

BVE SHIPBUILDING SERVICE

Your Trusted Partner in Shipbuilding and Repair

About Us:

BVE SHIPBUILDING SERVICE specializes in ship construction and repair, along with various steel structures construction. Our expertise covers a wide range of ships—from luxury yachts to large cargo ships—and extends to metal fabrication, where we handle everything from planning and design to assembly. With our in-house facilities, skilled team, and commitment to industry standards, we ensure high-quality, efficient project completion for our clients within their budget.

Founded: **2018, Romania**

Our Core Activities: **Shipbuilding & Repair, Steel Structure Construction**

Secondary Activities: **Metal working and metal fabrication**

Growth: **Expanded to 115 active employees**

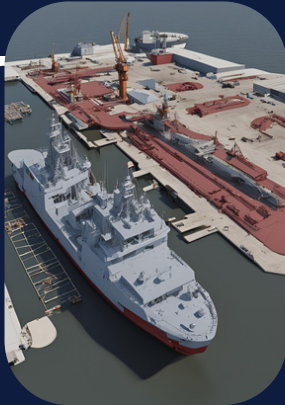


[Check full public information:](https://www.romanian-companies.eu/bve-shipbuilding-service-srl-38850653/)

<https://www.romanian-companies.eu/bve-shipbuilding-service-srl-38850653/>

Our core Activities

Our operations are closely linked and mutually supportive, enabling us to deliver projects more effectively.



SHIPBUILDING AND REPAIR

We undertake shipbuilding and repair projects internationally, with key projects across Europe, mainly in Germany and the Netherlands. Within national borders we specialize in repairs and construction of various naval elements, ensuring top-quality standards.



STEEL STRUCTURES

Our team has skilled professionals in planning and design activities, assembly of complex metal structures, tailored to meet project specifications and applicable standards.



CUSTOM METAL COMPONENTS

At our Constanta workshop facility, we handle many types of customized metallic components based on client requirements using CNC Plasma cutting technology, lathe and milling machines as well as other auxiliary equipment.

Our core Activities



OUTFITTING

We undertake outfitting activities for shipbuilding and repair such as:
Installation of cable tray supports, laying electrical cables and wall penetrations.



EMBOSSING

Our company has the capability of embossing plates for industrial clients as well as individuals. The most used materials are: stainless steel, aluminum and carbon steel.

Why BVE?



**Certified skilled
workforce**



Reliable Partner



Service Excellence

Ensuring superior quality in all our endeavours.



Prompt & Trustworthy



Customer Satisfaction

Meeting and exceeding client expectations.



Expert Knowledge

Built on long-term projects and fabrication know-how.

International Projects (naval)

We take pride in our long-standing partnerships with leading companies in the shipbuilding industry, where we send our skilled employees to their shipyards to support various projects, consistently meeting and exceeding expectations.

[RENSEL- Papenburg, Germany](#)

Germany: Continuous operations at Meyer Shipyard since 2018
on behalf of Rensel Service GmbH

Scope of Work: Shipbuilding, repair and outfitting of various cruise ships

[ERGOS SHIPBUILDING SERVICES - Franeker, Netherlands](#)

Netherlands: Continuous operations at Talsma Shipyard since 2018
on behalf of Ergos Shipbuilding Services


Scope of Work: Building, repair and maintenance of luxury yachts

Interventions (urgent, short notice project)

[SN FEADSHIP ROYAL DUTCH SHIPYARDS - Shipyard in Makkum, Súdwest-Fryslân, Netherlands](#)

[SN TALSMA SHIPYARDS - CURACAO](#)

Company Certifications

 MINISTERUL TRANSPORTURILOR SI INFRASTRUCTURII
AUTORITATEA NAVALA ROMANA

Autorizare Nr.: 109896 SAPNI-SP/MA

AUTORIZARE PRODUCĂTOR DE SERVICII ÎN DOMENIUL NAVAL

În baza HG 1133/2002 Anexa 1, Regulament, Cap. 2, Art. 4, lit. J, privind organizarea și funcționarea Autorității Navale Române și prevederilor normativului cod MT.RNR-NT 1/2 - 99 "Procedura privind autorizarea producătorilor de produse, servicii și echipamente cu specific naval și industrial" aprobat prin OMT nr. 288 din 04.06.1999, se autorizează societatea:

SC BVE-SHIPBUILDING SERVICE SRL
Sat Lazu, Comuna Agiea, Strada STUPINEI, Nr. 3, CAM 1, Judet Constanta
Punct de lucru Str. Traian nr. 98

pentru executarea în domeniul naval de:

Lucrări de reparatii la corpul navelor si ambarcatiunilor fluviale, precum si structurile metalice instalate sau montate pe acestea
Lucrări de reparatii la corpul constructiilor plutitoare, maritime si fluviale, precum si la structurile metalice instalate sau montate pe acestea



■ Serviciile se vor executa în conformitate cu cerințele din documentațiile și tehnologiile aprobate în prealabil de către ANR, pentru conformitatea cu "Normele tehnice privind clasificarea și construcția navelor maritime" cod MLPTL-ANR - NM - 2002 aprobate prin OMT 1901/2002, cu cerințele aplicabile din "Norme tehnice privind construcția și clasificarea navelor de navigație interioară" cod MT-ANR-NI-99, aprobate prin OMT 306 / 1999, "Cerințele tehnice pentru nave de navigație interioară" aprobate prin OMT 1472 / 2018 precum și prevederile standardului ES-TRIN în vigoare.
■ Lucrările de reparatii la navele si ambarcatiunile fluviale precum si la constructiile plutitoare maritime si fluviale se vor face doar cu sudorii autorizati ANR.
■ Controlul nedistructiv a lucrărilor aflate sub supravegherea ANR se va face numai de către operatori autorizați și laboratoare acreditate/recomandate de către ANR.

La baza autorizării au stat: adresa S.C. BVE-SHIPBUILDING S.R.L. nr. 55 din 18.11.2022, dosarul tehnic nr. 109896 MA din 23.11.2022 și raportul de evaluare nr. 109896 SAPNI - SP/MA din 19.12.2022.

Autorizarea este valabilă până la data de **18.12.2025**, în condițiile efectuării unui audit de supraveghere, cu posibilitatea prelungirii pe o perioadă de 3 ani, dacă sunt menținute condițiile inițiale care au stat la baza acordării acesteia.


