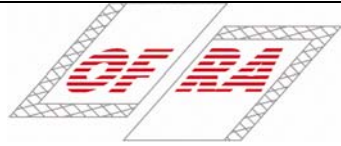


**ELENCO PROCEDIMENTI DI SALDATURA**  
SUMMARY OF PROCEDURE QUALIFICATION RECORDS  
WPAR (EN 288/3 – ISO 15614-1)

**Doc. No.:**  
**Elenco WPQR UNI-EN**  
**OFRA Rev7.doc**  
**Date: 28-06-06**  
**Pagina 1 di 5**

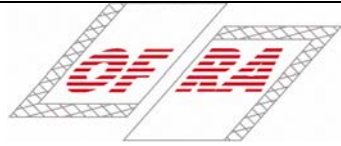
No	TIPO Type	METALLO BASE Base Material				SUPP. E TIPO Backing Type	METALLO D'APPORTO Filler Metal				FILO Wire		ELETTRODI Electrodes		POSIZIONE Position	GAS / FLUSSO Gas / Flux	T. TERMICO P.W.H.T. °C	ENTE DI QUALIFICA Notified Body	NOTE Remarks
		Gr	DIAMETRO Diameter	SPESSORI Thickness Mm	CIANFRINO Groove		TIPO Type	DIAM. Diam. mm	TIPO Type	DIAM. Diam. mm									
01/01 A	121	1	≥500	3-24	Single V	N.A.*	EN	765	S3Si	OK 12.32 ESAB	3,2			PA (ALL per No KV- HV)	OK10.62		ISPESL	KV -20°C *CON RIPRESA with backing	
							EN	760	SA FB 155 AC H5										
01/01 B	141 111	9	30-120	3-11	Single V	Argon	AWS	A 5.9	ER 308L	TIGROD 16.10	2,4			ALL	Ar	RINA	/		
							EN	1600	E 19 9 L R 12			OK 61.30	2,5						
02/01 A	141 111	1	24,15-96,6	3-10,16	Single V	N.A.*	EN	440	G2Si	SIDERFIL Ar ESAB	2,4			PC (ALL per No KV- HV)	Ar	ISPESL	KV -20°C		
							EN	449	E 42 4B 42 H 5			OK48,50 ESAB	2,5						
02/01 B	136	9	≥500	3-20	Single V	N.A.*	AWS	A 5.22	E 316LT0-4	316 MY KOY	1,2			ALL	80%Ar+ 20%CO2	RINA	*CON RIPRESA with backing		
03/01	141 111	1	≥84,1	3-21,94	Single V	N.A.	EN	440	G2Si	SIDERFIL Ar ESAB	2,4			PC (ALL per No KV- HV)	Ar	ISPESL	KV -20°C		
							EN	449	E 42 4B 42 H 5			OK48,50 ESAB	3,25-4						
04/01	111	1	≥500	3-24	Single V	N.A.*	EN	449	E 42 4B 42 H 5			OK 4850 ESAB	3,25-4	PF (ALL per No KV- HV)		ISPESL	KV -20°C *CON RIPRESA with backing		



