

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

WPQR-N. GC0126/11
IIS Job N. C00000825



Company Name

COMERI COSTRUZIONI MECCANICHE SRL - VIA FRIULI,8 - 29017 FIORENZUOLA
D'ARDA (PC)

Welder's name

NOURDDINE ABDERRAZAK
CO 04/11 REV.0

Welding procedure specification

Clock Number --

Stamp No. NA

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	WELDOX 700 to - EN 10025 S355J2G3	WELDOX 700 to 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	Unlimited; 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	

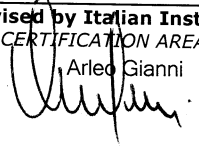
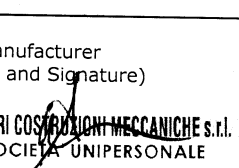
RADIOGRAPHIC TEST (4.31.3.2)

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

Interpreted by: Arleo Gianni Test No. 183008
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 D 1.1/D1.1M (2010).

Date 05/09/2011

<p>Test supervised by Italian Institute of Welding CERTIFICATION AREA CSP Arleo Gianni</p> 	<p>Manufacturer (Stamp and Signature) COMERI COSTRUZIONI MECCANICHE s.r.l. SOCIETA' UNIPERSONALE</p> 
---	---