București, **19 Decembrie 2022**

Serviciul Avizări Produse Navale, Industriale și Supraveghere Piață
SEF SERVICIU INSPECTOR

 Ștefan Gaiu
 Mihai Bogdan Axinte

ANR se exonerază de orice responsabilitate în cazul utilizării abuzive a prezentului document, întreaga răspundere revenind firmei acreditate.
Orice copie a prezentei acreditări are valabilitate numai prin dovădrea existenței originalului plastifat având timbrul sec ANR.

Form ANR / FAB - R - 02

 MINISTERUL TRANSPORTURILOR SI INFRASTRUCTURII
AUTORITATEA NAVALA ROMANA

Autorizație Nr. 45938/4/AS/SAPNI-SP

ACREDITARE EXAMINĂRI NEDISTRUCTIVE

În baza HG 1133/2002, privind organizarea și funcționarea Autorității Navale Române, a prevederilor normativului ANR cod, cod MT.RNR - NT11/2 - 99 "Prescripții privind acreditarea laboratoarelor de examinări nedistructive" aprobată prin OMT nr.288 din 04.06.1999 și a OMT nr.409/2018, se acreditează:

LABORATOR EXAMINĂRI NEDISTRUCTIVE

aparținând firmei:

S.C. BVE SHIPBUILDING SERVICE S.R.L. cu sediul în
Com. Agiea ; str. Stupinei nr.3 ; Jud. Constanta

pentru a efectua examinări nedistructive în domeniul:



UTg - măsurători grosimi table prin examinări cu ultrasunete

la produsele/lucrările/echipamentele
navale și industriale
aflate sub supravegherea Autorității Navale Române

Acreditarea este valabilă până la **29 Mai 2026**
în condițiile respectării OMT 409/2018 a cerințelor normei ANR cod, MT.RNR - NT 11/2 - 99 și în special a punctelor 5.2; 7.1; 7.4.7.
și a Anexei 1 a acesteia, precum și ES-TRIN 2021 ; Partea II ; Cap. 3.02

București, **31 Mai 2023**

Serviciul Avizări Produse Navale, Industriale și Supraveghere Piață
SEF SERVICIU INSPECTOR

 Ștefan GAIU
 Liviu Paul MARINA

ANR se exonerază de orice responsabilitate în cazul utilizării abuzive a prezentului document, întreaga răspundere revenind firmei acreditate.
Orice copie a prezentei acreditări are valabilitate numai prin dovădrea existenței originalului plastifat având timbrul sec ANR.

Company License

ROMÂNIA MINISTERUL TRANSPORTURILOR Compania Națională Administrația Porturilor Maritime S.A. Constanța	
LICENȚA DE LUCRU WORKING LICENCE	
Seria PS.. nr. 359..... Series ... no.	
constantza port	
În temeiul art. 11 din Legea nr. 84/1992, cu modificările și completările ulterioare, ale OMLPTL nr. 1431/2002 și în baza contractului In accordance with art. 11 from Law no. 84/1992, including further changes and follow-ups, of the OMLPTL no. 1431/2002 as well as on the basis of the Contract	
nr.1./.....2023.. încheiat cuSC.ADM.Romania Logistics SRL..... no.concluded with	
se acordă LICENȚA DE LUCRU firmeiBVE-SHIPBUILDING SERVICE SRL..... the WORKING LICENCE is granted to the company	
cu sediul înSat Lazu, Comuna Agigea, Strada Stupinei nr. 3, Cam. 1, Județ Constanța having its headquarters in	
Această licență este valabilă în perioada17.03.2024 - 16.03.2025 This licence is valid from - to	
și a fost acordată pentru activitatea deREPARAȚII LA BORDUL NAVELOR..... and it has been granted for the following activity	
COD CAEN 3315	
ce se va desfășura în perimetrul Zonei LibereConstanța that will be carried on within the premises	
Valoarea licenței de lucru este de4.239 lei The value of the working licence is	
DIRECTOR GENERAL Managing Director	Data emiterii Date
	22.02.2024

Welding procedure Certifications



OCA GLOBAL INSPECCIONES REGULATORIAS, S.A.U.
Dirección de Delegación

Certificado Nº: 24-OCA-P-0349
Certifcate No:

Fecha: / Date: 07.10.2024
Páginas: / Sheet: 1 de / of 3

REGISTRO DE CUALIFICACIÓN DE PROCEDIMIENTO SOLDEO WELDING PROCEDURE QUALIFICATION RECORD (WPQR)

CUALIFICACIÓN DEL PROCEDIMIENTO DE SOLDEO - CERTIFICADO DEL ENSAYO.
WELDING PROCEDURE QUALIFICATION - TEST CERTIFICATE

Fecha de soldado:
Date of welding: 06.09.2024

Nº WP Fabricante: 1411130 Rev: 0 Nº PQR: BVE08
Manufacturer WP No:

Fabricante / Manufacturer: BVE Shipbuilding Service

Dirección / Address: Strada Steișel nr.3, Cam. S. Lazar

Código/ Norma de ensayo: / Code/Testing standard: UNE EN ISO 15614-1:2018

Rango de cualificación / Range qualified: 141 + 111

Proceso(s) de soldado: / Welding Process(es) and type(s): BW, FW

Tipo de unión y de soldadura: / Joint and weld type: 8.1 - 8.1

Grupo(s) o subgrupo(s) del material de base: / Parent Metal Group: 6.02

Espesor del material base (mm): / Thickness (mm): 141: 3+8 / 111: 1+4

Espesor del metal de soldadura (mm): / Thickness weld metal (mm): 6.02

Espesor de garganta (mm): / Throat (mm): a = no restriction

Pasada simple/múltiple(s): (por lado) / Multiple or single pass (per side): ni

Diámetro exterior del tubo (mm): / Pipe outside diameter (mm): 114.3

Marca, Tamaño y Designación del material de aportación: / Trade name, Size and Specification of filler metal: 141: ESAB OK TIGROD 316LS, EN ISO 14343-A: W 19 12 3 L Si + 111: KSWEL-KST-316L, EN ISO 3581-A: E 19 12 3 L R 1 2

Designación del gas de protección/fuente: / Shielding gas designation: I1

Designación del gas de resque: / Backing gas designation: I1

Tipo de corriente de soldado y polaridad: / Current type and polarity: 141: DCEN (-) / 111: DCEP (+)

Modo de transferencia del metal: / Model of metal transfer: no restriction

Aporte térmico (KJ/cm): / Heat input (KJ/cm): PH

Posiciones de soldado: / Welding position(s): All except PG and PJ

Temperatura de precalentamiento: / Preheat temperature: 15 °C

Temperatura entre pasadas: / Interpass temperature: 100 °C

Post-calentamiento: / Postweld heat treatment: -

Tratamiento térmico posterior al soldado: / Postweld heat treatment: -

Nombre del soldador: / Welder name: Monica Petrica

Otra información: / El procedimiento objeto de este certificado es acorde con las disposiciones de la 2014/68/UE.

