Base Load Power Hub (BLPH)

WELDING OPERATORS LIST and
WELDER QUALIFICATIONS RECORD (WPQ)
H2 STORAGE VESSEL

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BREMBANA&ROLLE

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Revision / Change Log

Rev.	Description
00	Issue for Review (IFR)
01	Accepted for Construction (AFC)
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1	
2	
3	
4	

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BREMBANA&ROLLE

B&R Welders & Welding operators list
ASME IX

Stamp No.	Surname & Name	Stamp No.	Surname & Name
	Brembana & Rolle Albignasego & Marghera workshop		
S51	/	S85	/
S52	CATOZZO DAVIDE	S86	/
S53	CICALA EMANUELE	S87	/
S54	SITA DIOMBANA	S88	CIOBANU VALENTIN
S55	BALLOTTA ANDREA	S89	CRISTIAN FERRO
S56	TUIVERI FEDERICO	S90	MELATO TIZIANO
S57	LAZZARO FAUSTO	S91	DONÀ ANDREA
S58	BETTIN LUCIANO	S92	BONGOU JEAN
S59	MARTIN PARIDE	S93	/
S60	TIMPONE PIERPAOLO	S94	DI NATALE GIOSUÉ
S61	BENAISSOUN MONAIM	S95	MILOTIC ALAIN
S62	GARZOTTO MIRKO	S96	/
S63	LUGATO LUCA	S97	/
S64	DAL LAGO DAVIDE	S98	/
S65	RUSSO VINCENZO	S99	/
S66	VUJIC PEDRAG	S100	MIOTTO DENNIS
S67	STORACI FEDERICO		
S68	FILIPPONE MASSIMILIANO		
S69	LAZZARIN GUERRINO		
S70	MICHAEL MANFO		
S71	TASINATO FEDERICO		
S72	CORRADO PERONI		
S73	MIRKO GIBBIN		
S74	ZANELLATO OMAR		
S75	BELLOMIA FRANCESCO		
S76	DEVICENTI ANDREA		
S77	LEKAJ NICOLI		
S78	SALVO' CLAUDIO		
S79	PADOVANI SIMONE		
S80	ZORAN ERMAN		
S81	/		
S82	/		
S83	SCHRAULECH MORENO		
S84	LUCATO FABIO		

ELENCO AGGIORNATO AL 26.01.24

A. Sandonà

International Institute of Welding ☆ Personnel Qualification System ☆
I.W.T.
A. Sandonà
IT/IWT/170065A
Issued date 15/06/2017

BREMBANA&ROLLE

B&R Welders & Welding operators list
ASME IX

Stamp No.	Surname & Name	Stamp No.	Surname & Name
	Brembana & Rolle		
	Valbrembo Workshop		
S01	BONACINA DARIO		
S02	SCIROCCO NICOLA	S32	KHACHI ABDERRAHIM
S03	PARIKKATHRA SUNEESAN	S35	CAPELLI STEFANO
S04	BELLIGERANTE ROSARIO	S36	DIAGNE MBAYE ABABACAR
S05	PREVITALI ROBERTO	S37	
S06	GIUSTINONI CRISTIAN		
S07	BRUNO PIETRO	S14	PEZZOLI MAURO
S08	/	S31	RUZZINI VALERIO
S09	DONGHI FRANCESCO	S33	DRAGOSINOIU VASILE VALENTIN
S10	GARGANTINI MASSIMILIANO	S34	SPATARU FLORIAN CLAUDIU
S11	JOSEPH JOY	S38	GOTTI STEFANO
S12	IMPERATORE GENNARO		
S13	LA PIETRA ASTOLFO		
S14	PASAN KAKNJASEVIC		
S15	BONZI MICHELE		
S16	MAGLI ALESSANDRO		
S17	IORDACHE VALENTIN		
S18	STAN GEORGEL		
S19	FILIPPERI FABIO		
S20	PRIBESCU CONSTANTIN		
S21	RUGGERI ANDREA		
S22	ROTA DANILO		
S23	MOYOTTIL SURESH BABU		
S24	/		
S25	RAVASIO FEDERICO		
S26	/		
S27	/		
S28	MICELI DIEGO		
S29	/		
S30	GAMBIRASIO MATTIA		

ELENCO AGGIORNATO AL 05.03.24

M.C.

