



ANB / ANBCC



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WELDING PROCEDURE QUALIFICATION RECORD QUALIFICAZIONE PROCEDURA DI SALDATURA

Certificate No./ Certificato No. LD0001/13

**WE HEREBY CERTIFY THAT /
SI CERTIFICA CHE**

**the procedure METAL POINT snc WPS No.METAL POINT 01/12
Rev. 0**

**IS QUALIFIED ACCORDING TO / E' QUALIFICATA IN ACCORDO A
Section IX of the ASME Code BPV**

**REMARKS / NOTE
Annexes 20**

**ISSUE DATE /
DATA DI EMISSIONE 27/12/2012**

**CERTIFICATION AREA CSP
AREA CERTIFICAZIONE CSP
Della Ragione Renato**



**SGQ n° 021A PRS n° 021C
PRD n° 021B SGA n° 033D**

Membro degli Accordi di Mutuo Riconoscimento EA, IAF e ILAC
Signatory of EA, IAF and ILAC Mutual Recognition Agreement

Il presente certificato è soggetto al rispetto delle condizioni stabilite nel Regolamento IIS CERT QAS 023 R.
This certificate complies with the terms established by IIS CERT regulations QAS 023 R.

**IIS CERT Srl Lungobisagno Istria 29 R - 16141 GENOVA - www.iiscert.it
Corporate Governance Istituto Italiano della Saldatura**

METAL POINT SNC

Via Del Ponte, 44 - 23862 CIVATE (LC)
Cod. Fisc. e Part. IVA 01892300136

WELDER
PERFORMANCE QUALIFICATION
WPQ

WPQR-N. LC0002/13
IIS Job N. C00002667



Company Name
Welder's name

METAL POINT SNC - VIA DEL PONTE, 44 - 23862 CIVATE (LC)
TENTORI DANIELE

Clock Number NONE

Stamp No. TD

Welding Process(es)
Type(s)

b) GMAW
b) Semiautomatic

Identification of WPS followed by welder during welding of test coupon

METAL POINT 01/12 Rev.0

Base material(s) welded.

SA - 516 Gr.60

Thickness 25 (mm)

Manual or SemiAut. Variables for Each Proc. (QW-350)

Backing (QW-402) Yes No

ASME P-No 1 to P-No 1 (QW-403)

Plate Pipe (Enter O.D., if Pipe mm)

Filler metal variety for GTAW, PAW (QW-404)

Consumable Insert for GTAW or PAW

Welding position (1G, 5G, etc.) (QW-405)

Progression (uphill/downhill)

Fuel gas for OFW (QW-408)

Backing Gas for GTAW, PAW, or GMAW

GMAW/FAW transfer mode (QW-409)

Filler metal (QW-404)

Filler metal F-No.

Weld deposit thickness for each welding process (mm)
(Test Coupon Thickness for Fillet)

3 Layers minimum

GTAW welding current type / polarity

Actual Values	Range qualified
<input type="radio"/> Metal <input type="radio"/> Nonmetallic <input type="radio"/> Nonfusing metal <input checked="" type="radio"/> Other Weld metal	With
1 to 1	P-No.1 through P-No.15F, P-No.34, P-No.41 through P-No. 49, unassigned metals of similar mechanical and chemical requirements of the assigned metal
PLATE	Plates and pipes 73 O.D. and over
bare (solid)	bare (solid) or metal-cored
<input type="radio"/> with <input type="radio"/> without <input checked="" type="radio"/> NA	NA
1G	Groove: plate and pipe >24" O.D. : F ; for pipe <24" O.D. : F ; Fillet : F
<input type="radio"/> Up <input type="radio"/> Down <input checked="" type="radio"/> NA	NA
NA	NA
<input type="radio"/> with <input type="radio"/> without <input checked="" type="radio"/> NA	NA
NA	NA
Spec. 5.18	all F-No.6
Class.ER70S-6	
6	Max to be welded - All Fillet size
20	
<input checked="" type="radio"/> Yes <input type="radio"/> No <input type="radio"/> NA	--
NA/NA	NA/NA