Another information: / The subject procedure of this certificate is according with the arrangements of the 2014/68/UE.

Certificamos que las soldaduras de ensayo han sido preparadas, soldadas y ensayadas satisfactoriamente de acuerdo con los requisitos del código/norma de ensayo arriba indicado.

We certify that the testing welds are prepared, welded and tested satisfactorily according with the code/norma specifications previously indicated.

Lugar/Place: Bucharest

Nombre de la Persona u Organismo examinador/Examiner or examining body: OCA GLOBAL INSPECCIONES REGULATORIAS, S.A.U. (ON/NB: 0058)

Fecha de emisión: / Date: 07.10.2024

Firmado por: / Signed by: Casan Raluca

Inspector: OCA GLOBAL

7800-GEN-16-03 REV.01 06/23



OCA GLOBAL INSPECCIONES REGULATORIAS, S.A.U.
Dirección de Delegación

Certificado Nº: 24-OCA-P-0349
Certifcate No:

Fecha: / Date: 07.10.2024
Páginas: / Sheet: 2 de / of 3

REGISTRO DEL ENSAYO DE SOLDADURA WELDING TEST RECORD

Detalles de la preparación de la soldadura (proyecto) / Weld preparation details (project)



Parámetros de soldado: / Welding parameters:

Pasada post no.	Proceso de soldado	Tamaño aporte	Intensidad	Voltaje	Corriente	Vel. adm. alambre	Velocidad avance	Aporte térmico
1	141	2.0	80	10	DCEN (-)	-	2.95	9.76
2	141	2.0	85	10.2	DCEN (-)	-	3.82	5.36
3	111	2.6	56	24	DCEP (+)	-	6.81	9.47
4	111	2.6	56	24	DCEP (+)	-	5.21	12.38

Condiciones de ensayo: / Conditions of testing: 350 Degrees C / 2h

Gas/fuente de soldado: / Shielding gas: I1

(1) Protección: / Protection: I1

(2) Resque: / Backing gas: I1

Caudal del gas de (lit/min): / Gas flow rate of (lit/min): 10 - 14

Tipo medida del electrodo voltímetro: / Voltage electrode type: W120 / 2.4 mm

Temperatura de precalentamiento: / Preheat temperature: 15 °C

Temperatura entre pasadas: / Interpass temperature: 100 °C

Post-calentamiento: / Postweld heat treatment: -

Fabricante: / Manufacturer: BVE Shipbuilding Service

Nombre de la Persona u Organismo examinador: / Examiner or examining body: OCA GLOBAL INSPECCIONES REGULATORIAS, S.A.U. (ON/NB: 0058)

Firmado por: / Signed by: Casan Raluca

Inspector: OCA GLOBAL

7800-GEN-16-03 REV.01 06/23



OCA GLOBAL INSPECCIONES REGULATORIAS, S.A.U.
Dirección de Delegación

Certificado Nº: 24-OCA-P-0349
Certifcate No:

Fecha: / Date: 07.10.2024
Páginas: / Sheet: 3 de / of 3

RESULTADOS DE LOS ENSAYOS / TEST RESULTS

Ensayos No Destructivos: / Non Destructive Testing:	Resultado / Result	Nº Informe / Report No.
Examen Visual: / Visual Examination:	Accepted	24-OCA-VT-39
Líquidos Penetrantes/Part. Magnéticas: Penetrant T. Mag. Particle	Accepted	24/2024
Radiografía: / Radiographic testing:	Accepted	2457
Ensayo por Ultrasonidos: / Ultrasonic testing:	-	-

Ensayos de tensión / Tensile Test:

Tipo/Nº	Dimensiones	Área	Límite elástico	Tensión Rotura	Alargamiento	Shredón rotura	Observaciones
Type/No	Dimensions	Area	Re (N/mm²)	Rm (N/mm²)	A %	2 %	Observations
11	12.2 x 6.1	74.42	-	550	-	-	BM Accepted
12	14.2 x 6.1	74.42	-	529	-	-	BM Accepted

Ensayos de doblado: / Bend Test:

Tipo/Nº	Ángulo doblado	Alargamiento	Resultados	Tipo/Nº	Ángulo doblado	Alargamiento	Resultados
Type/No	Bend angle	Elongation	Results	Type/No	Bend angle	Elongation	Results
11	180	-	Accepted	12	180	-	Accepted

Ensayo de impacto: / Impact Test:

Tipo/Nº	Localización entalla	Temperatura Ensayo	Valores (J) / Values	Promedio	Observaciones
Type/No	Notch location	Test temperature	1	2	Average
-	-	-	-	-	-
-	-	-	-	-	-

Tipo Entalla/Notch Type:

Tamaño/Size	Requisitos/Requirements
-	-

Ensayo de dureza: / Hardness Test:

Carga / Load	Unión soldadura	Material base	ZAT	Soldadura	ZAT	Material Base
-	-	-	-	-	-	-
-	-	-	-	-	-	-

Tipo/Carga / Type/Load:

Tipo/Nº	C	Mn	P	S	Cr	Ni	Mo	Cu	Al	Ti
Type/No	0.014	0.86	0.35	0.03	0.002	16.54	10.05	2.01	-	-

Análisis Químico: / Chemical analysis:

Examen Macroscópico: / Macro-examination Test: Accepted acc. to report no. 780/2024

Otros ensayos: / Other Test: *Chemical composition acc. to inspection certificate no. V5-302419-22

Ensayos llevados a cabo de acuerdo con los requisitos de: / Tests carried out according to the requirements of: UNE EN ISO 15614-1:2018

Ensayos dirigidos por: / Test conducted by: Bucuraru Claudia

Laboratorio: / Laboratory: Welding Technology Center

Lugar / Place: Bucharest, Romania

Nombre de la Persona u Organismo examinador: / Examiner or examining body: OCA GLOBAL INSPECCIONES REGULATORIAS, S.A.U. (ON/NB: 0058)

Fecha de emisión: / Date: 07.10.2024

Firmado por: / Signed by: Casan Raluca

Inspector: OCA GLOBAL

7800-GEN-16-03 REV.01 06/23

Welding procedure Certifications



OCA GLOBAL INSPECCIONES REGLEMENTARIAS, S.A.U.
Dirección de Delegación

Certificado Nº: 24-OCA-P-0348
Certificate No:

Fecha: / Date: 07.10.2024
Página: / Sheet: 1 de / of 3

REGISTRO DE CUALIFICACIÓN DE PROCEDIMIENTO SOLDADO WELDING PROCEDURE QUALIFICATION RECORD (WPQR)

CUALIFICACIÓN DEL PROCEDIMIENTO DE SOLDADO - CERTIFICADO DEL ENSAYO.
WELDING PROCEDURE APPROVAL - TEST CERTIFICATE.