BREMBANA & ROLLE S.p.A.
M. CARMINATI
WELDING DEPARTMENT

BREMBANA&ROLLE

B&R Welders & Welding operators list for Rosetti Marino/Crosswind Hollande Kust Noord Wind Park Project (B&R job 23096)

H2 STORAGE VESSEL items V25001 A÷F

Brembana & Rolle Albignasego & Marghera workshop

Stamp No.	Surname & Name	Weld Process
S55	BALLOTTA ANDREA	GTAW SMAW SAW
S58	BETTIN LUCIANO	GTAW SMAW SAW
S60	TIMPONE PIERPAOLO	GTAW SMAW SAW
S61	BENAISSOUN MONAIM	GTAW SMAW SAW
S70	MICHAEL MANFO	GTAW SMAW
S71	TASINATO FEDERICO	GTAW SMAW SAW
S72	CORRADO PERONI	GTAW SMAW
S73	MIRKO GIBBIN	GTAW SMAW SAW
S74	ZANELLATO OMAR	SMAW SAW
S76	DEVICENTI ANDREA	GTAW SMAW
S77	LEKAJ NICOLI	SMAW SAW
S79	PADOVANI SIMONE	GTAW SMAW
S83	SCHRAULECH MORENO	GTAW SMAW
S84	LUCATO FABIO	GTAW
S88	CIOBANU VALENTIN	SAW
S90	MELATO TIZIANO	SAW
S91	DONÀ ANDREA	GTAW SMAW SAW
S92	BONGOU JEAN	GTAW SMAW
S100	MIOTTO DENNIS	SAW

Brembana & Rolle Valbrembo workshop

Stamp No.	Surname & Name	Weld Process
S03	PARIKKATHRA SUNEESAN	GTAW SMAW SAW
S06	GIUSTINONI CRISTIAN	GTAW SMAW SAW
S20	PRIBESCU CONSTANTIN	GTAW SMAW SAW
S28	MICELI DIEGO	GTAW SMAW SAW

Rev.	Date	Description	Issued by (W.E.)	Verified by (Q.C.M.)
0	09.05.2024	Issued for approval	A. Sandonà	M. Galli

I.W.T. A. Sandonà IT/WT/1170065A

BREMBANA & ROLLE S.P.A. ALBIGNASEGO - PD - ITALY QC MANAGER M.GALLI DATE:

BREMBANA&ROLLE

RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ)
(QW-301 Section IX ASME B.P.V Code)

W.P.Q. No. **S03 12/19**

Welder' s name: **PARIKKATHRA SUNEESAN** Identification No.: **S03**

TEST DESCRIPTION

Identific. of WPS followed: **CS GTAW SMAW** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 516 Gr. 70** Thickness(mm): **24**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW - SMAW	GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH	WITH or WITHOUT - WITH
■ Plate ☐ Pipe (enter diameter if pipe or tube):	N.A.	73 mm and OVER
Base metal P or S-No. to P or S-No.:	P-No.1 to P-No.1	PNo.1 ÷ 15F, 34, 41 ÷ 49
		(see note 1)
Filler metal or electrode specification(s) (SFA):	5.18 - 5.1	
Filler metal or electrode classification(s):	ER70S-3 - E7018-1	
Filler metal F-No.:	6 - 4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH - N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT - N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID - N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 3 mm	GTAW: UP to 3 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 21 mm	SMAW: Max. to be welded
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	2G	Groove: F - H
		Fillet: F - H
Vertical progression (uphill or downh	N.A.	N.A.
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.	WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN - N.A.	DCEN - N.A.
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Approved for Pressure Equipment Directive 97/68/UE on behalf of Lloyd's Register Espana ,S.A NoBo 0094
A. Monastra
Milan Office 07/02/19
Lloyd's Register Espana SA

