

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

**WPQR-N.** GC0125/11  
**IIS Job N.** C00000825



**Company Name** COMERI COSTRUZIONI MECCANICHE SRL - VIA FRIULI,8 - 29017 FIOREZZUOLA  
**Welder's name** D'ARDA (PC)  
**Welding procedure specification** NOURDDINE ABDERRAZAK  
**Clock Number** -- **Stamp No.** NA  
 CO 03/11 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"/> <input type="radio"/> <input checked="" type="radio"/>	NA
Current / Polarity	DCEP	DCEP
Welding position [Table 4.12 Item (3)] Progression (uphill/downhill) [Table 4.12 Item (5)]	1G <input type="radio"/> <input type="radio"/> <input checked="" type="radio"/>	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"/> <input type="radio"/> welded from both sides	with
Base Material	WELDOX 700 -	WELDOX 700
Thickness [Table 4.12]	<input checked="" type="radio"/> <input type="radio"/> <input type="radio"/> 30mm	3unlimited; Fillet: unlimited Also qualifies plug and slot weld
Diameter [Table 4.12]	<input type="radio"/> <input type="radio"/> <input checked="" type="radio"/> 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. 183208  
 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' UNIPERSONALE