Nº WPQR Fabricante: 11101 Rev. 0 Nº PQR: BV087
Fabricante / Manufacturer: BVE Shipbuilding Service
Dirección: / Address: Strada Stupinei nr.3, Cam 1, Lazu

Código/ Norma de ensayo: / Code/Testing standard: UNE EN ISO 15614-1:2018

Rango de cualificación / Range qualification:
Proceso(s) de soldadura / Welding Process(es) and type(s): 111
Tipo de unión y de soldadura: / Joint and weld type: BW, FW
Grupo(s) o subgrupo(s) del material de base: / Parent Metal Group: 1.2-1.2.1.2-1.1.1.1-1.1
Espesor del material base (mm): / Thickness (mm): 11.13 Rango Calificado: 3+22.26
Espesor del metal de soldadura (mm): / Thickness weld metal (mm): 11.13 Rango Calificado: max.22.26
Espesor de garganta (mm): / Throat (mm): a = no restriction
Pasada simple/multipasada (por lado) / Multiple or single pass (per side): ni

Diámetro exterior del tubo (mm): / Pipe outside diameter (mm): 114.3 Rango Calif.: ≥ 57.15

Marca, Tamaño y Designación del material de aportación: / Trade name, Size and Specification of filler metal:
Proceso: root: ESAB OK 53.70, EN ISO 2560-A; E 42 5 B 12 HS / fil: ESAB OK 48.60, EN ISO 2560-A; E 42 4 B 42 HS

Designación del gas de protección: / Shielding gas designation:
Tipo de corriente de soldadura y polaridad: / Current type and polarity: root: DCEN (+), fil: DCEP (+)

Modo de transferencia del metal: / Metal transfer mode:
Aporte térmico (kJ/cm): / Heat input (kJ/cm): (8.43-17.28) ± 25%

Posición de soldadura: / Welding position(s): PH Rango Calif.: All except PG and PJ

Temperatura de precalentamiento: / Preheat temperature: 15 °C

Temperatura entre pasadas: / Interpass temperature: 200 °C

Post-calentamiento: / Postheat maintenance: -

Tratamiento térmico posterior al soldado: / Postweld heat treatment: -

Nombre del soldador: / Welder name: Carp Costel

Otra información: / Other information: El procedimiento objeto de este certificado es acorde con las disposiciones de la 2014/68/UE.

Certificamos que las soldaduras de ensayo han sido preparadas, soldadas y ensayadas satisfactoriamente de acuerdo con los requisitos del código/norma de ensayo arriba indicado.
We certify that the testing welds are prepared, welded and tested satisfactorily according with the code/norms specifications previously indicated.

Lugar/Place: Bucharest

Nombre de la Persona u Organismo examinado/Examiner or examining body: OCA GLOBAL INSPECCIONES REGLEMENTARIAS, S.A.U. (ON/NB: 0058)

Fecha de emisión: / Date: 07.10.2024

Firmado por: / Signed by: Inspector/O

7000-GEN-16.03 REV.01 06/23



OCA GLOBAL INSPECCIONES REGLEMENTARIAS, S.A.U.
Dirección de Delegación

Certificado Nº: 24-OCA-P-0348
Certificate No:

Fecha: / Date: 07.10.2024
Página: / Sheet: 2 de / of 3

REGISTRO DEL ENSAYO DE SOLDADURA

Detalles de la preparación de la soldadura (requerido) / Weld preparation details (mandatory)



Parámetros de soldadura / Welding parameters:

Pasada pos no.	Proceso de soldadura	Tamaño aporte Size electrode	Intensidad Current	Voltage Voltage	Corriente / polaridad Current mode / polarity	Vel. alm. vientos Throat feed speed	Velocidad avance Welding speed	Aporte térmico Heat input
1	111	2.5	70	25	DCEN (+)	-	5.35	15.70
2	111	3.2	105	23	DCEP (+)	-	7.27	15.94
3	111	3.2	205	23	DCEP (+)	-	6.73	17.28
4	111	2.5	75	24	DCEP (+)	-	9.08	9.52
5	111	2.5	75	24	DCEP (+)	-	10.25	8.43
6	111	2.5	75	24	DCEP (+)	-	9.65	8.95

Condiciones secado: / Drying conditions: 350 Degrees C / 2h

Gus/Fuente de soldadura: / Electrode: max. 3 x electrode diameter

(1) Protección: / Protection: -

(2) Respaldo: / Backing: -

Caudal del gas de soldadura: / Shielding gas flow rate: 15 l/min

Tiempo de calentamiento: / Preheat time: 15 °C

Temperatura de precalentamiento: / Preheat temperature: 200 °C

Temperatura entre pasadas: / Interpass temperature: -

Post-calentamiento: / Postheat maintenance: -

Fabricante: / Manufacturer: BVE Shipbuilding Service

Nombre de la Persona u Organismo examinado: / Examiner or examining body: OCA GLOBAL INSPECCIONES REGLEMENTARIAS, S.A.U. (ON/NB: 0058)

Firmado por: / Signed by: Inspector/O

Fecha: / Date: 07.10.2024

7000-GEN-16.03 REV.01 06/23



OCA GLOBAL INSPECCIONES REGLEMENTARIAS, S.A.U.
Dirección de Delegación

Certificado Nº: 24-OCA-P-0348
Certificate No:

