

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

**WPQR-N.** GC0127/11  
**IIS Job N.** C00000825



**Company Name** COMERI COSTRUZIONI MECCANICHE SRL - VIA FRIULI,8 - 29017 FIORENZUOLA  
**Welder's name** D'ARDA (PC)  
**Welding procedure specification** NOURDDINE ABDERRAZAK  
CO 06/11 REV.0

**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 Short & Spray Arc	GMAW Semiautomatic Short & Spray Arc
Electrode [Table 4.12 Item (7)]	○ ○ ●	NA
Current / Polarity	DCEP	DCEP
Welding position [Table 4.12 Item (3)] Progression (uphill/downhill) [Table 4.12 Item (5)]	1G ○ ○ ●	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)]	○ ● NA	with and without where applicable
Base Material	EN 10210 - S355J2H(Similar to the steels pertaining Group II)	EN 10210 S355J2H(Similar to the steels pertaining Group II)
Thickness [Table 4.12]	□ □ ⊗ ● ○ 10mm	3÷20; Also qualifies for welding any Fillet or PJP weld size on any thickness og plate, pipe or tubing
Diameter [Table 4.12]	○ ○ ● 130mmOD	100 unlimited
Filler metal [Table 4.12] Specification No Class.	AWS A5.28 ER70S-6	AWS A5.28 ER70S-6
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. 183308  
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