

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



**No. WELD/20/03507**

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 s12.0 PA ss,mb		
Welder	MASSIMO FERRO		
Born in	CHIOGGIA (VE) On 02-JUN-1977		
Identification	CHECKED BY EXAMINER	Method of identification	IDENTIFICATION DOCUMENT
Employed by	P.F. COSTRUZIONI METALLICHE SNC		

**WPS used by welder during welding of test coupon:** 01SV19 **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	12.0	$3.0 \leq s \leq 6.0$	$s \geq 3.0$
	15.0 (proc. 135 + 135)		$S \geq 3.0$ (proc. 135 + 135)	
Pipe outside diameter [mm]	-		D $\geq$ 500mm (fixed pipe); D $\geq$ 75mm (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	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	13-Jan-2020			Expiry Date	12-Jan-2023		
Revalidation method	9.3a			Current Issue	13-Jan-2020		

Filippo Lago  
 (Italy Welding & Pressure Equipments Certification Head)

This certificate consists of 2 pages

The contents of this document is confidential and copyrighted.



**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/20/03523

Designation	UNI EN ISO 9606-1 135 P FW FM1 S t12.0 PB ml		
Welder	MASSIMO FERRO		
Born in	CHIOGGIA (VE) On 02-JUN-1977		
Identification	CHECKED BY EXAMINER	Method of identification	IDENTIFICATION DOCUMENT
Employed by	P.F. COSTRUZIONI METALLICHE SNC		

WPS used by welder during welding of test coupon: 02S19 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	1.2	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]	12.0 ; 12.0	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						

valid from	13-Jan-2020	Expiry Date	12-Jan-2023
Revalidation method	9.3a	Current Issue	13-Jan-2020

Filippo Lago  
 (Italy Welding & Pressure Equipments Certification Head)



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