Fecha: / Date: 07.10.2024
Página: / Sheet: 3 de / of 3

RESULTADOS DE LOS ENSAYOS / TEST RESULTS

Ensayos No Destructivos: / Non Destructive Testing:	Resultado / Result	Nº Informe / Report No.
Examen Visual: / Visual examination:	Accepted	24-OCA-VT-37
Líquidos Penetrantes/Part Magnéticas: Penetrant /Magnet Particle	Accepted	24/2024
Radiofrafado: / Radiographic testing:	Accepted	59/2024
Ensayo por Ultrasonidos: / Ultrasonic testing:	Accepted	59/2024

Ensayos de tracción / Tensile Tests								
Tipo/Nº Type/No.	Dimensiones Dimensions bxa [mm]	Área Area [mm2]	Límite elástico Elastic yield Re [N/mm²]	Tensión Ruptura Tensile strength Rm [N/mm²]	Alargamiento Elongation A %	2 %	Situación rotura Fracture location	Observaciones Observations
Oxigenios	-	-	-	490 - 650	-	-	-	-
T1	12 x 11.4	136.80	-	511	-	-	BM	Accepted
T2	12.4 x 11.6	143.84	-	506	-	-	BM	Accepted

Ensayos de doblado: / Bend Tests:				Diámetro del mandril: / Former diameter: 40			
Tipo/Nº Type/No	Ángulo doblado Bend angle	Alargamiento Elongation	Resultados Results	Tipo/Nº Type/No	Ángulo doblado Bend angle	Alargamiento Elongation	Resultados Results
11	180	-	Accepted	11	180	-	Accepted
12	180	-	Accepted	12	180	-	Accepted

Ensayo de Impacto: / Togness Test:							
Tipo/Nº Type/No	Localización entalla Notch location	Temperatura Ensayo Test temperature	Valores (E) / Values			Promedio Average	Observaciones Observations
1	VWT	-50	42	94	31	56	Accepted
2	VHT		43	75	99	72	Accepted
Tipo Entalla/Notch type:		Tamaño/Size:	Requisitos/Requirements:				

Tipo Entalla/Notch type: KV Tamaño/Size: 7.5 x 10 Requisitos/Requirements: 30 J

Ensayo de dureza: / Hardness Test:		Valores / Values					
Carga(s) / Load(s)		Metal Base		TS	Indicador	TS	Metal Base
No. of Reps							
1		172, 176, 167	199, 211, 196		215, 212, 197	195, 188, 207	163, 170, 168
2		164, 165, 169	183, 182, 190		194, 191, 190	206, 208, 193	166, 165, 177

Análisis Químico: / Chemical analysis:											
Tipo/Nº Type/No.	C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al	Ti
P355N12	0.17	1.19	0.23	0.013	0.003	0.08	0.08	0.02	0.24	0.025	0.001

Examen Macrográfico: / Macro-examination Test: Accepted acc. to report no. 779/2024

Otros ensayos: / Other Test: *Chemical composition acc. to inspection certificate no. 13639

Ensayos Revisados a cabo de acuerdo con los requisitos de: / Tests carried out according to the requirements of: UNE EN ISO 15614-1:2018

Ensayos dirigidos por: / Test conducted by: Bucneru Claudia

Laboratorio: / Laboratory: Welding Technology Center

Lugar / Place: Bucharest, Romania

Nombre de la Persona u Organismo examinado: / Examiner or examining body: OCA GLOBAL INSPECCIONES REGLEMENTARIAS, S.A.U. (ON/NB: 0058)

Fecha de emisión: / Date: 07.10.2024

Firmado por: / Signed by: Inspector/O

7000-GEN-16.03 REV.01 06/23

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Welding procedure Certifications



OCA GLOBAL INSPECCIONES REGLEMENTARIAS, S.A.U.
Dirección de Delegación

Certificado Nº: 24-OCA-P-0345
Certificator No:

Fecha / Date: 07.10.2024
Página / Sheet: 1 de / of 3

REGISTRO DE CUALIFICACIÓN DE PROCEDIMIENTO SOLDEO WELDING PROCEDURE QUALIFICATION RECORD (WPQR)

CUALIFICACIÓN DEL PROCEDIMIENTO DE SOLDEO - CERTIFICADO DEL ENSAYO
WELDING PROCEDURE APPROVAL - TEST CERTIFICATE

Fecha de soldo: 05.09.2024
Date of welding:

Nº WPFS Fabricante: 14104 Rev. 0 Nº PQR: BVE04
Manufacturer WPFS No: Rev. PQR No:

Fabricante / Manufacturer: BVE Shipbuilding Service
Dirección / Address: Strada Stupinel nr.3, Cam 3, Lasiu

Código/norma de ensayo / Code/Testing standard: UNE EN ISO 15614-1:2018

Rango de cualificación / Range certified: 141

Proceso(s) de soldo(s) / welding process(es) and type(s):

Tipo de unión y de soldadura: / Joint and weld type: BW, FW

Grupo(s) o subgrupo(s) del material de base: / Parent Metal Group: 8.1 - 8.1

Espesor del material base (mm) / Thickness (mm): 5.08 Rango Calificado: 3 x 10.16

Espesor del metal de soldadura (mm) / Thickness weld metal (mm): 5.08 Rango Calificado: BW: max. 10.16

Espesor de garganta (mm) / Throat (mm): BW: a no restriction

Pasada simple/multipasada (por lado) / Multiple or single pass (per side): ml

Diámetro exterior del tubo (mm) / Pipe outside diameter (mm): 48.26 Rango Calif.: > 24.13

Marca, Tamaño y Designación del material de aportación: / Trade name, Size and Specification of Filler metal: OK Tigrod 316LSi, EN ISO 14343-A: W 12 3 1 Si

Designación gas de protección/fundente: / Shielding gas designation: I1

Designación del gas de respaldo: / Backing gas designation: I1

Tipo de corriente de soldo y polaridad: / Current type and polarity: DCEN (-)

Modo de transferencia del metal: / Mode of metal transfer: -

Aporte térmico (J) / Heat input (J): no restriction

Posiciones de soldo: / Welding position(s): PH Rango Calif.: All except PG and PI

Temperatura de precalentamiento: / Preheat temperature: 15 °C

Temperatura entre pasadas: / Interpass temperature: 100 °C

Post-calentamiento: / Postheat maintenance: -

Tratamiento térmico posterior al soldo: / Postweld heat treatment: -

Nombre del soldador: / Welder name: Monica Petrica

Otra información: / Other information: El procedimiento objeto de este certificado se acorde con las disposiciones de la 2014/68/EU.

Another information: The subject procedure of this certificate is accordance with the arrangements of the 2014/68/EU.

