

WELDER APPROVAL CERTIFICATE
ACCORDING TO UNI EN ISO 9606-1:2013



No. **17VE01465PO1**

Designation	UNI EN ISO 9606-1 135-S T FW FM1 S t6 D60 PB ml		
Welder	[REDACTED]		
Born in	[REDACTED] (TS)	on	[REDACTED]
Identification	AY 7534594	Method of Identification	C.I. Stamp No. TK
Employed by	ISOL.ME.CAR. S.R.L. - Monfalcone (GO)		

WPS used by welder during welding of test coupon: **01/17 S**

Job knowledge: **not tested**

Welding variables	Test piece	Range of qualification
Welding process(es)	135-S	135; 138
Transfer mode	Spray-arc	Spray, globular and pulsed-arc
Product type	Pipes	Plates and pipes
Type of weld	FW	Fillet weld
Parent Metal group (ISO/TR 15608)	1.2	1 to 11
Filler material group(s)	FM1	FM1, FM2
Filler material type	Solid wire	Solid wire/electrode core: M
Shielding gas (EN ISO 14175)	M24	All compatible
Type of current and polarity	DC EP	All compatible
Material thickness (mm)	6	>= 3
Pipe outside diameter (mm)	60	30 and over
Welding position(s)	PB	PA, PB
Weld details / Layer technique	ml	sl, ml

Type of test							
Visual	Acceptable	Radiographic	Not tested	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Acceptable	Fracture	Not tested	Bend	Not tested		

This certificate is valid from	10 October 2017	to	10 October 2020
Issued at	GENOVA	on	20 December 2017

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 Via Corsica 12 - 16128 Genova

1.4576075946RBE9618T67V175157G1P17

Prolongation for approval by employer / coordinator for the following 6 months

Prolongation for approval by examiner or test body

Date	Signature	Position of title	Date	Signature	Position of title

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WELDER APPROVAL CERTIFICATE
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No. **17VE01465PO2**

Designation	UNI EN ISO 9606-1 135-S T FW FM1 S t6 D60 PB ml				
Welder	[REDACTED]				
Born in	[REDACTED]	on	[REDACTED]		
Identification	AV 7036751	Method of Identification	C.I.	Stamp No.	CA
Employed by	ISOL.ME.CAR. S.R.L. - Monfalcone (GO)				

WPS used by welder during welding of test coupon: **01/17 S**

Job knowledge: **not tested**

Welding variables	Test piece	Range of qualification
Welding process(es)	135-S	135; 138
Transfer mode	Spray-arc	Spray, globular and pulsed-arc
Product type	Pipes	Plates and pipes
Type of weld	FW	Fillet weld
Parent Metal group (ISO/TR 15608)	1.2	1 to 11
Filler material group(s)	FM1	FM1, FM2
Filler material type	Solid wire	Solid wire/electrode core: M
Shielding gas (EN ISO 14175)	M24	All compatible
Type of current and polarity	DC EP	All compatible
Material thickness (mm)	6	>= 3
Pipe outside diameter (mm)	60	30 and over
Welding position(s)	PB	PA, PB
Weld details / Layer technique	ml	sl, ml

Type of test							
Visual	Acceptable	Radiographic	Not tested	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Acceptable	Fracture	Not tested	Bend	Not tested		

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WELDER APPROVAL CERTIFICATE
ACCORDING TO UNI EN ISO 9606-1:2013



No. **17VE01465PO3**

Designation	UNI EN ISO 9606-1 135-S T FW FM1 S t6 D60 PB ml				
Welder	[REDACTED]				
Born in	[REDACTED]	on	[REDACTED]		
Identification	AU 1547277	Method of Identification	C.I.	Stamp No.	PJ
Employed by	ISOL.ME.CAR. S.R.L. - Monfalcone (GO)				

WPS used by welder during welding of test coupon: **01/17 S**

Job knowledge: **not tested**

Welding variables	Test piece	Range of qualification
Welding process(es)	135-S	135; 138
Transfer mode	Spray-arc	Spray, globular and pulsed-arc
Product type	Pipes	Plates and pipes
Type of weld	FW	Fillet weld
Parent Metal group (ISO/TR 15608)	1.2	1 to 11
Filler material group(s)	FM1	FM1, FM2
Filler material type	Solid wire	Solid wire/electrode core: M
Shielding gas (EN ISO 14175)	M24	All compatible
Type of current and polarity	DC EP	All compatible
Material thickness (mm)	6	>= 3
Pipe outside diameter (mm)	60	30 and over
Welding position(s)	PB	PA, PB
Weld details / Layer technique	ml	sl, ml

Type of test							
Visual	Acceptable	Radiographic	Not tested	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Acceptable	Fracture	Not tested	Bend	Not tested		

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coordinator for the following 6 months****Prolongation for approval by examiner or
test body**

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WELDER APPROVAL CERTIFICATE
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No. **17VE01465PO4**

Designation	UNI EN ISO 9606-1 135-D/135-S P BW FM1/FM1 S/S t12 PA ss nb		
Welder	[REDACTED]		
Born in	[REDACTED]	on	[REDACTED]
Identification	AY 7534594	Method of Identification	C.I. Stamp No. TK
Employed by	ISOL.ME.CAR. S.R.L. - Monfalcone (GO)		