**ELENCO PROCEDIMENTI DI SALDATURA**  
SUMMARY OF PROCEDURE QUALIFICATION RECORDS  
WPAR (EN 288/3 – ISO 15614-1)

**Doc. No.:**  
**Elenco WPQR UNI-EN**  
**OFRA Rev7.doc**  
**Date: 28-06-06**  
**Pagina 2 di 5**

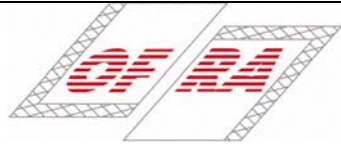
No	TIPO Type	METALLO BASE Base Material				SUPP. E TIPO Backing Type	METALLO D'APPORTO Filler Metal				FILO Wire		ELETTRODI Electrodes		POSIZIONE Position	GAS / FLUSSO Gas / Flux	T. TERMICO P.W.H.T. °C	ENTE DI QUALIFICA Notified Body	NOTE Remarks
		Gr	DIAMETRO Diameter	SPESSORI Thickness Mm	CIANFRINO Groove		TIPO Type	DIAM. Diam. mm	TIPO Type	DIAM. Diam. mm									
05/01	136	1	>=500	3-24	Single V	N.A.*	EN	758	T 46 2 MM 1 H5	61.03 ETC	1,2			PA (ALL per No KV- HV)			ISPESL	KV -20°C *CON RIPRESA with backing	
06/01	141 111 121	1	>=500	12,5-50	Single V	N.A.	EN EN EN	440 499 756	G35 OM G2Si E 42 4B 42 H 5 S 46 6 FB S3 Si	SIDERFIL Ar ESAB  OK 12.32 ESAB	2,4  3,2	  OK 48.50 ESAB	3,2-4	PC (ALL per No KV- HV)	Ar  OK10.62		ISPESL	KV -20°C	
07/01	111	1	24,15-96,6	12,5-50	*Double ½ V	N.A.*	EN	499	E 42 4B 42 H 5			OK 48.50 ESAB	3,2-4	PA (ALL per No KV- HV)			ISPESL	KV -20°C	
08/01	111	1	>=64,1	12, 5-50	*Double ½ V	N.A.*	EN	499	E 42 4B 42 H 5			OK 48.50 ESAB	3,2-4	PF(ALL per No KV- HV)			ISPESL	KV -20°C	
09/2001	135	3	>=500	20-80	Single V	N.A.*	AWS	A 5.28	ER 100S-G	Inefil NiMoCr INE	1,2			PA	80%Ar+ 20%CO2	625°C x 135min. Heating/cooling rate 100°/h Cooling controlled up since 300°C	DNV	WELDOX KV -20°C *CON RIPRESA with backing	
01/2002	141 111	9	44,45-117,8	3-6,24	Single V	N.A.	AWS AWS	A 5.9 A5.4	ER 316L E 316L-17	512MY KOY	2,4			ALL	Ar		DNV		
02/2002	141	9	24,15-96,6	2,77-5,54	Single V	N.A.	AWS	A 5.9	ER 316L	512MY KOY	2,4			ALL	Ar		DNV		
P3843/02	135 136	1	>=500	7,5-30	Single V	N.A.	EN EN	440 758	424 M21G3Si 1 T 46 4 MM 2 H 5	SUPRAMIG LINCOLN MEGAFIL 710 M	1,2 1,2			PA (ALL per No KV- HV)	80%Ar+ 20%CO2		BV	KV -29°C	



**ELENCO PROCEDIMENTI DI SALDATURA**  
SUMMARY OF PROCEDURE QUALIFICATION RECORDS  
WPAR (EN 288/3 – ISO 15614-1)

**Doc. No.:**  
**Elenco WPQR UNI-EN**  
**OFRA Rev7.doc**  
**Date: 28-06-06**  
**Pagina 3 di 5**

No	TIPO Type	METALLO BASE Base Material				SUPP. E TIPO Backing Type	METALLO D'APPORTO Filler Metal				FILO Wire		ELETTRODI Electrodes		POSIZIONE Position	GAS / FLUSSO Gas / Flux	T. TERMICO P.W.H.T. °C	ENTE DI QUALIFICA Notified Body	NOTE Remarks
		Gr	DIAMETRO Diameter	SPESSORI Thickness Mm	CIANFRINO Groove		TIPO Type	DIAM. Diam. mm	TIPO Type	DIAM. Diam. mm									
06/03	141	9	≥500	17,5-70	Single V	N.A.	EN	12072	AWS A5.9 ER308L	510MY KOY	2,4			ALL	Ar		ISPESL		
							EN	1600	AWS A5.4 E308L			OK 61.30 ESAB	3,25						
	121						EN	12072	AWS A5.9 ER308L	AUTROD 16.10	3,2								OK 10.92
07/03	141	9	31,15-120,6	10-40	Single ½ V Plate/pipe	N.A.	EN	12072	AWS A5.9 ER308L	510MY KOY	2,4			ALL	Ar		ISPESL		
	111						EN	1600	AWS A5.4 E308L			OK 61.30 ESAB	3,25						
08/03	141	9	≥84,15	10-40	Single ½ V Plate/pipe	N.A.	EN	12072	AWS A5.9 ER308L	510MY KOY	2,4			ALL	Ar		ISPESL		
	111						EN	1600	AWS A5.4 E308L			OK 61.30 ESAB	3,25						
P2132/04	141	9+1	24,15-96,60	3-16	Single V	N.A.	EN	12072	AWS A5.9 ER309L	509MY KOY	2,4			ALL	Ar		BV	KV -20°C	
	111						EN	1600	AWS A5.4E309-16			77 KOY	2,5						
01/05	136	1	≥500	12-48	Double V	Metal	EN	758	T 46 3 P M1 H5	71 EH Lincoln	1,2			H-L045	80% Ar+ 20% CO2	600°C x 120min. Heating/cooling rate 85°/h  Cooling controlled up since 300°C	BV	KV -40°C	
02/05	136	1	≥150	20-80	Double V	Metal	EN	758	T 46 3 P M1 H5	71 EH Lincoln	1,2			PA(ALL per No KV- HV)	80% Ar+ 20% CO2	600°C x 120min. Heating rate 66°/h Cooling rate 80°/h  Cooling controlled up since 300°C	BV	KV -40°C	
	121						EN	756	S2Si SAAB167 ACH5	AUTROD 12.22	3,2								OK 10.71