Certificamos que las soldaduras de ensayo han sido preparadas, soldadas y ensayadas satisfactoriamente de acuerdo con los requisitos del código/norma de ensayo arriba indicado.
We certify that the testing welds are prepared, welded and tested satisfactorily according with the code/norma specifications previously indicated.

Legar/Place: Bucharest

Nombre de la Persona u Organismo examinador/Examiner or examining body: OCA GLOBAL INSPECCIONES REGLEMENTARIAS, S.A.U. (ON/Nº: 0058)

Fecha de emisión: 07.10.2024

Firmado por: Inspector/a

7620-GEN-16-03 REV 01 06/23



OCA GLOBAL INSPECCIONES REGLEMENTARIAS, S.A.U.
Dirección de Delegación

Certificado Nº: 24-OCA-P-0345
Certificator No:

Fecha / Date: 07.10.2024
Página / Sheet: 2 de / of 3

REGISTRO DEL ENSAYO DE SOLDADURA Details of the preparation of the weld (preparation)

Detalle de la unión / Joint Design:



Perímetros de soldo: / Welding parameters:

Pasada por soldo	Proceso de soldo	Tamaño aporte	Intensidad	Voltage	Corriente / polaridad	Vál. adm. alambre	Velocidad avance	Aporte térmico
Proceso	Proceso	(mm)	(A)	(V)	(A) / (polaridad)	(mm/min)	(mm/min)	(J/mm)
TC24-04A-1	141	2.0	75	10.2	DCEN (-)	-	2.50	11.02
TC24-04A-2	141	2.0	80	10.4	DCEN (-)	-	5.60	5.35
TC24-04A-3	141	2.0	80	10.4	DCEN (-)	-	4.28	7.00
TC24-04B-1	141	2.0	75	10.2	DCEN (-)	-	2.80	9.84
TC24-04B-2	141	2.0	80	10.4	DCEN (-)	-	4.30	6.97
TC24-04B-3	141	2.0	80	10.4	DCEN (-)	-	4.85	6.18
TC24-04C-1	141	2.0	75	10.2	DCEN (-)	-	2.52	10.93
TC24-04C-2	141	2.0	80	10.4	DCEN (-)	-	4.22	7.10
TC24-04C-3	141	2.0	80	10.4	DCEN (-)	-	4.26	7.03

Condiciones secado: / Drying conditions: max. 7 mm

Ubicación (máximo de pasadas): / Location (maximum number of passes):

Detalle del código pulido: / Detail of the code polished: (ml)

Distancia del tubo de contacto a la placa: / Distance from the tube of contact to the plate:

Detalle del tubo de contacto a la placa: / Detail of the tube of contact to the plate:

Ángulo de la pistola: / Angle of the torch:

Detalle del resaca/respaldo: / Detail of the back/reinforcement:

Tratamiento térmico posterior: / Postweld heat treatment:

Temperatura de precalentamiento: / Preheat temperature: 15 °C

Temperatura entre pasadas: / Interpass temperature: 100 °C

Post-calentamiento: / Postheat maintenance: -

Fabricante: BVE Shipbuilding Service

Nombre de la Persona u Organismo examinador: OCA GLOBAL INSPECCIONES REGLEMENTARIAS, S.A.U. (ON/Nº: 0058)

Firmado por: Inspector/a

7620-GEN-16-03 REV 01 06/23



OCA GLOBAL INSPECCIONES REGLEMENTARIAS, S.A.U.
Dirección de Delegación

Certificado Nº: 24-OCA-P-0345
Certificator No:

Fecha / Date: 07.10.2024
Página / Sheet: 3 de / of 3

RESULTADOS DE LOS ENSAYOS / TEST RESULTS

Ensayos No Destructivos / Non Destructive Testing:	Resultado / Result	Nº Informe / Report No.
Examen Visual: / Visual Examination	Accepted	24-OCA-VT-38
Líquidos Penetrantes/Part Magneticas: Penetrant T, Mag-Particle	Accepted	24-OCA-PT-38
Radiografía: / Radiographic testing	Accepted	2454
Ensayo por Ultrasonido: / Ultrasonic testing	-	-

Ensayos de Tensión / Tensile Test:	Dimensiones / Dimensions	Área / Area	Límite elástico / Elastic yield	Tensión Rotura / Tensile strength	Alargamiento / Elongation	2 %	Situación rotura / Fracture location	Observaciones / Observations
Tipo/Nº	Dimensiones / Dimensions	Área / Area	R _e [N/mm²]	R _m [N/mm²]	A %	2 %		
T1	6.5 x 5.5	35.75	558	558	15	15	BM	Accepted
T2	5.5 x 5.5	30.49	577	577	15	15	BM	Accepted

Ensayos de Doblado / Bend Test:	Ángulo doblado / Bend angle	Alargamiento / Elongation	Resultados / Results	Tipo/Nº	Ángulo doblado / Bend angle	Alargamiento / Elongation	Resultados / Results
T1	180	150	Accepted	T2	180	150	Accepted

Ensayos de Impacto / Impact Test:	Temperatura Ensayo / Test temperature	Valores (J) / Values	Promedio / Average	Observaciones / Observations
Tipo/Nº	Temperatura Ensayo / Test temperature	1	2	3
T1	10	10	10	10
T2	10	10	10	10

Ensayos de Dureza / Hardness Test:	Lineas de ensayo / No of tests	Valores / Values	Promedio / Average	Observaciones / Observations
Tipo/Carácter / Type/Character	Lineas de ensayo / No of tests	Valores / Values	Promedio / Average	Observaciones / Observations
T1	1	1	1	1
T2	1	1	1	1

Análisis Químico: / Chemical analysis:	C	Mn	Si	P	S	Cr	Ni	Mo	Cu	Al	Ti
1.4404	0.017	1.55	0.49	0.038	0.006	16.66	10.02	2.02	-	-	-

Examen Macrográfico: / Macro-examination Test: Accepted acc. to report no. 776/2024

Otros ensayos: / Other Test: *Chemical composition acc. to inspection certificate no. STU/EXO/2023-2024/121/6

Ensayos llevados a cabo de acuerdo con los requisitos de: UNE EN ISO 15614-1:2018

Ensayos dirigidos por: Bucneru Claudiu

Laboratorio: / Laboratory: Welding Technology Center

Lugar / Place: Bucharest, Romania

Nombre de la Persona u Organismo examinador: OCA GLOBAL INSPECCIONES REGLEMENTARIAS, S.A.U. (ON/Nº: 0058)

