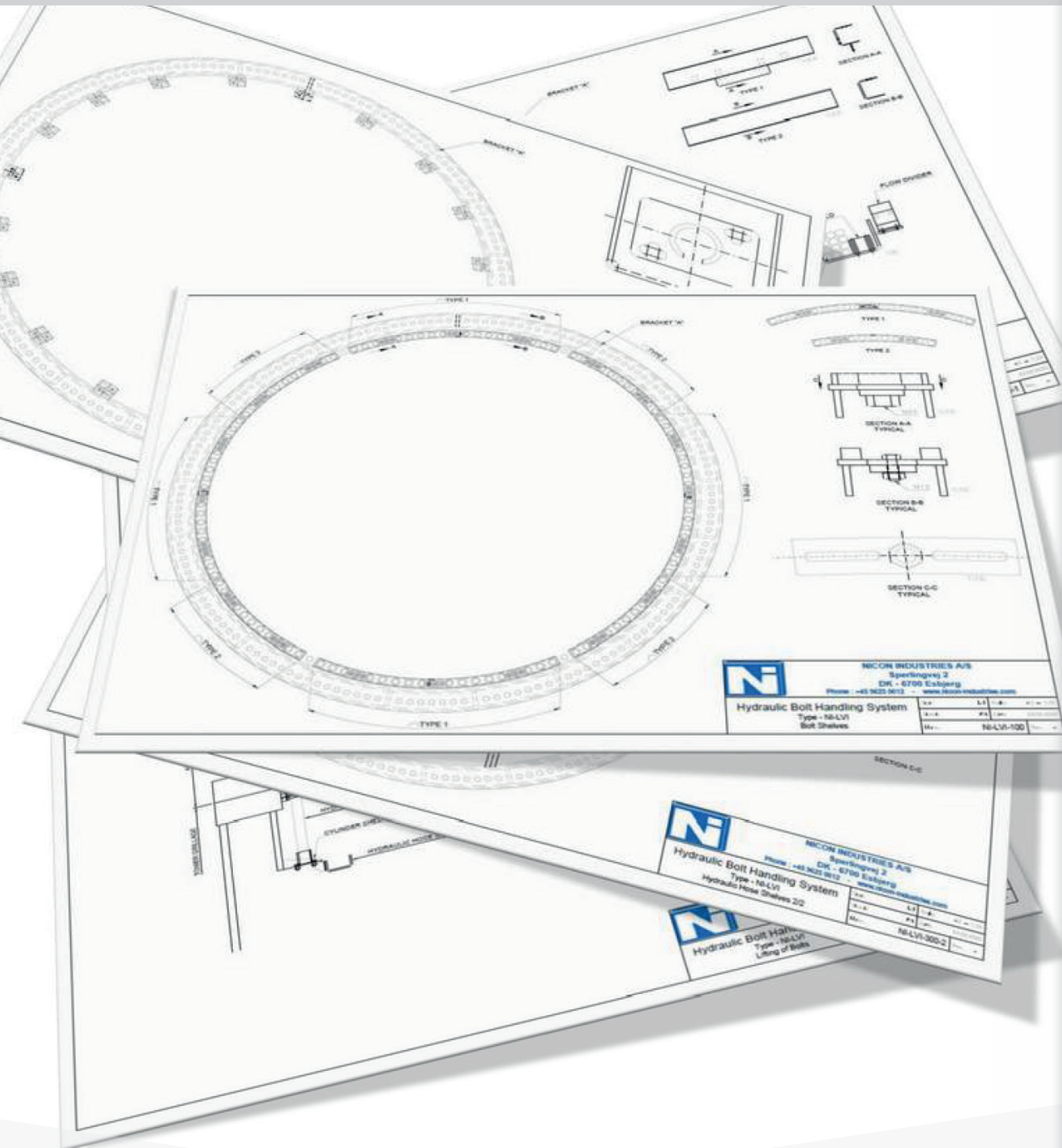
NO.	WICKET ADDRESS	ALIGNED WICKET	MEASURED DIMENSION	DIFFERENCE	STATUS
1	1200	+0	13.284	+4	OK
2	1200	+0	13.281	+1	OK
3	1200	+0	13.282	+2	OK
4	1470	+0	14.707	+7	OK
5	1470	+0	14.729	+29	OK
6	1470	+0	0.643	-2	OK
7	1470	+0	0.645	+1	OK
8	1470	+0	0.647	+7	OK
9	1470	+0	0.651	+1	OK
10	1470	+0	0.652	+2	OK

SPUDCAN NO. 1 - WICKETS
DIMENSIONAL CONTROL

NICON INDUSTRIES ESBJERG A/S
Esbjergvej 2
DK - 6700 Esbjerg
Phone: +45 9623 0000 Fax: +45 9623 0111
www.niconindustries.com

