



Welder Qualification Test Certificate EN ISO 9606-1: 2017

Designation: EN ISO 9606-1: 111 T BW FM1 C/B s5,5(2,0/3,5) d.50,0 PH ss nb/ss mb

Welding Procedure Specification Reference No. 02/20

Welder's Name CALAFIÖRE Antonio (Stamp nr. CA)

Identification: CA53722DA

Method of identification: C.I.

Date and place of birth: 14/06/1981 - Napoli (NA)

Employer: EASY SERVIZI SRL - Napoli

Code/Testing Standard: EN ISO 9606-1: 2017

Job knowledge: Not Tested

Test piece

Welding process(es) 111

Transfer Mode N.A.

Product type (plate or pipe) T - Pipes

Type of weld BW

Parent material group(s)/subgroups 1.2

Filler material group(s) FM1

Filler material (Designation) Root: C

Shielding gas Fill/Cap: B

Auxiliaries N.A.

Type of current and polarity N.A.

Material thickness (mm) DCEP

Deposited thickness (mm) 5,5

Outside pipe diameter (mm) 111C: 2,0 / 111B: 3,5

Welding positions 50,0

Weld details PH

Multi-layer/single layer ss nb

Range of qualification

111

N.A.

Plates and pipes

BW and BC with angle 60° and over

1 to 11

FM1, FM2

Root: C

Fill/Cap: A, RA, RB, RC, RR, R, B

N.A.

N.A.

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111C: 2,0 to 4,0 / 111B: 3,0 to 7,0

25,0 and over

PA, PE, PF

111C: ss nb, mb, bs, gb, fb

111B: ss mb, bs

N.A.

Supplementary fillet weld test (completed in conjunction with a butt weld qualification): Not Applicable

Additional information is available on attached sheet and/or welding procedure specification: 02/20

Type of test	Performed and acceptable	Not tested	Notes (Report Numbers, etc)
Visual testing	X		
Radiographic testing		X	
Ultrasonic testing		X	
Magnetic particle / Penetrant test		X	
Macroscopic examination		X	
Fracture test	X		
Bend test		X	
Notch tensile test		X	

Salvatore BOTTARI

Surveyor to Lloyd's Register

A subsidiary of Lloyd's Register Group Limited

Date of issue: 17 gennaio 2020

Location: Milan

Date of welding: 13 gennaio 2020

Revalidation 9.3 a)	Valid Until 12 gennaio 2023
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Revalidation 9.3 b)	Valid Until
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Revalidation 9.3 c)	Valid Until
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Certificate no:

PRJ11100245378/16

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Confirmation of the validity by employer / welding coordinator / examiner or examining body for the following 6 months [refer 9.2)]

**Revalidation for qualification by examiner or examining body for the following 2 years [refer to 9.3 b)] (if applicable)

Date

Valid until

Confirmation based on (Report numbers etc)

Signature / Position or Title

30/7/2020 31/01/2021

Easy Servizi s.r.l.
Amministratore Unico
Dionigi Ruggiano

** 01/02/2021 31/07/2021

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Welder Qualification Test Certificate EN ISO 9606-1: 2017

Designation: EN ISO 9606-1: 311L T BW FM1 S s4,8 d.114,3 PH ss nb

Welding Procedure Specification Reference No. 03/20

Welder's Name CALAFIORE Antonio (Stamp nr. CA)

Identification: CA53722DA

Method of Identification: C.I.

Date and place of birth: 14/06/1981 - Napoli (NA)

Employer: EASY SERVIZI SRL - Napoli

Code/Testing Standard: EN ISO 9606-1: 2017

Job knowledge: Not Tested

Test piece

Welding process(es) 311L

Transfer Mode N.A.

Product type (plate or pipe) T - Pipes

Type of weld BW

Parent material group(s)/subgroups 1.2

Filler material group(s) FM1

Filler material (Designation) Solid wire

Shielding gas N.A.

Auxiliaries N.A.

Type of current and polarity DCEP

Material thickness (mm) 4,8

Deposited thickness (mm) 4,8

Outside pipe diameter (mm) 114,3

Welding positions PH

Weld details ss nb

Multi-layer/single layer N.A.

Examining Body:
Reference No:

Range of qualification
311L
N.A.
Plates and pipes
BW and BC with angle 60° and over
1 to 11
FM1, FM2
Solid wire / Electrode wire M

N.A.
N.A.
-
-
3,0 to 7,2
57,15 and over
PA, PE, PF
ss nb, mb, bs, gb, fb
N.A.

