WELDING PROCEDURE QUALIFICATION RECORDS

3	Manufacturer's Welding Procedure Specification		Inspection Company :	**SGS Italia S.p.A.**
4	Reference No. :	**30**	Reference No. :	**WPQR PED.VE.879**
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:	**≤ 200°C**
20	Post Weld Heat Treatment and/or Ageing :	**None**		
	Branch connection angle alfa:	**N.A.**		
21	Other Information :	**Heat Input : - 25% Fillet throat thickness : No restriction 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**