

What is EN 1090?

The EN 1090 standard applies across Europe and specifies the requirements for the conformity assessment of steel and aluminium components that are placed on the market as construction products. In Germany, EN 1090 supersedes the previously applicable DIN 18800-7.

What is a WPQR?

A report qualifying the welding procedure. A component is welded according to specifications in the pWPS and then tested. If the weld meets the required quality standards, a WPQR is issued.

WPQR = Welding Procedure Qualification Record

Standardised term: procedure test

What is a WPS?

The WPS is the qualified welding procedure specification. It includes pWPS information and the WPQR number.

WPS = Welding Procedure Specification

Standardised term: welding procedure specification

What is EN 15612?

EN ISO 15612 sets out the “specification and qualification of welding procedures for metallic materials – qualification by adoption of a standard welding procedure” (*quote*): “*This standard gives the manufacturer the possibility to use welding procedures based on welding procedure tests performed by other organisations.*”

What is EN ISO 3834?

The EN ISO 3834 series of standards defines the quality requirements that must be met by fabricators of fusion-welded components and structures.

What is the EWM WPQR package?

The EWM WPQR package is a catalogue of procedure tests (WPQR) and associated welding procedure specifications (WPS). The catalogue can be used by businesses as part of the EN 1090 certification process to fulfil requirements in relation to welding activities.

What does the EWM WPQR package consist of?

The EWM WPQR package consists of a WPQR and WPS covering the following:

- Material: material group 1.1 (e.g. S235 or S355)
- Panel thickness: 1.5–24 mm
- Welding position: PA, PB, PF
- Butt joint and T-joint
- Welding consumable: G3Si1 and G4Si1 (diameter 1.0 mm or 1.2 mm)
- Shielding gas: ArC-18
- Welding process: 135 MIG/MAG (short arc, transitional arc, spray arc, pulse, rootArc, coldArc, forceArc)

- Suitable welding machines: all EWM Synergic inverters built in or after 2010

With which EWM machines can the EWM WPQR package be used?

The alpha Q, Phoenix, Taurus Synergic and Picomig machine series.

With which welding consumables can the EWM WPQR package be used?

Version A – Qualification through standard welding procedure specifications:

With the above-mentioned EWM welding machines and **any wire** that complies with the standard description given in the WPQR [up to S355].

Version B – Qualification through the welding consumable:

An EWM welding consumable tested in the WPQR package with any welding machine on which the current and voltage can be set in accordance with the WPS [up to S275].

Who will find the EWM WPQR package useful?

Small skilled manufacturers and large industrial companies alike.

Even if the package does not cover all of a large company's welding tasks, it will still be possible to save time and money for the applicable welds.

How much does the EWM WPQR package cost?

Less than the cost of one single welding procedure test.

Where can I buy the EWM WPQR package?

From all EWM sales partners and EWM branches

How is the EWM WPQR package supplied?

In a folder with 13 WPQR certificates, 52 qualified welding procedure specifications and a CD containing all the documents in PDF format.

Who was responsible for testing the EWM WPQR package?

TÜV Rheinland.

What do I need to do after purchasing the package?

The WPQR package is legally permitted to be used only after it has been registered online. After registration, the package and associated CD may be used with the generated security code.

www:

Why, when and how do I register the EWM WPQR package?

Registration ensures any changes and updates can be communicated effectively. The package must be registered immediately after purchase at www.ewm-group.com.

How do I use the EWM WPQR package?

Your company can put the data from the WPS in the package directly into practice. To do so, it is necessary to create your own WPS using the data. This individually created WPS is immediately valid for use.

As a company, how do I get started with the EWM WPQR package?

The package must be registered and activated online in order to ensure that any changes and updates can be communicated effectively.

What happens if there are any changes to the content?

An update will be issued. Owners can receive updates by registering their package.

Can I use the EWM WPQR package for aluminium welding?

No, qualification of a WPS according to EN 15612 for aluminium materials is not included in the standard.

How many welding machines can I use with the EWM WPQR package?

As many as you like. The only restriction is that the owner of the WPQR package also needs to be the user. You are not permitted to forward the package to third parties on liability grounds.

Is there a time limit on the validity of the EWM WPQR package?

No, there are no time limits on the duration of validity.

Can the EWM WPQR package be transferred to other businesses?

You are not permitted to forward the package to third parties on liability grounds.