Alternative radiographic examination result (QW-191): **NO**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **NO** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **Ultrasonic examination SATISFACTORY (See report WPQ S03 12/19 UT)**
Film or specimens evaluated by: **B&R Welding Engineer & TP Inspector** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: / Laboratory test no.: /
Welding supervised by: **B&R S.p.A. Welding Supervisor - Third part Inspector**

Lloyd's Register Verification Limited
A member of the Lloyd's Register group
Lloyd's Register
☑ Witnessed ☐ Monitored ☐ Reviewed
Alessandro Monastra
Milan Office 07/02/19

Notes:

1) And unassigned metals of similar chemical composition to these metals

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY	CHECKED AND APPROVED BY	Date
M.CARMINATI	**N.TOSTO**	**07.02.2019**

BREMBANA&ROLLE	RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ) (QW-301 Section IX ASME B.P.V Code)	W.O.P.Q. No. S03 01/19

Welder' s name: **PARIKKATHRA SUNEESAN** Identification No.: **S03**

TEST DESCRIPTION

Identific. of WPS followed: **CS SAW** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 516 Gr. 70** Thickness(mm): **35**
Base metal P or S-No.: **P-No. 1** to base metal P or S-No.: **P-No. 1** Position (2G,6G,3F,etc.): **1G**
■ Plate ☐ Pipe (enter diameter if pipe or tube): /
Filler metal (SFA) specification: **5.17** Filler metal or electrode classification: **EH12K**

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	MACHINE	MACHINE
Welding process:	SAW	SAW
Direct or remote visual control:	DIRECT	DIRECT
Automatic arc voltage control (GTAW):	N.A.	N.A.
Automatic joint tracking:	WITHOUT	WITH or WITHOUT
Welding position (2G, 6G, 3F, etc.):	1G	F
Consumable inserts (GTAW or PAW):	N.A.	N.A.
Backing (metal, weld metal, etc.):	WITH	WITH
Single or multiple passes per side:	MULTIPASS	SINGLE and MULTIPASS
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Approved for Pressure Equipment Directive 2014/68/UE on behalf of Lloyd's Register España S.A. NoBo 0094
A. Monastra Milan Office
Lloyd's Register España S.A.
20 DIC. 2020

Alternative radiographic examination result (QW-191): **UT SATISFACTORY**
Fillet weld-fracture test (QW-180): / Length and percent of defects: /
Macro examination (QW-184): / Fillet size (mm): / Concavity/convexity (mm): /
Other tests: **Ultrasonic examination SATISFACTORY (See report WPQ S03 01/19 UT)**
Film or specimens evaluated by: **Welding Engineer** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: / Laboratory test no.: /
Welding supervised by: **B&R S.p.A. Welding Supervisor - Third Part Inspector**

Notes:

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV.

PREPARED BY **M.CARMINATI**

CHECKED AND APPROVED BY **N.TOSTO**

Lloyd's Register Verification Limited
Incorporated into Lloyd's Register group
☐ Witnessed ☐ Monitored ☐ Reviewed
Alessandro Salvatore Monastra
Milan Office
Lloyd's Register
Date **22.01.19**

BREMBANA&ROLLE	RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ) (QW-301 Section IX ASME B.P.V Code)	W.O.P.Q. No. S06 01/23

Welder' s name: **GIUSTINONI CRISTIAN** Identification No.: **S06**

TEST DESCRIPTION

Identific. of WPS followed: **CS SAW** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 516 Gr. 70** Thickness(mm): **35**
Base metal P or S-No.: **P-No. 1** to base metal P or S-No.: **P-No. 1** Position (2G,6G,3F,etc.): **1G**
■ Plate ☐ Pipe (enter diameter if pipe or tube): **/**
Filler metal (SFA) specification: **5.17** Filler metal or electrode classification: **EH12K**

