



RINA

SINCERT

ACCREDITAMENTO PROCASSIMI UFFICIO CASORIA ESPRIZZANO

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. 09FI00132PO1/A

Manufacturer STAR DIESEL 2001 S.r.l. - JESI (AN)

WPQR No. 01/SD

Dated 12-01-2010

Manufacturer's welding procedure (WPS) No. 01SD Rev.0

Dated 16-12-2009

RANGE OF APPROVAL

Welding process 135 Type Partly mechanized

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 t₁ = 6 to 14,4 t₂ = 6 to 14,4

Throat thickness (mm) No restriction

Weld deposit thickness (mm) 3 to 24

Outside diameter (mm) Over 150

Filler metal type Solid rod EN 440: G3Si1

Shielding gas (ISO 14175) M21 with max. CO₂ % = 20 Backing gas (ISO 14175) N.A.

Type of welding current DCEP Heat input Kj/cm Max. 23,7

Welding position All, vertical down excluded

Preheat min. (°C) None Interpass temp. Max. (°C) 250

Post weld heat treatment / Ageing None

Other information ----

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. TEC05

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.





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SINCERT

ACCREDITAMENTO ORGANISMO DI CERTIFICAZIONE E ISPEZIONE

SGQ N° 002A - SGA N° 002D
PRD N° 002B - PRS N° 008C
SCR N° 003F - SSI N° 001G

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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 t₁ = 6 to 14,4 t₂ = 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

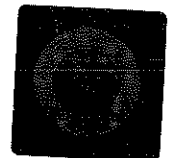
Laboratory test No. TEC06

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

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