



RINA

SINCERT

ACCREDITAMENTO ORGANISMO DI CERTIFICAZIONE ESPERTISSE

SGQ N° 002A - SGA N° 002D  
PRD N° 002B - PRS N° 006C  
SCR N° 003F - SSI N° 001G

Membro degli Accordi di Mutuo Riconoscimento EA e IAF  
Signatory of EA and IAF Mutual Recognition Agreements

WELDING PROCEDURE QUALIFICATION RECORD (WPQR)

N. 09FI00132PO2/A

Manufacturer STAR DIESEL 2001 S.r.l. - JESI (AN)  
WPQR No. 02/SD Dated 12-01-2010  
Manufacturer's welding procedure (WPS) No. 02SD Rev.0 Dated 16-12-2009

RANGE OF APPROVAL

Welding process 111 Type Manual  
Joint type Plates and Pipes BW ssnb-ssmb-bs/FW  
Single/Multiple pass Multiple  
Parent material group(s) 1-1 (subgroup 1.1 only) ISO/TR 15608  
with specified minimum Rs ≤ 275 Mpa  
Parent material thickness (mm) Butt Joint = 3 to 24 Fillet Joint t<sub>1</sub> = 6 to 14,4 t<sub>2</sub> = 6 to 14,4  
Throat thickness (mm) No restriction  
Weld deposit thickness (mm) 3 to 24  
Outside diameter (mm) Over 150  
Filler metal type Covered electrode AWS A 5.1 E7016-1 \*  
Shielding gas (ISO 14175) N.A. Backing gas (ISO 14175) N.A.  
Type of welding current DCEP Heat input Kj/cm Max. 37,5  
Welding position All, vertical down excluded  
Preheat min. (°C) 20 Interpass temp. Max. (°C) 250  
Post weld heat treatment / Ageing None  
Other information \*EN classification not available at Manufacturer

Welders name SCARCIGLIA TEODORO Stamp No. ST  
Welding test conducted by STAR DIESEL 2001 S.r.l.  
Mechanical test conducted by TECNOLAB RINA IIS Laboratory test No. TEC06  
At presence of RINA Surveyor D. ERANIO

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 15614-1: 2008 Standard

Issued at: GENOVA

on 16 Febbraio 2010

RINA Services S.p.A.