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	MACHINE	MACHINE
Welding process:	SAW	SAW
Direct or remote visual control:	DIRECT	DIRECT
Automatic arc voltage control (GTAW):	N.A.	N.A.
Automatic joint tracking:	WITHOUT	WITH or WITHOUT
Welding position (2G, 6G, 3F, etc.):	1G	F
Consumable inserts (GTAW or PAW):	N.A.	N.A.
Backing (metal, weld metal, etc.):	WITH	WITH
Single or multiple passes per side:	MULTIPASS	SINGLE and MULTIPASS
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **UT SATISFACTORY**
Fillet weld-fracture test (QW-180): / Length and percent of defects: /
Macro examination (QW-184): / Fillet size (mm): / Concavity/convexity (mm): /
Other tests: **Ultrasonic examination SATISFACTORY (See report WPQ S06 01/23 UT)**
Film or specimens evaluated by: **Welding Engineer** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: / Laboratory test no.: /
Welding supervised by: **B&R S.p.A. Welding Supervisor - Third Part Inspector**

Notes:

BUREAU VERITAS ITALIA WELDING 14
TITLE:
DATE:
WITNESSED ☐ REVIEW ☑ Date 01.03.23

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY **M.CARMINATI** CHECKED AND APPROVED BY **N.TOSTO**

BREMBANA&ROLLE

RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ)
(QW-301 Section IX ASME B.P.V Code)

W.P.Q. No. **S06 04/23**

Welder' s name: **GIUSTINONI CRISTIAN** Identification No.: **S15**

TEST DESCRIPTION

Identific. of WPS followed: **CS GTAW SMAW** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 516 Gr. 70** Thickness(mm): **24**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW - SMAW	GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH	WITH or WITHOUT - WITH
■ Plate ☐ Pipe (enter diameter if pipe or tube):	N.A.	73 mm and OVER
Base metal P or S-No. to P or S-No.:	P-No.1 to P-No.1	PNo.1 ÷ 15F, 34, 41 ÷ 49
		(see note 1)
Filler metal or electrode specification(s) (SFA):	5.18 - 5.1	
Filler metal or electrode classification(s):	ER70S-3 - E7018-1	
Filler metal F-No.:	6 - 4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH - N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT - N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID - N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 3 mm	GTAW: UP to 6 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 21 mm	SMAW: Max. to be welded
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	2G	Groove: F - H
		Fillet: F - H
Vertical progression (uphill or downh	N.A.	N.A.
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.	WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN - N.A.	DCEN - N.A.
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **NO**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **NO** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **See note**
Film or specimens evaluated by: **B&R Welding Engineer & TP Inspector** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: **/** Laboratory test no.: **/**
Welding supervised by: **B&R S.p.A. Welding Supervisor - Third part Inspector**

Notes:

1) And unassigned metals of similar chemical composition to these metals
Ultrasonic examination SATISFACTORY (See report WPQ S06 04/23 UT)
Magnetic examination SATISFACTORY (See report WPQ S06 04/23 MT)

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY **M.CARMINATI**
CHECKED AND APPROVED BY **N.TOSTO**
Date **02.03.2023**

BUREAU VERITAS ITALIA WELDING 14
FILE:
DATE:
WITNESSED ☐ REVIEW ☐

BREMBANA&ROLLE	RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ) (QW-301 Section IX ASME B.P.V Code)	W.P.Q. No. S20 12/19

Welder' s name: **PRIBESCU CONSTANTIN** Identification No.: **S20**

TEST DESCRIPTION

Identific. of WPS followed: **CS GTAW SMAW** ■ Test coupon ☐ Production weld

Specificat. of base metal(s): **SA 516 Gr. 70** Thickness(mm): **24**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW - SMAW	GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH	WITH or WITHOUT - WITH
■ Plate ☐ Pipe (enter diameter if pipe or tube):	N.A.	73 mm and OVER
Base metal P or S-No. to P or S-No.:	P-No.1 to P-No.1	PNo.1 ÷ 15F, 34, 41 ÷ 49 (see note 1)
Filler metal or electrode specification(s) (SFA):	5.18 - 5.1	
Filler metal or electrode classification(s):	ER70S-3 - E7018-1	
Filler metal F-No.:	6 - 4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH - N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT - N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID - N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 3 mm	GTAW: UP to 6 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 21 mm	SMAW: Max. to be welded
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	2G	Groove: F - H
		Fillet: F - H
Vertical progression (uphill or downh	N.A.	N.A.
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.	WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN - N.A.	DCEN - N.A.
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Approved for Pressure Equipment Directive 2014/68/UE on behalf of Lloyd's Register España S.A. No.0090
A. Monastra Milan Office
Lloyd's Register España SA
DIC. 2020