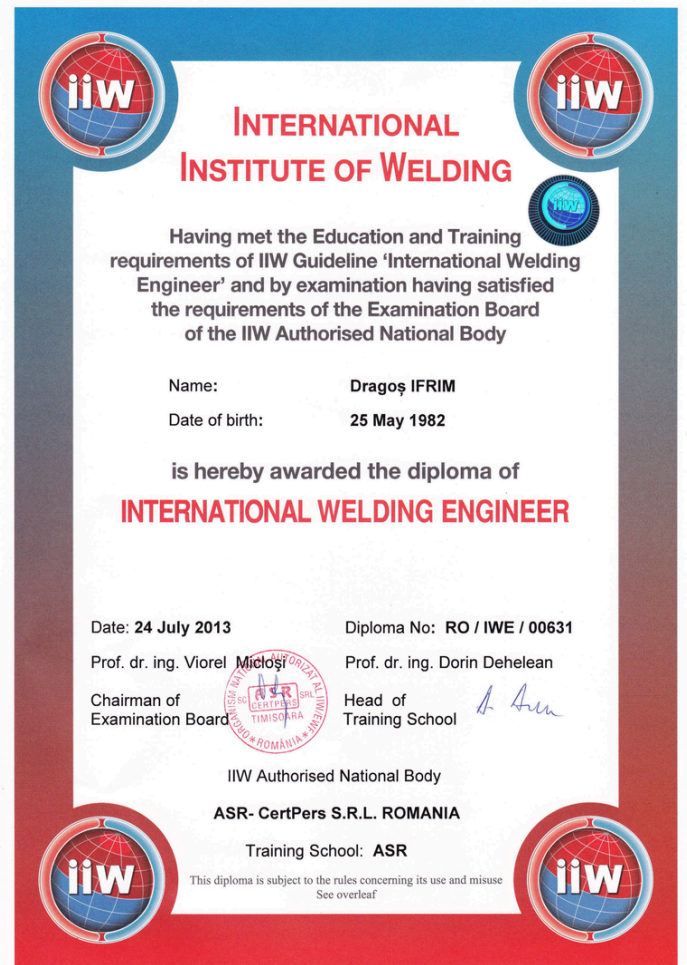
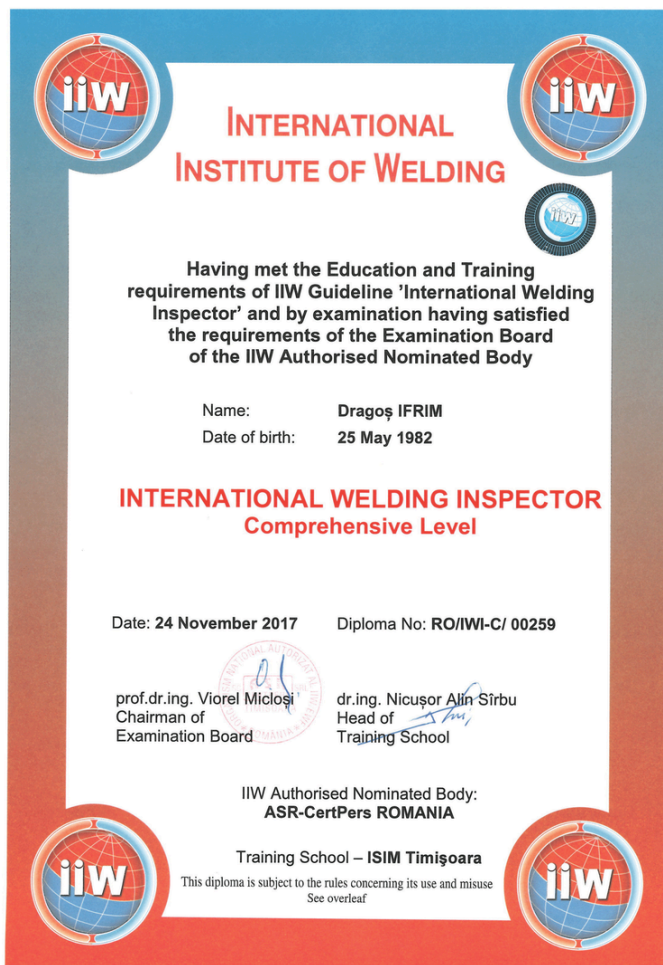
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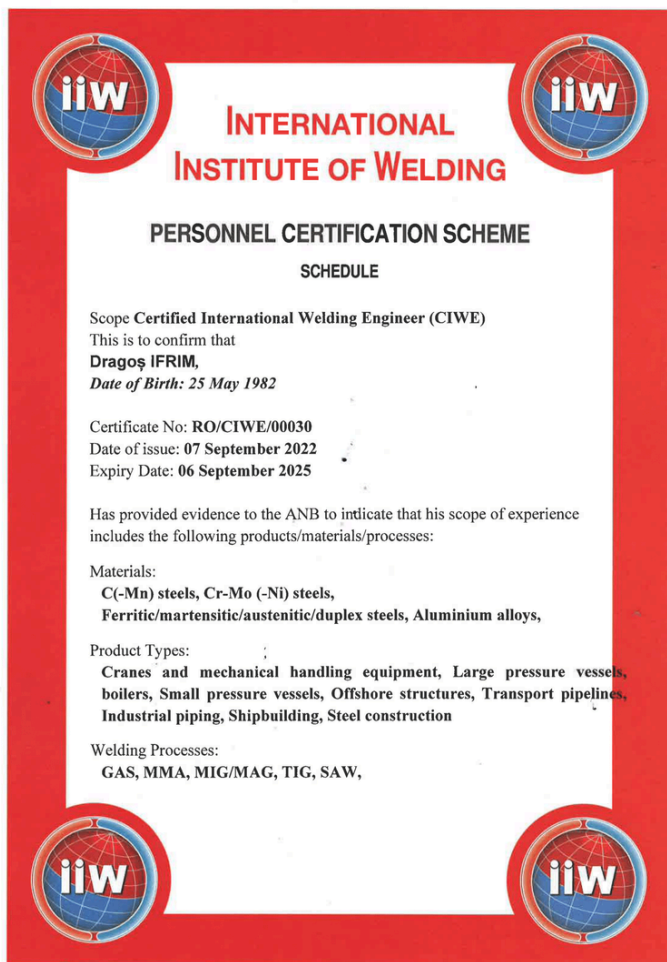
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Specialist Certifications

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ADEVERINȚĂ

Prin prezenta se adeverește că domnul IFRIM Dragoș, născut în anul 1982, luna mai, ziua 25, în Constanța, a participat și a promovat examenul la cursul „Cerințe de calitate pentru producătorii de structuri sudate conform EN ISO 3834” organizat de către S.C. TUV AUSTRIA România S.R.L., în perioada 27.05 – 28.05.2021, online.

