

WELDER APPROVAL CERTIFICATE
ACCORDING TO UNI EN ISO 9606-1:2017



No. WELD/21/00393

Designation	UNI EN ISO 9606-1 135 P BW FM1 S s2.0 PA bs UNI EN ISO 9606-1 135 P BW FM1 S s8.0 PA ss,mb		
Welder			
Place and Date of Birth			
Identification	CHECKED BY EXAMINER	Method of identification	IDENTIFICATION DOCUMENT
Employed by	FERRERO S.P.A.		

WPS used by welder during welding of test coupon: 04-10D Job knowledge: not tested

Welding variables	Test piece		Range of qualification	
Welding process(es)	135	135	135; 138	135; 138
Transfer mode	Short-circuit	Spray	Globular; Pulsed; Short-circuit; Spray	Globular; Pulsed; Spray
Product type	P		P; T	
Type of weld	BW		Butt welds	
Branch connection angle [deg]	-		-	
Parent metal group	1.1		1 to 11	
Filler material group(s)	FM1	FM1	FM1; FM2	FM1; FM2
Filler material type	S	S	S; M	S; M
Shielding gas (ISO14175)	M21	M21	All compatible	All compatible
Auxiliaries	-	-	-	-
Type of current and polarity	DC EP	DC EP	All compatible	All compatible
Deposited thickness [mm]	2.0	8.0	$2.0 \leq s \leq 4.0$	$3.0 \leq s \leq 16.0$
	10.0 (proc. 135 + 135)		$3.0 \leq S \leq 20.0$ (proc. 135 + 135)	
Pipe outside diameter [mm]	-		D \geq 500mm (fixed pipe); D \geq 75mm (rotated pipe)	
Weld position	PA		PA	
Weld details	bs	ss,mb	bs; ss,mb	bs; ss,mb

Type of test							
Visual	Acceptable	Radiographic	Not Tested	Macro	Not Tested	Magnetic Particle	Not Tested
Penetrant	Not Tested	Fracture	Acceptable	Bend	Not Tested	Ultrasound	Not Tested
Notch Tensile	Not Tested						

Valid from	21-Jan-2021	Expiry Date	20-Jan-2024
Revalidation method	9.3a	Current Issue	09-Feb-2021

Filippo Lago

(Italy Welding & Pressure Equipment Certification Head)

This certificate consists of 2 pages

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PRS N° 066 C
PRD N° 002 B

Membro degli accordi di Mutuo riconoscimento EA, IAF e ILAC

Signatory of EA, IAF and ILAC Mutual Recognition Agreements

RINA Services S.p.A.

PED No. Bo. 0474

Via Corsica 12 - 16128 Genova

WELDER APPROVAL CERTIFICATE
ACCORDING TO UNI EN ISO 9606-1:2017



No. WELD/21/00394

Designation	UNI EN ISO 9606-1 135 P FW FM1 S t10.0 PB ml		
Welder			
Place and Date of Birth			
Identification	CHECKED BY EXAMINER	Method of identification	IDENTIFICATION DOCUMENT
Employed by	FERRERO S.P.A.		

WPS used by welder during welding of test coupon: 01-10D Job knowledge: not tested

Welding variables	Test piece	Range of qualification
Welding process(es)	135	135; 138
Transfer mode	Spray	Globular; Pulsed; Spray
Product type	P	P; T
Type of weld	FW	Fillet welds
Branch connection angle [deg]	-	-
Parent material group	1.1	1 to 11
Filler material group(s)	FM1	FM1; FM2
Filler material type	S	S; M
Shielding gas (ISO14175)	M21	All compatible
Auxiliaries	-	-
Type of current and polarity	DC EP	All compatible
Deposited thickness [mm]	-	-
Material thickness [mm]	10.0	t ≥ 3.0
Pipe outside diameter [mm]	-	D ≥ 500mm (fixed pipe); D ≥ 75mm (rotated pipe - positions PA; PB)
Weld position(s)	PB	PA; PB
Weld details / Layer technique	ml	ml; sl

Type of test							
Visual	Acceptable	Radiographic	Not Tested	Macro	Not Tested	Magnetic Particle	Not Tested
Penetrant	Not Tested	Fracture	Acceptable	Bend	Not Tested	Ultrasound	Not Tested
Notch Tensile	Not Tested						

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