Guided Bend Test Results

Guided Bend Test Type QW-462.2 (Side) Results QW-462.3(a) (Trans.R&F) Type QW-462.3 (Long R&F) Results

transverse	180° Satisfactory		
transverse	180° Satisfactory		

Visual examination results (QW-302.4) SATISFACTORY

Radiographic test results (QW-304 and QW-305) NONE (For alternative qualification of groove welds by radiography)

Fillet Weld - Fracture Test -- Length and percent of defects -- mm

Macro Test Fusion -- Fillet leg size -- mm x -- mm Concavity/convexity -- mm

Welding test conducted by METAL POINT snc - CIVATE (LC)

Mechanical test conducted by Laboratorio T.O.S.I. srl - LEGNANO (MI)

laboratory test No. 12P8072

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded and tested in conformance with the requirements of the section IX of ASME Code BPV 2010 (2011a Addenda - July 1, 2011)

Date 27/12/2012

Test supervised by Italian Institute of Welding
CERTIFICATION AREA CSWIS CERT S.R.L.
Della Regione Regione Lombardia Istituto Italiano della Saldatura
L'ISPETTORE INCARICATO
(Pi. Renato Della Ragione)

Manufacturer
(Stamp and Signature)
METAL POINT S.n.c.

Via Del Ponte, 44 - 23862 CIVATE (LC)
Cod. Fisc. e Part. IVA 01892300136

WELDER PERFORMANCE QUALIFICATION WPQ

WPQR-N. LC0001/13
IIS Job N. C00002667



Company Name METAL POINT SNC - VIA DEL PONTE, 44 - 23862 CIVATE (LC)
Welder's name TENTORI DANIELE **Clock Number** NONE **Stamp No.** TD

Welding Process(es) Type(s) a) GTAW a) Manual
Identification of WPS followed by welder during welding of test coupon METAL POINT 01/12 Rev.0
Base material(s) welded. SA - 516 Gr.60 **Thickness (mm)** 25

Manual or SemiAut. Variables for Each Proc. (QW-350)

	Actual Values	Range qualified
Backing (QW-402) <input checked="" type="radio"/> Yes <input type="radio"/> No	<input type="radio"/> Metal <input type="radio"/> Nonmetallic <input type="radio"/> Nonfusing metal <input checked="" type="radio"/> Other	With
ASME P-No 1 to P-No 1 (QW-403)	Welded from both sides 1 to 1	P-No.1 through P-No.15F, P-No.34, P-No 41 through P-No. 49, unassigned metals of similar mechanical and chemical requirements of the assigned metal
<input checked="" type="radio"/> Plate <input type="radio"/> Pipe (Enter O.D., if Pipe mm)	PLATE	Plates and pipes 73 O.D. and over
Filler metal variety for GTAW, PAW (QW-404)	bare (solid)	bare (solid) or metal-cored
Consumable Insert for GTAW or PAW	<input type="radio"/> with <input type="radio"/> without <input checked="" type="radio"/> NA	NA
Welding position (1G, 5G, etc.) (QW-405)	1G	Groove: plate and pipe >24" O.D. : F ; for pipe <24" O.D. : F ; Fillet : F
Progression (uphill/downhill)	<input type="radio"/> Up <input type="radio"/> Down <input checked="" type="radio"/> NA	NA
Fuel gas for OFW (QW-408)	NA	NA
Backing Gas for GTAW, PAW, or GMAW	<input type="radio"/> with <input checked="" type="radio"/> without <input type="radio"/> NA	with and without
GMAW/FCAW transfer mode (QW-409)	NA	NA
Filler metal (QW-404)	Spec. 5.18	all F-No.6
Filler metal F-No.	Class.ER70S-6	
Weld deposit thickness for each welding proc. (mm) (Test Coupon Thickness for Fillet)	6	
3 Layers minimum	5	Up to 10 - All Fillet size
GTAW welding current type / polarity	<input type="radio"/> Yes <input type="radio"/> No <input checked="" type="radio"/> NA	--
	DC /EN	DC /EN

Guided Bend Test Results

Guided Bend Test Type QW-462.2 (Side) Results QW-462.3(a) (Trans.R&F) Type QW-462.3 (Long R&F) Results