Alternative radiographic examination result (QW-191): **NO**

Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**

Macro examination (QW-184): **NO** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**

Other tests: **Ultrasonic examination SATISFACTORY (See report WPQ S20 12/19 UT)**

Film or specimens evaluated by: **B&R Welding Engineer & TP Inspector** Company: **Brembana & Rolle S.p.A.**

Mechanical tests conducted by: **/** Laboratory test no.: **/**

Welding supervised by: **B&R S.p.A. Welding Supervisor - Third part Inspector**

Notes:

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY **M.CARMINATI** CHECKED AND APPROVED BY **N.TOSTO** Date **07.02.2019**

Lloyd's Register Verification Limited
A member of the Lloyd's Register group
☐ Witnessed ☐ Monitored ☐ Reviewed
Alessandro Salvatore Monastra
Milan Office
Lloyd's Register

BREMBANA&ROLLE	RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ) (QW-301 Section IX ASME B.P.V Code)	W.O.P.Q. No. S20 01/19

Welder' s name: **PRIBESCU CONSTANTIN** Identification No.: **S20**

TEST DESCRIPTION

Identific. of WPS followed: **CS SAW** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 516 Gr. 70** Thickness(mm): **35**
Base metal P or S-No.: **P-No. 1** to base metal P or S-No.: **P-No. 1** Position (2G,6G,3F,etc.): **1G**
■ Plate ☐ Pipe (enter diameter if pipe or tube): **/**
Filler metal (SFA) specification: **5.17** Filler metal or electrode classification: **EH12K**

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

Approved for Pressure Equipment Directive 2014/68/UE on behalf of Lloyd's Register España S.A. NoBo 0094
A. Monastra
Milan Office
Lloyd's Register España S.A. 30 DIC. 2020

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	MACHINE	MACHINE
Welding process:	SAW	SAW
Direct or remote visual control:	DIRECT	DIRECT
Automatic arc voltage control (GTAW):	N.A.	N.A.
Automatic joint tracking:	WITHOUT	WITH or WITHOUT
Welding position (2G, 6G, 3F, etc.):	1G	F
Consumable inserts (GTAW or PAW):	N.A.	N.A.
Backing (metal, weld metal, etc.):	WITH	WITH
Single or multiple passes per side:	MULTIPASS	SINGLE and MULTIPASS
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **UT SATISFACTORY**
Fillet weld-fracture test (QW-180): / Length and percent of defects: /
Macro examination (QW-184): / Fillet size (mm): / Concavity/convexity (mm): /
Other tests: **Ultrasonic examination SATISFACTORY (See report WPQ S20 01/19 UT)**
Film or specimens evaluated by: **Welding Engineer** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: / Laboratory test no.: /
Welding supervised by: **B&R S.p.A. Welding Supervisor - Third Part Inspector**

Notes:

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV.

PREPARED BY **M.CARMINATI** CHECKED AND APPROVED BY **N.TOSTO** Date **21.01.19**

Lloyd's Register Verification Limited
A member of the Lloyd's Register group
Lloyd's Register
☐ Witnessed ☐ Monitored ☐ Reviewed
Alessandro Salvatore Monastra
Milan Office

BREMBANA&ROLLE	RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ) (QW-301 Section IX ASME B.P.V Code)	W.P.Q. No. S28 12/19

