



RINA



SGQ N° 002 A SSI N° 001 G
SGA N° 002 D DAP N° 001 H
PRD N° 002 B PRS N° 006 C
SCR N° 003 F LAB N° 0832

Signatory of EA, IAF and ILAC
Mutual Recognition Agreements

WELDING PROCEDURE QUALIFICATION RECORD (WPQR)

N. 12FI00260PO2/A

Manufacturer CEDRONE OLEODINAMICA SRL

WPQR No. 02/12-A

Dated 28/9/2012

Manufacturer's welding procedure (WPS) No. 02/12

Dated 6/9/2012

RANGE OF APPROVAL

Welding process	141	Type	Manual
Joint type	Bar to coupling fillet weld (see sketch)		
Single/Multiple pass	Single		
Parent material group(s)	8-8 (Subgroup 8.1 only)	ISO/TR 15608	
Parent material thickness (mm)	Fillet Joint $t_1 = 6,65$ to $26,6$ (bar) $t_2 = 3$ to 10 (coupling)		
Throat thickness (mm)	1,5 to 3		
Weld deposit thickness (mm)	N.A.		
Outside diameter (mm)	D1 $\geq 62,5$ (bar); D2 12,5 to 50 (coupling)		
Filler metal type	Solid wire EN 14343-A: W 19 12 3 L		
Shielding gas (ISO 14175)	II	Backing gas (ISO 14175)	N.A.
Type of welding current	DCEN	Heat input KJ/cm	no restriction
Welding position	PB		
Preheat min. (°C)	10	Interpass temp. Max. (°C)	N.A.
Post weld heat treatment / Ageing	None		
Other information	-		

Welders name

Stamp No. MA

Welding test conducted by CEDRONE OLEODINAMICA SRL

Mechanical test conducted by TECNOLAB – Civitavecchia (RM) Laboratory test No. dated

At presence of RINA Surveyor M. Arecco

We certify that statements in this certificate are correct and that the test welds were prepared, welded and tested in accordance with the requirements of UNI EN ISO 15613: 2004 Standard

Issued at: GENOVA

on 17 October 2012



RINA Services S.p.A.