Rev: 1
Date: 20.08.2018
Rev: 1

DRAWINGS



SUBCONTRACTORS

Subsupplier name:	Assessment of sub-suppliers										Nicon assessment:					Total score
	Evaluation										Delivery risk	Quality system	Inventory	Technical ability		
	Certified system: 3 Implemented system: 2 Not applicable: 1	ISO 9001	ISO 14001	ISO 9002	ISO 9001	John	Alpha	ISO								
Finnish Airbus A/S	3	-	-	-	-	-	-	-	3	3	3	3	15			
Danisco	3	-	-	-	-	-	-	-	3	3	3	3	12			
TDK Steel	3	-	-	-	-	-	-	-	3	3	3	3	12			
Steel Tank	3	-	-	-	-	-	-	-	3	3	3	3	12			
Transt Wind Europe	3	-	-	-	-	-	-	-	3	3	3	3	12			
Steenmet	3	-	-	-	-	-	-	-	3	3	3	3	12			
Danisco	3	-	-	-	-	-	-	-	3	3	3	3	12			
J.E. Løyer	3	-	-	-	-	-	-	-	3	3	3	3	12			
TMA Group	3	-	-	-	-	-	-	-	3	3	3	3	12			
LNT	3	-	-	-	-	-	-	-	3	3	3	3	12			
Marek Steel	3	-	-	-	-	-	-	-	3	3	3	3	12			
Nordmark A/S	3	-	-	-	-	-	-	-	3	3	3	3	12			
KS Maskinteknik	3	-	-	-	-	-	-	-	3	3	3	3	12			
BH2 Industri	3	-	-	-	-	-	-	-	3	3	3	3	12			
Makinafabrikken Flugtange	3	-	-	-	-	-	-	-	3	3	3	3	12			
Göteborg	3	-	-	-	-	-	-	-	3	3	3	3	12			
Victor-DST A/S	3	-	-	-	-	-	-	-	3	3	3	3	12			
T.S. Tech	3	-	-	-	-	-	-	-	3	3	3	3	12			
Dancoast	3	-	-	-	-	-	-	-	3	3	3	3	12			
Kolding Coast	3	-	-	-	-	-	-	-	3	3	3	3	12			
HIS Industri Service	3	-	-	-	-	-	-	-	3	3	3	3	12			
Axiens Shipyard	3	-	-	-	-	-	-	-	3	3	3	3	12			
Global Outsourcing	3	-	-	-	-	-	-	-	3	3	3	3	12			
DOT	3	-	-	-	-	-	-	-	3	3	3	3	12			
Vicos	3	-	-	-	-	-	-	-	3	3	3	3	12			
BMS Steel Construction	3	-	-	-	-	-	-	-	3	3	3	3	12			
BMS	3	-	-	-	-	-	-	-	3	3	3	3	12			
Tip Top Johansen	3	-	-	-	-	-	-	-	3	3	3	3	12			
Prima-vent A/S	3	-	-	-	-	-	-	-	3	3	3	3	12			

Low: 8 - 12

Medium: 13 - 19

High: 20 - 26

Below is an explanation of total score

It is important to look at the Nicon assessment, which is based on experience through several years of trade and cooperation.

We should always, no matter the total score, look at "Delivery on time". If it is low, we should take our precautions.

We are still allowed to do business with suppliers and sub-suppliers who are marked red. We just need to take our precautions, or if the Nicon assessment is high, especially "Delivery on time".

Example of precautions:

If for instance we are asking for some special steel plates or profiles and they are the only supplier that can provide this, we should, before the order is given, ask them to forward the material certificate to ensure that the material fulfil the requirements we have specified. Also to make sure that the material is in stock. We might retrieve the material ourselves.

In case of a service provision, an assessment must be made of how critical the sub-supplier's task is for the overall project in terms of time, finances and quality.

NON CONFORMITY REPORT (NCR)

Nicon Industries A/S		Date:	09.04.2018	Responsible: QM
QA-8.05.1 - Nonconformity report		Replaces date:	16.08.2016	Page 1 of 1
Project no.:	Report no.:	Report date:	Project name:	Created by:
Nonconformity: (the standard):				
Reason for nonconformity: (finding the cause)				
Nonconformity: (last cause):				
(Binding Draw-8, Draw-4, Measuring, Flares, Control, Calculation, Resources, Management, Purchase, Supply, Sub-supplier, Customer, Audio)				
Remedial action:				
Corrective action:				
Registration: Furthermore the above will be registered in our "QA-8.05.2 Nonconformity registration and monitoring", in order to give an overall view for the periods nonconformities and the frequency of each individual type.				
Costs:				
Verification of a Corrective Action:		Price in DKK:	N.NNN.NN	
Any Corrective Action will be registered and monitored in our "QA-13.06 Action plan". Here we will also verify the effect hereof.				

TECHNICAL QUERY (TQ)

NICON INDUSTRIES A/S		Date: 31.03.2018	Ansvarlig: KA
Technical Query (QA-8.05.3)		Erstatter date: 04.12.2014	Side 1 af 1
Project name:	Project no.:	Customer ref.:	
Customer name:	Issued date:	Prepared by:	
TQ nr.:	Clarification of deviation / non conformity:		
Cause:			
Technical correction / adjustment:			
Attached documents:			
Impact on project schedule:		Impact on project cost:	
Response from customer:			
Date	Signature	Project manager	
Quality responsible:		Date & Signature	
Date & Signature			





Nicon Industries A/S
Sperlingvej 2
DK-6700 Esbjerg

www.nicon-industries.com

Henrik R. Jensen
hrj@nicon-industries.com
Tel. (+45) 6011 1354

Jens Juul
jjj@nicon-industries.com
Tel. (+45) 4042 6324



NICON INDUSTRIES A/S

www.nicon-industries.com · +45 9623 0012 *quality on time*