

1 WT 0014-19 CERTIFICATO QUALIFICA SALDATORE Page 1
 2 Designation EN ISO 9606-1 **135 S PFW FMI S t30,00 PB ml ml**
 3 Manufacturer's Welding Procedure Specification Insp. Authority: E.Riva EWT 30125
 4 Reference No. : **WPS WT 55-19**
 5 Welder's Name : **Osvaldo Bianchi**
 6 Identification : **OB**
 7 Method of Identification : Identity Card Photograph
 8 Date and Place of Birth : 10/11/1969 - Galliate (NO)
 9 Employer : **SAN MICHELE S.r.l - Via ai Campi 20,24 - Airuno (LC)**
 10 Code / Testing Standard : EN ISO 9606-1 (required)
 11 Remark
 12 Job Knowledge : Not tested

	Weld Test Details	Welding Position of Approval
13 Welding Process	135	135-138
14 Transfer mode	Spray transfer	Globular, spray transferred transfer
15 Plate or Pipe	P-plate	P,T
16 Joint type	FW	FW
17 Parent Metal (Group)	1.2	
18 Filler Material (Group)	FMI	FMI, FM2
19 Filler Metal (Type)	Solid (S)	(S), Metal Cored M)
20 Shielding gas	EN ISO 14175: MI	All similar group
21 Gas backing	n.a.	n.a.
22 Auxiliaries	n.a.	n.a.
23 Type of current		/
24 Type of polarity		/
25 Mat. Thk: (mm)	30,000	≥ 3
26 Deposited thickness s (mm)		/
27 Pipe Outside dia. (mm)	Na	≥ 75 mm
28 Welding Positions		PA,PB
30 Weld details	ml	ml-sl
31 Layers for fillet weld		ml-sl

Additional information is available on attached sheet and / or welding procedure specification No. : WPS WT 55-19

Type of Test	Performed and acceptable	Not required
Visual	X	
Radiography		X
Mag. partic./Pe		
Macro-/microsectio		
Fracture		X
Bend		X
Additional Tests		X

Date of Issue : 07/05/2019
 Location : Airuno (LC)
 Validity of approval until : 06/05/2022



Manufacturer		E.Riva EWT 30125 Weld & Tests s.r.l.
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Revalidation 9.3 (a)
 Revalidation 9.3 (b)
 Revalidation 9.3 (c)