**ELENCO PROCEDIMENTI DI SALDATURA**  
SUMMARY OF PROCEDURE QUALIFICATION RECORDS  
WPAR (EN 288/3 – ISO 15614-1)

**Doc. No.:**  
**Elenco WPQR UNI-EN**  
**OFRA Rev7.doc**  
**Date: 28-06-06**  
**Pagina 4 di 5**

No	TIPO Type	METALLO BASE Base Material				SUPP. E TIPO Backing Type	METALLO D'APPORTO Filler Metal			FILO Wire		ELETTRODI Electrodes		POSIZIONE Position	GAS / FLUSSO Gas / Flux	T. TERMICO P.W.H.T. °C	ENTE DI QUALIFICA Notified Body	NOTE Remarks
		Gr	DIAMETRO Diameter	SPESSORI Thickness Mm	CANFRINO Groove					TIPO Type	DIAM. Diam. mm	TIPO Type	DIAM. Diam. mm					
03/05	136	1	>=150	50-200	Double V	Metal	EN	758	T 46 3 P M1 H5	Megafil 710 M	1,2			PA(ALL per No KV- HV)	80% Ar+ 20% CO2 OK 10.62	630°C x 150min. Heating/cooling rate 85°/h Cooling controlled up since 300°C	BV	KV -40°C
	121							756	S3Si SAfB155 ACH5	AUTROD 12.32	4,0							
04/05	111	1	>=150	ALL	FILLET	Metal	EN	499				E 42/46 4B 42H5	3,2	PA(ALL per No KV- HV)		600°C x 120min. Heating/cooling rate 85°/h Cooling controlled up since 300°C	BV	KV -40°C
PAD-06- B-129	141	22.1,	>=84,25	>=7,5	Double V	N.A.			AWS5.10-ER5183	T&R	3,2		ALL (except PG and J-L045)					
	131	22.2, 22.3, 22.4							AWS5.10-ER5183	T&R	1,2							
PAD-06- B-130	141	22.1, 22.2, 22.3, 22.4	>=30	3-12	Double V	N.A.			AWS5.10-ER5183	T&R	3,2		ALL (except PG and J-L045)					



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SUMMARY OF PROCEDURE QUALIFICATION RECORDS  
WPAR (EN 288/3 – ISO 15614-1)

**Doc. No.:**  
**Elenco WPQR UNI-EN**  
**OFRA Rev7.doc**  
**Date: 28-06-06**  
**Pagina 5 di 5**

No	TIPO Type	METALLO BASE Base Material				SUPP. E TIPO Backing Type	METALLO D'APPORTO Filler Metal			FILO Wire		ELETTRODI Electrodes		POSIZIONE Position	GAS / FLUSSO Gas / Flux	T. TERMICO P.W.H.T. °C	ENTE DI QUALIFICA Notified Body	NOTE Remarks	
		Gr	DIAMETRO Diameter	SPESSORI Thickness Mm	CIANFRINO Groove					TIPO Type	DIAM. Diam. mm	TIPO Type	DIAM. Diam. mm						
PAD-06- B-251	141	8.1.	>=30,15	3-11,08	Single V	N.A.	EN	12072	AWS5..9-ER316L	OK Tigrod 316L Esab	2			ALL	Ar		BV		
	111						EN	1600	AWS5.4-E316L16			OK63.34 Esab	2,5	(H-L045)	99,999%				
PAD-06- B-252	141	10.1.	>=30,15	3-11,80	Single V	N.A.	EN	12072	AWS5..9-ER2209	OK Tigrod 2209 Esab	2			ALL	Ar		BV		
	111						EN	1600	AWS5.4-E2209-15			OK67.55 Esab	2,5	(H-L045)	99,999%				
PAD-06- B-253	111 Repair	10.1.	>=30,15	3-11,80 2,95-7,08	Single V	N.A.	EN	1600	AWS5.4-E2209-15			OK67.55 Esab	2,5	ALL (H-L045)	Ar 99,999%		BV		
PAD-06- B-254	141	8.1 10.1.	>=30,15	3-10,16	Single V	N.A.	EN	12072	AWS5..9-ER316L	OK Tigrod 316L Esab	2			ALL	Ar		BV		
	111						EN	1600	AWS5.4-E316L16			OK63.34 Esab	2,5	(H-L045)	99,999%				