Transverse	180° Satisfactory		
Transverse	180° Satisfactory		

Visual examination results QW-302.4) SATISFACTORY
Radiographic test results QW-304 and QW-305) NONE (For alternative qualification of groove welds by radiography)
Fillet Weld - Fracture Test -- Length and percent of defects -- mm
Macro Test Fusion -- Fillet leg size -- mm x -- mm Concavity/convexity -- mm
Welding test conducted by METAL POINT snc - CIVATE (LC)
Mechanical test conducted by Laboratorio T.O.S.I. srl - LEGNANO (MI)
Laboratory test No. 12P8072

We, the undersigned, certify that the statements in this record are correct and that the test welds were prepared, welded and tested in conformance with the requirements of the section IX of ASME Code BPV 2010 (2011a Addenda - July 1, 2011)

Date 27/12/2012

Test supervised by Italian Institute of Welding

CERTIFICATION AREA CSP IIS CERT S.R.L.

Della Ragione, Renato
dell'Istituto Italiano della Saldatura
L'ISPETTORE INCARICATO
(P.I. Renato Della Ragione)

Manufacturer
(Stamp and Signature)

METAL POINT S.n.c.

METAL POINT SNC

Via Del Ponte, 44 - 23862 CIVATE (LC)
Cod. Fisc. e Part. IVA 01892300136

WELDING OPERATOR
PERFORMANCE QUALIFICATION
WPQ

WPQR-N. LC0003/13
IIS Job N. C00002667



Company Name METAL POINT SNC - VIA DEL PONTE, 44 - 23862 CIVATE (LC)
Welder's name TENTORI DANIELE Clock Number NONE Stamp No. TD

Welding Process(es) a) GMAW
Type(s) a) Machine
Identification of WPS followed by welder during welding of test coupon METAL POINT 02/12 Rev.0
Base material(s) welded. SA - 516 Gr. 60 Thickness 15 (mm)

Machine Welding Var. for the Proc. Used (QW-361.2)

	Actual Values	Range qualified
Direct/remote visual control	<input checked="" type="radio"/> Direct <input type="radio"/> Remote	Direct visual control
Automatic voltage control (GTAW)	<input type="radio"/> with <input type="radio"/> without <input checked="" type="radio"/> NA	NA
Automatic joint tracking	<input type="radio"/> with <input checked="" type="radio"/> without <input type="radio"/> NA	with and without
<input checked="" type="radio"/> Plate <input type="radio"/> Pipe (Enter O.D., if Pipe)	PLATE	Plates and pipes 73 O.D. and over
Welding position (1G, 5G, etc.)	1G	Groove: plate and pipe >24" O.D. : F ; for pipe <24" O.D. : F ; Fillet : F
Consumable Insert	<input type="radio"/> with <input type="radio"/> without <input checked="" type="radio"/> NA	NA
Backing (metal, wld metal, welded from both sides, etc.) (QW-402) <input type="radio"/> Yes <input checked="" type="radio"/> No	without	With and without backing
Single or Multiple passes per side	<input type="radio"/> single <input type="radio"/> NA <input checked="" type="radio"/> multiple	single and multiple

Guided Bend Test Results

Guided Bend Test Type QW-462.2 (Side) Results QW-462.3 (Trans.R&F) Type QW-462.3 (Long R&F) Results

Visual examination results QW-302.4 SATISFACTORY

Radiographic test results QW-304 and QW-305 SATISFACTORY (For alternative qualification of groove welds by radiography)

Fillet Weld - Fracture Test -- Length and percent of defects -- mm

Macro Test Fusion -- Fillet leg size -- mm x -- mm Concavity/convexity -- mm

Welding test conducted by METAL POINT snc - CIVATE (LC)

Mechanical test conducted by IIS - LEGNANO (MI)

Laboratory test No. RT-2667/1

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Date 27/12/2012

Test supervised by Italian Institute of Welding
CERTIFICATION AREA CSP
Della Regione Lombardia
Istituto Italiano della Saldatura
L'ISPETTORE INCARICATO
(Pi. Renato Della Regione)

Manufacturer
(Stamp and Signature)

METAL POINT S.N.C.