Welder' s name: **MICELI DIEGO** Identification No.: **S28**

TEST DESCRIPTION

Identific. of WPS followed: **CS GTAW SMAW** ■ Test coupon ☐ Production weld

Specificat. of base metal(s): **SA 516 Gr. 70** Thickness(mm): **24**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW - SMAW	GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH	WITH or WITHOUT - WITH
■ Plate ☐ Pipe (enter diameter if pipe or tube):	N.A.	73 mm and OVER
Base metal P or S-No. to P or S-No.:	P-No.1 to P-No.1	PNo.1 ÷ 15F, 34, 41 ÷ 49 (see note 1)
Filler metal or electrode specification(s) (SFA):	5.18 - 5.1	
Filler metal or electrode classification(s):	ER70S-3 - E7018-1	
Filler metal F-No.:	6 - 4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH - N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT - N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID - N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 3 mm	GTAW: UP to 6 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 21 mm	SMAW: Max. to be welded
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	2G	Groove: F - H
		Fillet: F - H
Vertical progression (uphill or downh	N.A.	N.A.
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.	WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN - N.A.	DCEN - N.A.
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Approved for Pressure Equipment Directive 2014/68/UE on behalf of Lloyd's Register España S.A. No.0094
A. Monastra
Milan Office
Lloyd's Register España SA
10 DIC. 2020

Alternative radiographic examination result (QW-191): **NO**

Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**

Macro examination (QW-184): **NO** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**

Other tests: **Ultrasonic examination SATISFACTORY (See report WPQ S28 12/19 UT)**

Film or specimens evaluated by: **B&R Welding Engineer & TP Inspector** Company: **Brembana & Rolle S.p.A.**

Mechanical tests conducted by: **/** Laboratory test no.: **/**

Welding supervised by: **B&R S.p.A. Welding Supervisor - Third part Inspector**

Notes:

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV.

PREPARED BY **M.CARMINATI**

CHECKED AND APPROVED BY **N.TOSTO**

Date **21.08.2019**

Lloyd's Register Verification Limited
A member of the Lloyd's Register group
☐ Witnessed ☐ Monitored ☐ Reviewed
Alessandro Salvatore Monastra
Milan Office

BREMBANA&ROLLE	RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ) (QW-301 Section IX ASME B.P.V Code)	W.O.P.Q. No. S28 01/19

Welder' s name: **MICELI DIEGO** Identification No.: **S28**

TEST DESCRIPTION

Identific. of WPS followed: **CS SAW** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 516 Gr. 70** Thickness(mm): **35**
Base metal P or S-No.: **P-No. 1** to base metal P or S-No.: **P-No. 1** Position (2G,6G,3F,etc.): **1G**
■ Plate ☐ Pipe (enter diameter if pipe or tube): **/**
Filler metal (SFA) specification: **5.17** Filler metal or electrode classification: **EH12K**

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	MACHINE	MACHINE
Welding process:	SAW	SAW
Direct or remote visual control:	DIRECT	DIRECT
Automatic arc voltage control (GTAW):	N.A.	N.A.
Automatic joint tracking:	WITHOUT	WITH or WITHOUT
Welding position (2G, 6G, 3F, etc.):	1G	F
Consumable inserts (GTAW or PAW):	N.A.	N.A.
Backing (metal, weld metal, etc.):	WITH	WITH
Single or multiple passes per side:	MULTIPASS	SINGLE and MULTIPASS
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Approved for Pressure Equipment Directive 2014/68/UE on behalf of Lloyd's Register España ,S.A. NoBo 0004
A. Monastra Milan Office
28 DIC. 2020
Lloyd's Register España SA

Alternative radiographic examination result (QW-191): **UT SATISFACTORY**
Fillet weld-fracture test (QW-180): / Length and percent of defects: /
Macro examination (QW-184): / Fillet size (mm): / Concavity/convexity (mm): /
Other tests: **Ultrasonic examination SATISFACTORY (See report WPQ S28 01/19 UT)**
Film or specimens evaluated by: **Welding Engineer** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: / Laboratory test no.: /
Welding supervised by: **B&R S.p.A. Welding Supervisor - Third Part Inspector**

Notes:

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY **M.CARMINATI**
CHECKED AND APPROVED BY **N.TOSTO**
Date **23.08.19**

Lloyd's Register Verification Limited
A member of the Lloyd's Register group
☑ Witnessed ☑ Monitored ☐ Reviewed
Alessandro Salvatore Monastra
Milan Office

555

ROLLE S.p.A. Albignasego (PD) ITALY	WELDERS PERFORMANCE QUALIFICATION (for manual and semiautomatic welding process) QW-484	WPQ 5 /E

BALLOTTA	ANDREA	5	GTAW02	0
Surname	Name(s)	Stamp No.	WPS used	Rev.

