Certificate no: Page 1 of 3

- / -

MLN1790519/02A

Welding Procedure Qualification Certificate

Examining body

Reference No:

(EN ISO 15614-1)

FOR02

ANTINONE Carmine (Stamp. AC) EN ISO 15614-1:2012

31 marzo 2017

FOR.TEC - FORNITURE TECNOLOGICHE - S.R.L.

VIA APPIA KM 186,900 - 81040 FRANCOLISE (CE)

Energy - Downstream, Power and Manufacturing

Manufacturer's Welding Procedure QualificationRecord No.:

Manufacturer: Address:

Welders Name

Code/Testing Standard: Date of Welding:

Range of Qualification

Welding Process(es): 135 (Partly Mechanized) Type of joint and weld: Butt weld on plate - (range of approval: Plates and pipes BW: bs/FW) Parent materialgroup(s) and sub-UNI EN 10025-2: 2005 S355J2 - Group 1.2 acc. to ISO/TR 15608 (Range of approval: Subgroup 1.1 to Parent Material Thickness (mm): 6,0 mm - (range of approval: 3.0 to 12.0) Weld Metal Thickness (mm): 6,0 mm - (range of approval: 3.0 to 12.0) Throat Thickness (mm) No restriction Single Run/Multi Run Multiple run N.A. - Range of approval: O.D. 150 and over (PA-PC rotated pos.), 500 and over(other positions) Outside Pipe Diameter (mm): EN ISO 14341-A: G 46 4 M21 3Si1 Filler Material Designation: Filler Material Make: UltraMag Filler Material Size: Ø 1.0 mm Designation of Shielding Gas/Flux: Argon 80%+20%CO2 (EN ISO 14175: M21) - (Range of approval: CO2 max 22%) Designation of Backing Gas: None Type of Welding Current and Polarity: DC EP Mode of Metal Transfer: Spray arc Heat Input: Min. 7.3 KJ/cm All (Vertical down excluded) Welding Positions: Preheat Temperature: 10°C 250°C Interpass Temperature: Post-Heating: None Post-Weld Heat Treatment and/or None

Other Information

Certified that test welds were prepared, welded and tested satisfactorily in accordance with the requirements of the code/testing standard indicated above. Location: FRANCOLISE (CE) Date of Issue: 09 maggio 2017

Surveyor	
S. Bottari	
Surveyor to Lloyd's Register EMEA	

A subsidiary of Lloyd's Register Group Limited

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Examining Body

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A subsidiary of Lloyd's Register Group Limited							1-1-1-	5	
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* As Required

MLN1790519/02A Certificate no: Page 3 of 3

Test Results											
Manufacturer's Welding Procedure Qualification Record No.: FOR02				Examin Referer	ing Body: Ice No:						
Visual Examination: Satisfactor		Satisfactory	/ - Report r	ո° 388/17	Radiog	raphy*:		Satisfactory - Report nº 387/17			
Penetrant/Magnetic Satisfacto		Satisfactory	ry - Report n° 389-17		Ultraso	Ultrasonic Examination*:			/		
Coloration Assessm	nent**:	N.A.									
Tensile Tests*											
Type/No	Re N/mm²	Rm N/mm²	A% or	n	Z%	Fracture	Location	Temperature:		Remarks	
Requirements	/	470 R ≶6	30 /		1	1		1		1	
503 TP1	1	582.1	1		/	Base metal		22 °C		Ductile fracture	
503 TP2 /		560.1 /			1	Base metal		22 °C		Ductile fracture	
Bend Tests [*]											
Type/No	Bend Angle		Former Diameter		5		Result				
503 TFBB1	180°		Ø 24 mm			N.A OK N.A OK					
503 TFBB2	180°		Ø 24 mm								
503 TRBB1 503 TRBB2	180° 180°		Ø 24 mm		N.A		OK				
	100		Ø 24 mm		N.A		ОК				
Macroscopic Exami	ination: Satisf	actory - Repo		9-17	N.A		OK				
Macroscopic Exami Microscopic Examir Impact Tests*	ination: Satisf	actory - Repo		9-17		x 5 x 55 m		quirement:	27 J min		
Macroscopic Exami Microscopic Examir	ination: Satisf nation: / Type: KV	actory - Repo 2		Values (J)	Size: 10 s			quirement: Average (J)	27 J min Remarl		
Macroscopic Exami Microscopic Examir Impact Tests[*]	ination: Satisfination: / Type: KV ection	actory - Repo 2	rt n° RP 52			x 5 x 55 m 3 86	m Re				

Hardness Tests* Other Tests: HV10 Type/Load: _ 179 Max. Values - Parent Metal: - H.A.Z.: 215 Max. Remarks _ 182 Max. - Weld Metal:

Location of Measurements (Sketch)^{*} see attached

Tests carried out in accordance with the requirements of:

Laboratory Report Reference No:

Test Results were acceptable

Test carried out in the presence of:

A. Fasanella

EN ISO 15614-1:2012

CTR LAB. - Report n° RP 529-17 dd02.05.17;387/17-388-17-389-17 dd13.04.17

Surveyor

S. Bottari

alato

Surveyor toLloyd's Register EMEA A subsidiary of Lloyd's Register Group Limited

Examining Body