

Certificato n°:

QPE-ITA-19-00213-rev.0

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QW-484 RECORD OF WELDER PERFORMANCE QUALIFICATION (WPQ)

Welder name Clock No -- Stamp No CV
 Company name VESSEL TECHNICAL SERVICES SRL -VIA FAUSTO COPPI 11-80010 QUARTO NAPOLI

Test description

Welding process used GTAW for hard-facing overlay Type Manual
 (HFO)

Identification of WPS used by welder during VT 10/19
 welding of test coupon

Base material(s) A/SA-479 TP 316 L Thickness 10
 welded [mm]

Testing Variables and qualification Limits

WELDING VARIABLES (QW - 350)	Actual values	Range qualified
Backing (QW - 402)	-	-
ASME P-No. to ASME P No. (QW - 403)	8 to 8	1+15F-34-41+49
☐ Plate ☒ Pipe (enter diameter, if pipe)	50 mm	PLATE AND PIPE Over 50 mm
Filler metal specification (SFA) (QW - 404)	5.21	--
Filler metal F-No (QW -404)	72	72
AWS Classification (QW - 404)	ERCoCr-A	---
Weld deposit (mm)	6,3	Max 12,6
Welding position (QW - 405)	1G	F
Progression	--	--
Backing gas (QW-408)	NO	NO
Consumable insert (QW-404)	N.A.	N.A.
GTAW welding current/polarity (QW - 409)	DC STRAIGHT	DC STRAIGHT

TEST RESULTS

Visual examination (QW - 302.4) SATISFACTORY

Radiographic (QW - 304) -

Laboratory test No. -

Bend test (QW - 462) -

Other test (QW-453) Macro/PT Test SATISFACTORY

Laboratory test No. RP 19/451 A-B

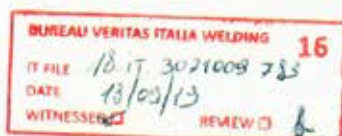
Mechanical test conducted by --

Laboratory test No.

We certify that the statements in this record are correct and that the test welds were prepared and tested in accordance with the requirements of section IX of the ASME Code.

Issued at Napoli

on 18/09/2019



Approved by