WPS used by welder during welding of test coupon: **03/17 S**

Job knowledge: **not tested**

Welding variables	Test piece	Range of qualification
Welding process(es)	135-D / 135-S	135; 138
Transfer mode	Short-arc / Spray-arc	Short, spray, globular and pulsed-arc
Product type	Plate	Plates and pipes
Type of weld	BW	Butt weld
Parent Metal group (ISO/TR 15608)	1.2	1 to 11
Filler material group(s)	FM1	FM1, FM2
Filler material type	135-D	Root: Solid wire Fill/Cap: Solid wire/electrode core: M
	135-S	Root: Solid wire Fill/Cap: Solid wire/electrode core: M
Shielding gas (EN ISO 14175)	M24	All compatible
Type of current and polarity	135-D: DC EP; 135-S: DC EP	All compatible
Deposited thickness (mm)	12	135-D: 3 to 6 135-S: 3 to 18
Pipe outside diameter (mm)	N.A.	135-D / 135-S: >= 3 75 and over
Welding position(s)	PA	PA
Weld details / Layer technique	ss nb	135-D: ss nb, ss mb, bs, ss gb, ss fb 135-S: ss nb, ss mb, bs, ss gb, ss fb

Type of test							
Visual	Acceptable	Radiographic	Not tested	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Not tested	Fracture	Acceptable	Bend	Not tested		

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WELDER APPROVAL CERTIFICATE
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No. **17VE01465PO5**

Designation	UNI EN ISO 9606-1 135-D/135-S P BW FM1/FM1 S/S t12 PA ss nb				
Welder	[REDACTED]				
Born in	[REDACTED]	on	[REDACTED]		
Identification	AV 7036751	Method of Identification	C.I.	Stamp No.	CA
Employed by	ISOL.ME.CAR. S.R.L. - Monfalcone (GO)				

WPS used by welder during welding of test coupon: **03/17 S**

Job knowledge: **not tested**

Welding variables	Test piece	Range of qualification
Welding process(es)	135-D / 135-S	135; 138
Transfer mode	Short-arc / Spray-arc	Short, spray, globular and pulsed-arc
Product type	Plate	Plates and pipes
Type of weld	BW	Butt weld
Parent Metal group (ISO/TR 15608)	1.2	1 to 11
Filler material group(s)	FM1	FM1, FM2
Filler material type	135-D	Root: Solid wire
	135-S	Fill/Cap: Solid wire/electrode core: M
		Root: Solid wire
		Fill/Cap: Solid wire/electrode core: M
Shielding gas (EN ISO 14175)	M24	All compatible
Type of current and polarity	135-D: DC EP; 135-S: DC EP	All compatible
Deposited thickness (mm)	12	135-D: 3 to 6
		135-S: 3 to 18
		135-D / 135-S: >= 3
Pipe outside diameter (mm)	N.A.	75 and over
Welding position(s)	PA	PA
Weld details / Layer technique	ss nb	135-D: ss nb, ss mb, bs, ss gb, ss fb
		135-S: ss nb, ss mb, bs, ss gb, ss fb

Type of test							
Visual	Acceptable	Radiographic	Not tested	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Not tested	Fracture	Acceptable	Bend	Not tested		

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WELDER APPROVAL CERTIFICATE
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No. **17VE01465PO6**

Designation	UNI EN ISO 9606-1 135-D/135-S P BW FM1/FM1 S/S t12 PA ss nb				
Welder	[REDACTED]				
Born in	[REDACTED]	on	[REDACTED]		
Identification	AU 1547277	Method of Identification	C.I.	Stamp No.	PJ
Employed by	ISOL.ME.CAR. S.R.L. - Monfalcone (GO)				

WPS used by welder during welding of test coupon: **03/17 S**

Job knowledge: **not tested**

Welding variables	Test piece	Range of qualification
Welding process(es)	135-D / 135-S	135; 138
Transfer mode	Short-arc / Spray-arc	Short, spray, globular and pulsed-arc
Product type	Plate	Plates and pipes
Type of weld	BW	Butt weld
Parent Metal group (ISO/TR 15608)	1.2	1 to 11
Filler material group(s)	FM1	FM1, FM2
Filler material type	135-D	Root: Solid wire
	135-S	Fill/Cap: Solid wire/electrode core: M
		Root: Solid wire
		Fill/Cap: Solid wire/electrode core: M
Shielding gas (EN ISO 14175)	M24	All compatible
Type of current and polarity	135-D: DC EP; 135-S: DC EP	All compatible
Deposited thickness (mm)	12	135-D: 3 to 6
		135-S: 3 to 18
		135-D / 135-S: >= 3
Pipe outside diameter (mm)	N.A.	75 and over
Welding position(s)	PA	PA
Weld details / Layer technique	ss nb	135-D: ss nb, ss mb, bs, ss gb, ss fb
		135-S: ss nb, ss mb, bs, ss gb, ss fb

Type of test							
Visual	Acceptable	Radiographic	Not tested	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Not tested	Fracture	Acceptable	Bend	Not tested		

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