QW	Essential Variables	Actual Values from Coupon or Production Weld	Qualified Ranges	
352-356	Process(s)	1: GTAW manual 2: SMAW	1: GTAW manual 2: SMAW	
Info. onl.	Base Material(s) T	SA106 Gr.B T: 23.01	to SA106 Gr.B T: 23.01	
403.18	P-No. to P-No.	1 Gr.1 to 1 Gr.1	P-No 1 to 11, 34, 41 to 49	
403.16	Plate /Pipe O.D. <73 or >73mm	8" (219.1mm)	>=2.7/8" (73mm) and plate	
405.1	Position	1: 6G 2: 6G	Groove	Fillet
	Plate and pipe over 24" (610mm) O.D.		1:ALL 2: ALL	1:ALL 2: ALL
	Pipe 73mm <= O.D. <= 610mm		1:ALL 2: ALL	1:ALL 2: ALL
	Pipe > 73mm O.D		1:ALL 2: ALL	1:ALL 2: ALL
	Pipe unlimited O.D.		1:-- 2:--	1:ALL 2: ALL
405.3	Vertical up or down	1: Upward 2: Upward	1: Upward	2: Upward
402.4	Backing	1: ☐YES ☒NO 2: ☒YES ☐NO	1: With/Without	2: With backing
404.30	t: Weld metal deposit	1: 3 2: 20.1	1: 6 max.	2:up to max. to weld
404.32	t: Limit (GMAW Short Circ.)	a) T<1/2":/ :/ 1.1XT b) T>1/2":/ :/ 2T-8"	/ max.	
409.2	Tranf. Mode Spray Puls. Clobular Short Circ.	n.a.	1: n.a.	2: n.a.
409.4	AC - DC (GTAW) only	DC/SP	DC/SP	
404.15	Chge F-No. SMAW except F4 = F1 - F4	1: F-No. 6 2: F-No. 4	1: F-No. 6	2: F-No.1 to 4 with support
404.22	± Insert (GTAW only)	☐ with ☒ without	Without insert	
404.23	Filler metal product form (GTAW)	Solid rod	Solid rod or metal cored	
408.8	(-) Inert backing	1: Without 2: N.A.	1: With/Without	2: N.A.
404.14	± Filler (GTAW)	1: With 2: N.A.	1: With	2: N.A.

QW-161	GUIDED BEND TEST		
Type QW-462.3 (a) (b)	Results:	Type QW-462.2	Results:
/ (Face Bend)	/	N. 2 (Side Bend)	SATISFACTORY
/ (Root Bend)	/	N. 2 (Side Bend)	SATISFACTORY

QW-304 and QW-305 : RADIOGRAPHIC TEST Results: SATISFACTORY

QW-302.4: VISUAL EXAMINATION Results: SATISFACTORY

QW-181.2 FILLET WELD TEST QW-462.4 (b) or (c)

Location of track or tear:

Length: N.A. % Results: N.A.

QW-184 MACRO EXAMINATION QW-462.4 (b)

Length of indication: N.A. Concavity: N.A. Convexity: N.A.

Fillet leg size: N.A. Results: N.A.

Welding test conducted by: WELDER FOREMAN – M.PIVA

Mechanical / radiographic tests conducted by: Q.C. INSP. - A. DONA' Laboratory test no.: SE/11

We certify that the statements in this record are correct and that welds were prepared, welded and tested according to Section IX of the ASME Code.

