



FSQ

SCRUBBER TEAM

- ✓ DOCUMENTED.
- ✓ VERIFIED.
- ✓ RELIABLE.

WE DELIVER RESULTS – EVERY TIME.



DEVELOPED FOR SCRUBBER REPAIRS

WPQR 131 vs WPQR 141 – know the difference, get the result.

WPQR 131 (MIG/MAG – process 131)

EN ISO 15614-1
Welding Procedure
Qualification Record

Manufacturer: **BachFSQ**

Test object: **Butt weld**

Welding process: **131 (MIG/MAG)**

Filler metal: **MT-254 (SMO 1.4547)**

Shielding gas: **Ar**

Position: **PB**

Thickness: **1.0 mm**

Result: **Approved**

Date / Ref: **EN ISO 15614-1**

- Process: 131 (MIG/MAG)
- Filler metal: **MT-254 (SMO 1.4547)**
- Gas: **Ar**
- Position: **PB (1.0 mm)**
- Result: **Approved**
- Acceptance: **Meets requirements**
- Macro: **Meets requirements**
- Micro: **Meets requirements**

EN ISO 15614-1

✓ Full penetration – approved

WELDING SPEED (REAL PRODUCTION)

540 mm/min

1 PASS

Completed in one weld

WPQR 141 (TIG – process 141)

EN ISO 15614-1
Welding Procedure
Qualification Record

Manufacturer: **BachFSQ**

Test object: **Butt weld**

Welding process: **141 (TIG)**

Filler metal: **Inconel 625**

Electrode: **Wolfram (WL20)**

Position: **PB**

Thickness: **1.0 mm**

Result: **Approved**

Date / Ref: **EN ISO 15614-1**

- Process: 141 (TIG)
- Filler metal: **Inconel 625**
- Electrode: **Wolfram (WL20)**
- Position: **PB**
- Result: **Approved**
- Acceptance: **Meets requirements**
- Macro: **Meets requirements**
- Micro: **Meets requirements**

EN ISO 15614-1

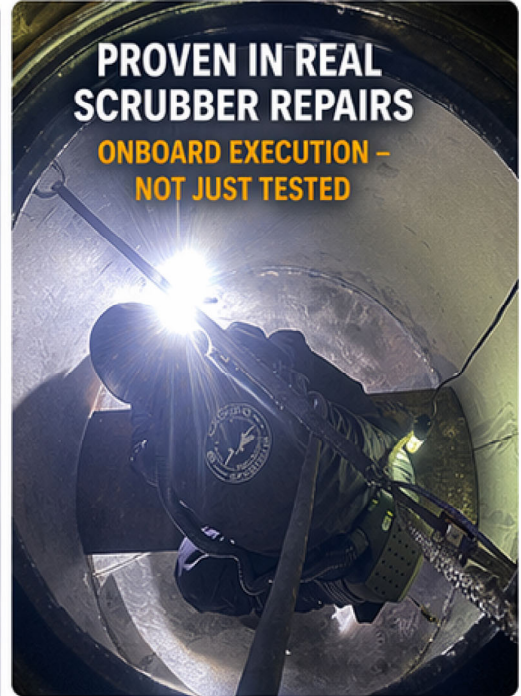
✓ 2 passes required to achieve the same – welding time is doubled

WELDING SPEED (REAL PRODUCTION)

115 mm/min

2 PASSES REQUIRED

Time is doubled



Direct comparison under identical test conditions (EN ISO 15614-1)

The difference is clear: Process 131 delivers, where 141 doesn't.

SPECIALISED IN SCRUBBER REPAIRS OFFSHORE AND MARINE

COMPARISON		
CRITERIA	WPQR 131 (MIG/MAG)	WPQR 141 (TIG)
✓ Welding speed (real production)	540 mm/min (1 pass)	115 mm/min (2 passes)
✓ Effective speed (real production)	540 mm/min	~57 mm/min
✓ Number of passes	1	2
✓ Quality (visual)	Good	Very good
✓ Heat input	Low – moderate	High
✓ Productivity	Very high	Low
✓ Quality (this test)	Approved	Approved
✓ Corrosion (weight loss)	0.89 g/m ²	3.73 g/m ²
✓ Filler material	SMO 1.4547 (match)	Inconel 625

- #### WPQR 131 – ADVANTAGES
- ✓ Perfect for scrubber repairs
 - ✓ Stable process – easy to repeat
 - ✓ Approved WPQR – documented (EN ISO 15614-1)
 - ✓ Matching filler material (SMO)
 - ✓ Ideal for retrofit and on-site work

- #### WPQR 141 – DISADVANTAGES
- ✗ Slower (higher heat input)
 - ✗ Longer process time
 - ✗ Requires special competence for finish
 - ✗ Higher overall cost

CORRECT FILLER MATCH vs TIG COMPROMISE	
MT-254 (SMO 1.4547) <ul style="list-style-type: none"> • 100% matching material • No compromise 	Inconel 625 TIG solution <ul style="list-style-type: none"> • Dissimilar filler metal • Lower productivity and higher risk

DOCUMENTED QUALITY
All our welds are documented and traceable.

FASTER AND MORE PRODUCTIVE
Process 131 delivers higher real welding speed and operational efficiency.

LOWER CORROSION – LONGER LIFETIME
Tested and proven – better protection over time.

WE WOULD LOVE TO PRESENT OUR RESULTS TO YOU.

The numbers speak for themselves – but we're happy to go into even more detail.

Let's meet and discuss how this can create value for you.