Supplementary fillet weld test (completed in conjunction with a butt weld qualification):

Additional information is available on attached sheet and/or welding procedure specification:

Not Applicable
03/20

Type of test	Performed and acceptable	Not tested	Notes (Report Numbers, etc)
Visual testing	X		
Radiographic testing		X	
Ultrasonic testing		X	
Magnetic particle / Penetrant test		X	
Macroscopic examination		X	
Fracture test	X		
Bend test		X	
Notch tensile test		X	

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Date of issue: 17 gennaio 2020

Location: Milan

Date of welding: 13 gennaio 2020

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Revalidation 9.3 b)	Valid Until
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Revalidation 9.3 c)	Valid Until
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Date

Valid until

Confirmation based on (Report numbers etc)

Signature / Position or Title

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Welder Qualification Test Certificate EN ISO 9606-1: 2017

Designation: EN ISO 9606-1: 111 T BW FM1 C/B s4,8(2,0/2,8) d.114,3 PH ss nb/ss mb

Welding Procedure Specification Reference No. 01/20

Welder's Name: CALÀFIORE Antonio (Stamp nr. CA)

Identification: CA53722DA

Method of Identification: C.I.

Date and place of birth: 14/06/1981 - Napoli (NA)

Employer: EASY SERVIZI SRL - Napoli

Code/Testing Standard: EN ISO 9606-1: 2017

Job knowledge: Not Tested

Test piece

Welding process(es) 111

Transfer Mode N.A.

Product type (plate or pipe) T - Pipes

Type of weld BW

Parent material group(s)/subgroups 1.2

Filler material group(s) FM1

Filler material (Designation) Root: C

Shielding gas Fill/Cap: B

Auxiliaries N.A.

Type of current and polarity N.A.

Material thickness (mm) DCEP

Deposited thickness (mm) 4,8

Outside pipe diameter (mm) 111C: 2,0 / 111B: 2,8

Welding positions 114,3

PH

Weld details ss nb

Multi-layer/single layer N.A.

Range of qualification

111

N.A.

Plates and pipes

BW and BC with angle 60° and over

1 to 11

FM1, FM2

Root: C

Fill/Cap: A, RA, RB, RC, RR, R, B

N.A.

N.A.

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111C: 2,0 to 4,0 / 111B: 2,8 to 5,6

57,15 and over

PA, PE, PF

111C: ss nb, mb, bs, gb, fb

111B: ss mb, bs

N.A.

Supplementary fillet weld test (completed in conjunction with a butt weld qualification): Not Applicable

Additional information is available on attached sheet and/or welding procedure specification: 01/20

Type of test	Performed and acceptable	Not tested	Notes (Report Numbers, etc)
Visual testing	X		
Radiographic testing		X	
Ultrasonic testing		X	
Magnetic particle / Penetrant test		X	
Macroscopic examination		X	
Fracture test	X		
Bend test		X	
Notch tensile test		X	

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Date of issue: 17 gennaio 2020

Location: Milan

Date of welding: 13 gennaio 2020

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**Revalidation for qualification by examiner or examining body for the following 2 years [refer to 9.3 b)] (if applicable)

Date 30/7/2020 Valid until 31/01/2021 Confirmation based on (Report numbers etc)

Signature Position Title S.r.l.
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Dionigi Ruggiano

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Welder Qualification Test Certificate

EN ISO 9606-1: 2017

Designation: **EN ISO 9606-1: 311L T BW FM1 S s5,5 d.50,0 PH ss nb**

Welding Procedure Specification Reference No: **04/20** Examining Body Reference No: **/**

Welder's Name: **CALAFIORE Antonio (Stamp nr. CA)**

Identification: **CA53722DA**

Method of Identification: **C.I.**

Date and place of birth: **14/06/1981 - Napoli (NA)**

Employer: **EASY SERVIZI SRL - Napoli**

Code/Testing Standard: **EN ISO 9606-1: 2017**

Job knowledge: **Not Tested**

Test piece: **311L** Range of qualification: **311L**

Welding process(es): **311L** Transfer Mode: **N.A.**

Product type (plate or pipe): **T - Pipes** Plates and pipes

Type of weld: **BW** BW and BC with angle 60° and over

Parent material group(s)/subgroups: **1,2** 1 to 11

Filler material group(s): **FM1** FM1, FM2

Filler material (Designation): **Solid wire** Solid wire / Electrode wire M

Shielding gas: **N.A.** N.A.

Auxiliaries: **N.A.** N.A.

Type of current and polarity: **DCEP** -

Material thickness (mm): **5,5** 3,0 to 8,25

Deposited thickness (mm): **5,5** 25,0 and over

Outside pipe diameter (mm): **50,0** PA, PE, PF

Welding positions: **PH** ss nb, mb, bs, gb, fb

Weld details: **ss nb** N.A.

Multi-layer/single layer: **N.A.**

Supplementary fillet weld test (completed in conjunction with a butt weld qualification): **Not Applicable**

Additional information is available on attached sheet and/or welding procedure specification: **04/20**

Photograph
(if required)

Type of test	Performed and acceptable	Not tested	Notes (Report Numbers, etc)
Visual testing	X		
Radiographic testing		X	
Ultrasonic testing		X	
Magnetic particle / Penetrant test		X	
Macroscopic examination		X	
Fracture test	X		
Bend test		X	
Notch tensile test		X	

Salvatore BOTTARI

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Date of issue: **17 gennaio 2020**

Location: **Milan**

Date of welding: **13 gennaio 2020**

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Confirmation based on (Report numbers etc)

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