



RINA



SGQ N° 002 A SSI N° 001 G  
SGA N° 002 D DAP N° 001 H  
FRD N° 002 B PRS N° 068 C  
SCR N° 003 F LAB N° 0032

Signatory of EA, IAF and ILAC  
Mutual Recognition Agreements

WELDING PROCEDURE QUALIFICATION RECORD (WPQR)

N. 16PA00547PO2/A

Manufacturer **CONDORELLI COSTRUZIONI SRL**  
WPQR No. **02/16** Dated **13/09/2016**  
Manufacturer's welding procedure (WPS) No. **02/16** Dated **27/09/2016**

RANGE OF APPROVAL

Welding process **135** Type **Partly mechanized**  
Joint type **Plates and Pipes FW**  
Single/Multiple pass **Single**  
Parent material group(s) **1-1** ISO/TR 15608  
with a specified minimum yield strength  $\leq 355$  MPa  
Parent material thickness (mm) **Butt Joint = N.A.** Fillet Joint  $t_1 = 3$  to **12**  $t_2 = 3$  to **12**  
Throat thickness (mm) **3,38 to 6,75**  
Weld deposit thickness (mm) **N.A.**  
Outside diameter (mm) **Over 150**  
Filler metal type **Solid wire UNI EN ISO 14341-A - G 42 4 M21 3Si1**  
Shielding gas (ISO 14175) **M21 with max. CO2 % = 22** Backing gas (ISO 14175) **None**  
Type of welding current **DCEP** Heat input kJ/cm **min. 6,15**  
Welding position **All positions, except vertical down**  
Preheat min. (°C) **20** Interpass temp. Max. (°C) **N.A.**  
Post weld heat treatment / Ageing **None**  
Other information **-**

Welders name **Condorelli Salvatore** Stamp No. **CS**  
Welding test conducted by **CONDORELLI COSTRUZIONI SRL**  
Mechanical test conducted by **S.S.M. Srl - GENOVA** Laboratory test No. **93I-16-MD**  
At presence of RINA Surveyor **G. Pace**

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: 2012** Standard.

Issued at: Palermo on 28/09/2016

RINA Services S.p.A.