

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



No. WELD/20/82101

Designation	UNI EN ISO 9606-1 135 P BW FM1 S s3.0 PA ss,nb UNI EN ISO 9606-1 135 P BW FM1 S s17.0 PA ss,mb		
Welder	PASCAL AGUSTONI		
Place and Date of Birth	SORENGO On 04-JUN-1980		
Identification	CHECKED BY EXAMINER	Method of identification	IDENTIFICATION DOCUMENT
Employed by	EROS TOGNI METALCOSTRUZIONI SA (CHE)		

WPS used by welder during welding of test coupon: 01-20 **Job knowledge:** not tested

Welding variables	Test piece		Range of qualification	
	Welding process(es)	135	135	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	1.2		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]	3.0	17.0	$3.0 \leq s \leq 6.0$	$s \geq 3.0$
	20.0 (proc. 135 + 135)		$S \geq 3.0$ (proc. 135 + 135)	
Pipe outside diameter [mm]	-		$D \geq 500\text{mm}$ (fixed pipe); $D \geq 75\text{mm}$ (rotated pipe)	
Weld position	PA		PA	
Weld details	ss,nb	ss,mb	bs; ss,fb; ss,gb; ss,mb; ss,nb	bs; ss,mb

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

Valid from	16-Sep-2020	Expiry Date	15-Sep-2023
Revalidation method	9.3a	Current Issue	10-Dec-2020

Filippo Lago

(Italy Welding & Pressure Equipment Certification Head)

This certificate consists of 2 pages

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PRD N° 002 B

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RINA Services S.p.A.

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