Prezenta adeverință este valabilă până la emiterea certificatului de absolvire de către S.C. TUV AUSTRIA Romania S.R.L.

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Întocmit,
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Director General
Fulga Doru

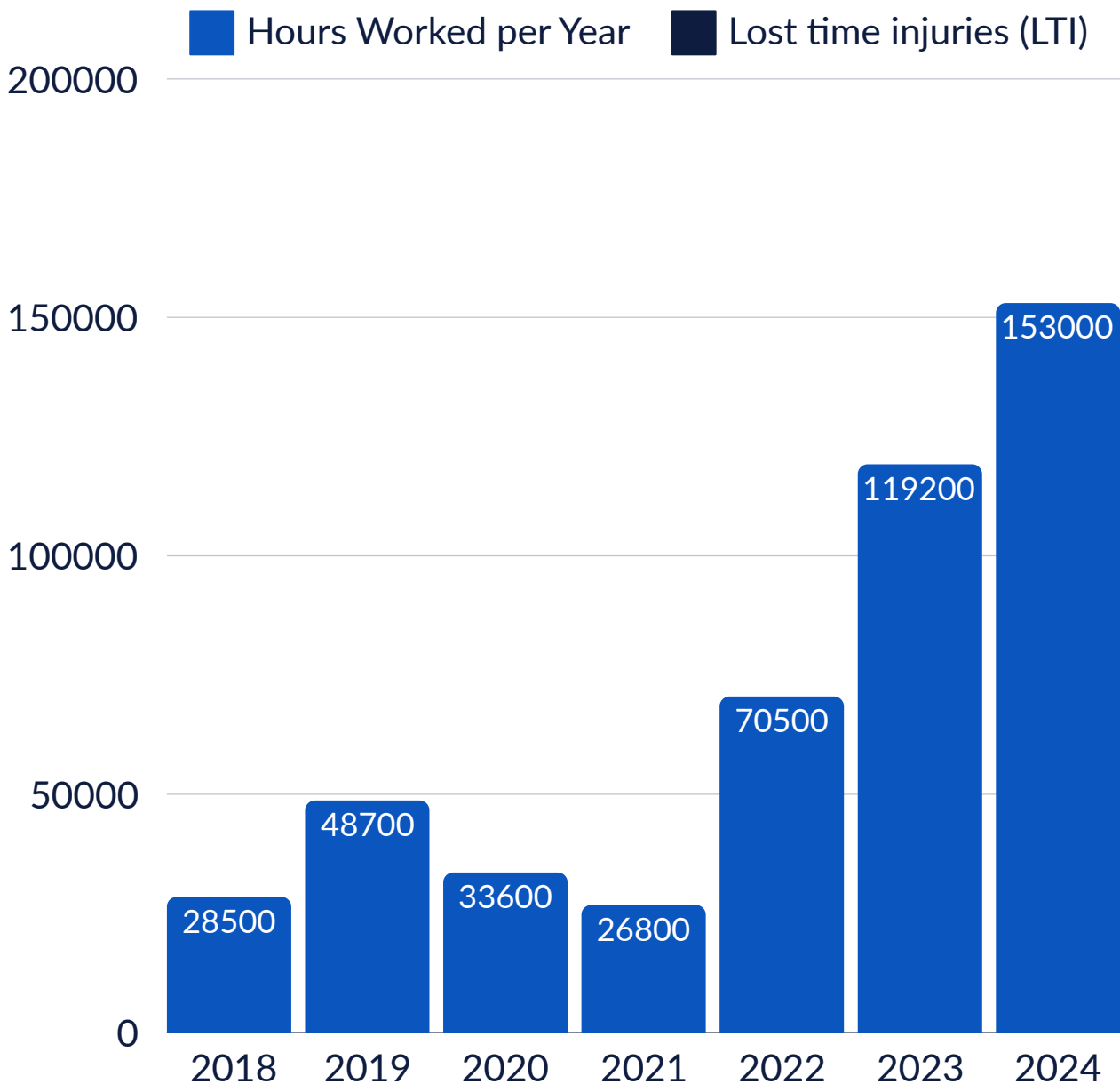


Nr. 38 Data eliberării: 28.05.2021

QFO-ADMIN-001-002 Rev 00

Hours Worked

Approximate hours worked per year over recent years up to November 2024



Safety Incidents

LOST TIME INJURIES

ZERO

INCIDENTS

ZERO

TRIR

ZERO

With hundreds of thousands of hours worked, we're proud to have maintained a flawless safety record – Zero injuries and zero safety concerns over the years.

Resources Available

(MAN*H/MONTH)	COUNTRY	STEEL TONS TO REPLACE/MONTH	
5000 man*h/month	ROMANIA	40t/month	REPAIR/REPLACEMENT
2500 man*h/month	NETHERLANDS	50t/month	CONSTRUCTION
10.000 man*h/month	GERMANY	70t/month	CONSTRUCTION/ REPAIR/REPLACEMENT



Repair and replacement work generally takes twice as long due to the complexity of removing old material and the nature of the tasks. In contrast, new construction is significantly more efficient, being 2-3 times faster on average.

Our main Clients

Our valued clients trust us to deliver quality and expertise, and we're proud to support their success.



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Our Plans for 2025

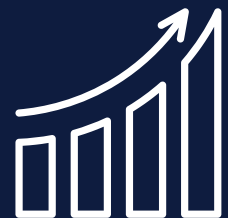
In 2025, we are actively pursuing additional certifications and authorizations to elevate our quality and safety standards even further. Our employees are already certified through top-tier organizations like Bureau Veritas, reflecting our commitment to delivering the highest level of service.



- ISO 3834-2
- ISO 14001
- ISO 45001

Clients can expect increased resources, as our facility will deliver thousands of work hours per month, supported by enhanced efficiency and an expanded workforce. This will enable us to manage more complex projects and exceed industry demands.

- +12 active employees
- + ~ 2.000 man*h/month
- +20t/month





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