



PROCEDURE QUALIFICATION RECORD (PQR)

AWS D1.1/D1.1M
PQR n. **QPR-ITA-19-
00076-rev.0**
Date 29/10/2019
Supp. WPS **WT 107/19**

Company name **San Michele srl – via ai campi 20/24, 23881 Airuno (LC) - Italy**

BASE METALS	Specification	Type & Grd.	AWS Gr. No.	BASE METAL THICKNESS	
Base Material	EN 10025-2	S275 JR	-	CJP Groove Welds	-
Welded to	EN 10025-2	S275 JR	-	PJP Groove Welds	-
Backing Material	Yes, base material			Fillet Welds	t₁ = 25 [mm]; t₂ = 12 [mm]
Other				Diameter	-

JOINT DETAILS		Sketch
Groove Type	FW - Fillet Weld	
Groove Angle	90°	
Root Opening	-	
Root Face	-	
Backgouging	-	
Method	-	
POST-WELD HEAT TREATMENT (PWHT)		
Temperature	n.a.	
Time at Temperature	n.a.	
Other		

PROCEDURE					
Weld Pass(es)	1	2	3	4	
Process	GMAW		GMAW		
Type	Semiautomatic		Semiautomatic		
Position	2F		2F		
Vertical progression	n.a.		n.a.		
Filler Metal (AWS spec.)	A5.18		A5.18		
AWS Classification	ER70S-6		ER70S-6		
Diameter [mm]	1.2 [mm]		1.2 [mm]		
Manufacturer/Trade Name	SAFILO 128 CA2		SAFILO 128 CA2		
Shielding gas composition	Ar+CO ₂ +O ₂ (96+3+1)%		Ar+CO ₂ +O ₂ - (96+3+1)%		
Flow Rate	16 – 17 [l/min]		16 – 17 [l/min]		
Nozzle size	19 [mm]		19 [mm]		
Preheat Temperature	10°C min		10°C min		
Interpass Temperature	-		250°C max		
Electrical Characteristics					
Current Type & Polarity	DC – EP		DC – EP		
Transfer Mode(GMAW)	Spray Arc		Spray Arc		
Amps	300	300	300	300	
Volts	25	25	25	25	
Wire feed speed	-		-		
Travel speed	280 mm/min	320 mm/min	320 mm/min	320 mm/min	
Maximum heat input	-		-		
Technique					
Stringer or Weave	Stringer		Stringer		
Multi or Single Pass (per side)	Single pass		Multi pass		
Oscillation	n.a.		n.a.		
Number of electrode	Single electrode		Single electrode		
Contact tube to work dist.	12-18 [mm]		12-18 [mm]		
Peening	n.a.		n.a.		