

WELDER APPROVAL CERTIFICATE
ACCORDING TO UNI EN ISO 9606-1:2013



No. **15VE00454PO17**

Designation	UNI EN ISO 9606-1 141/135-P T BW FM5/FM5 S/S t5.5 D60 PA ss nb		
Welder	QUARGNAL TIZIANO		
Born in	MONFALCONE (GO)	on	02/09/1975
Identification	QRGTZN75P02F356Z	Method of Identification	C.F. Stamp No. QT
Employed by	TECNO WELDING FRIULI - CERVIGNANO DEL FRIULI (UD)		

WPS used by welder during welding of test coupon: **06/2015**

Job knowledge: **not tested**

Welding variables	Test piece	Range of qualification
Welding process(es)	141 / 135-P	141; 142; 143; 145 / 135; 138
Transfer mode	Pulsed-arc	Spray, globular and pulsed-arc
Product type	Pipes	Plates and pipes
Type of weld	BW	Butt weld*
Parent Metal group (ISO/TR 15608)	8	1 to 11
Filler material group(s)	FM5	FM5
Filler material type	141	Root: Solid rod Fill/Cap: Solid rod/ metal-cored rod/No filler metal
	135-P	Solid wire/electrode core: M
Shielding gas (EN ISO 14175)	I1 / M12	All compatible
Type of current and polarity	141: DC EN; 135-P: DC EP	All compatible
Deposited thickness (mm)	5.5	141: 3 to 6 135-P: 2,50 to 5
Pipe outside diameter (mm)	60	141 / 135-P: 3 to 11 30 and over
Welding position(s)	PA	PA
Weld details / Layer technique	ss nb	141: ss nb, ss mb, bs, ss gb, ss fb 135-P: ss mb, bs

*Qualify also branch connections with an angle >= 60°

Type of test							
Visual	Acceptable	Radiographic	Not tested	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Not tested	Fracture	Acceptable	Bend	Not tested		

This certificate is valid until

22 May 2018

Issued at

GENOVA

on

22 May 2015

This certificate consist of 2 pages

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