1 **WELDING PROCEDURE QUALIFICATION RECORDS**

3 Manufacturer's Welding Procedure Specification — Inspection Company : **SGS Italia S.p.A.**
4 Reference No. : **29** — Reference No. : **WPQR PED.VE.878**

5 Manufacturer : **S.C. FIMARO S.A.**

6 Address : **Str. Corneliu Coposu, nr. 167, Cluj-Napoca, Jud. Cluj, Romania**

7 Code : Testing Standard : **EN ISO 15614-1:2004**

8 Date of Welding : **09.04.2009**

9 Range of Approval

10 Welding process : **135 (MAG) Partlymechanized**
11 Joint Type : **FW on plate and pipe**

12 Parent Metal Group(s) : **Group 1 (CR ISO 15608 Subgroup 1.1 & 1.2)**
to
Group 1 (CR ISO 15608 Subgroup 1.1 & 1.2)

13 Parent Material Thickness (mm) : **≥ 5,0**
Weld Metal Thickness (mm) : **NA**
14 Pipe Outside Diameter (mm) : **> 500 and plates; > 150 for PA**

15 Filler Metal Type/Designation : **Solid Wire / EN 440-1996: G 3 Si1**

16 Shielding Gas / Flux : **EN 439 : M21**

17 Type of Welding Current : **DCEP**
18 Welding Position : **PA - PB**
19 Preheat Temperature : **≥ 20 °C** — Interpass Temperature: **N.A.**
20 Post Weld Heat Treatment and/or Ageing : **None**
Branch connection angle alfa: **N.A.**

21 Other Information : **Heat Input : - 25%**
Fillet throat thickness : 6 mm
Metal transfer: short-arc

22 Certified that test welds prepared, welded and tested satisfactorily in accordance with the requirements of the code / testing standard indicated above.

Approved by: **Nogarin M.**
Notified Body N°: **1381**

23 Location : **Malcontenta (VE)-ITALY** Date of Issue : **22/04/2009** Issue by : **Toma Corneliu**

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