

**WELDER, WELDING OPERATOR
OR TACK WELDER
QUALIFICATION TEST RECORD**

WPQR-N. GC0124/11
IIS Job N. C00000825



Company Name COMERI COSTRUZIONI MECCANICHE SRL - VIA FRIULI,8 - 29017 FIOREZZUOLA
Welder's name D'ARDA (PC) **Clock Number** -- **Stamp No.** NA
Welding procedure specification NOURDDINE ABDERRAZAK 115 REV.0

Variables	Used in Qualification	Qualification range
Welding Process(es) [Table 4.12 Item (1)] Type GMAW transfer mode	GMAW Semiautomatic Spray Arc	GMAW Semiautomatic Spray Arc
Electrode [Table 4.12 Item (7)]	<input type="radio"/> Single <input type="radio"/> Multiple <input checked="" type="radio"/> NA	NA
Current / Polarity	DCEP	DCEP
Welding position [Table 4.12 Item (3)] Progression (uphill/downhill) [Table 4.12 Item (5)]	1G <input type="radio"/> Up <input type="radio"/> Down <input checked="" type="radio"/> NA	Production plate CJP, PJP Groove F, Fillet F-H; Production pipe (over 600mm) and production box tube butt CJP, PJP F with backing or backgouging, T-Y-K PJP with backing or backgouging Fillet F-H
Backing [Table 4.12 Item (6)]	<input checked="" type="radio"/> Yes <input type="radio"/> No welded from both sides	with
Base Material	EN 10025 - S355J2G3	EN 10025 S355J2G3
Thickness [Table 4.12]	<input checked="" type="checkbox"/> Plate <input type="checkbox"/> Pipe <input type="checkbox"/> Tube <input checked="" type="radio"/> Groove <input type="radio"/> Fillet 30mm	3unlimited; Fillet: unlimited Also qualifies plug and slot weld
Diameter [Table 4.12]	<input type="radio"/> Groove <input type="radio"/> Fillet <input checked="" type="radio"/> NA NA	Groove: over 600mm (24")
Filler metal [Table 4.12] Specification No Class.	AWS A5.28 ER100S-G	AWS A5.28 ER100S-G
F-No [Table 4.12 Item (2)]	NA	NA
Gas/Flux type	Ar - CO2	Ar - CO2
Other	NONE	NONE

VISUAL INSPECTION (4.9.1)

Test result: Acceptable Not Acceptable Remarks:

GUIDED BEND TEST (4.31.5)

Guided Bend Test Type	Results	Guided Bend Test Type	Results
FIGURE 4.13	180° SATISFACTORY		
FIGURE 4.13	180° SATISFACTORY		

FILLET WELD TEST (4.31.2.3 e 4.31.4.1)

Appearance		Fillet size	
Fracture test root penetration		Macrotech	

RADIOGRAPHIC TEST (4.31.3.2)

Film Id. Number	Results	Remarks	Film Id. Number	Results	Remarks

Interpreted by: Arleo Gianni Test No. 183108
 Organization: Italian Institute of Welding Date 05/06/2008

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded and tested in conformance with the requirements of section of AWS D1.1/D1.1M (2010).

Date 05/09/2011

Test supervised by Italian Institute of Welding
 CERTIFICATION AREA CSP

Arleo Gianni

Manufacturer
 (Stamp and Signature)

COMERI COSTRUZIONI MECCANICHE s.r.l.
 SOCIETA' A PERSONALE