Rolle s.p.a. — Organization / Manufacturer

IIW-International Welding Technologist
Alessandro Dona
IWT/IT 30364
Signature

18 | 08 | 11
Day Month Year

01-09-2009
BREMBANA & ROLLE S.p.A.
WELDING DEPT. - A. DONA'
☒ REVIEWED ☐ WITNESSED

SGS Italia S.p.A.

655

ROLLE SPA ALBIGNASEGO PADOVA	WELDING OPERATOR QUALIFICATION (automatic and machine welding) QW-360	WPQ 5 /H

BALLOTTA	ANDREA	5	SAW01	0
Surname	First Name(s)	Stamp No.	WPS used	Rev.

QW	Welding Variables	Actual Values from Coupon or Production Weld	Qualified Ranges
	GENERAL VARIABLES		
Info. onl.	Pipe or Plate	Plate	Plate and pipe over 24"
Info. onl.	Base Material(s) / T	SA516 Gr.60 T: 25	to SA516 Gr.60 T: 25
Info. onl.	P-No to P-No	1 to 1	P-No 1 to 11, 34, 41 to 49
	AUTOMATIC - WELDING		
361.1(a)	Process(s)	N.A	N.A.
361.1(b)	Change from Autom. to Mach.	N.A.	N.A.
	MACHINE – WELDING		
361.2 (a)	Process(s)	SAW	SAW
361.2 (b)	Direct Vis ⇆ Remote Control	☒ Direct ☐ Remote	DIRECT
361.2 (c)	Autom. Volt. Control (GTAW)	N.A.	N.A.
361.2 (d)	Autom. Joint Tracking	☐ yes ☒ no	YES/NO
361.2 (e)	Welding Position	1G	Groove: F; Fillet: F
361.2 (f)	Consumable Inserts	☐ yes ☒ no	n.a.
361.2 (g)	Backing	☒ yes ☐ no	Weld metal
361.2 (h)	Single Pass Multiple Pass	☐ single ☒ multiple	Multiple / Single

QW-161	GUIDED BEND TEST		
Type QW-462.3 (a) (b)	Results:	Type QW-462.2	Results:
(Face Bend)	/	no. 2 (Side Bend)	Satisfactory
(Root Bend)	/	no. 2 (Side Bend)	Satisfactory

QW-304 and QW-305 : RADIOGRAPHIC TEST Results: SATISFACTORY

QW-302.4: VISUAL EXAMINATION Results: SATISFACTORY

QW-181.2 FILLET WELD TEST QW-462.4 (b) or (c)

Location of track or tear:

Length: N.A. % Results: N.A.

QW-184 MACRO EXAMINATION QW-462.4 (b)

Length of indication: N.A. Concavity: N.A. Convexity: N.A.

Fillet leg size: N.A. Results: N.A.

Welding test conducted by: WELDER FOREMAN

Mechanical / radiographic tests conducted by: Q.C. INSP. - A. DONA' Laboratoy test no.: SH/1

We certify that the statements in this record are correct and that welds were prepared, welded and tested according to Section IX of the ASME Code.

Rolle s.p.a. — Organization / Manufacturer

IIW-International Welding Technologist
Alessandro Dona'
IWT/IT 3950
Signature

18 | 08 | 11
Day Month Year

BREMBANA & ROLLE S.p.A.
WELDING DEPT. - A. DONA'
☒ REVIEWED ☐ WITNESSED
01/04/14

SGS Italia S.p.A.

BREMBANA&ROLLE

RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ)
(QW-301 Section IX ASME B.P.V Code)

W.P.Q. No. **S58 01/19**

Welder' s name: **BETTIN LUCIANO** Identification No.: **S58**

TEST DESCRIPTION

Identific. of WPS followed: **pWPS 32/19 (reference PQR 32/19)** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 508 Gr.3 Cl.2** Thickness(mm): **88**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES		RANGE QUALIFIED	
Welding process(es):	GTAW - SMAW		GTAW - SMAW	
Type (ie:manual,semi-auto) used:	MANUAL		MANUAL	
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH		WITH or WITHOUT - WITH	
■ Plate ☐ Pipe (enter diameter if pipe or tube):	PLATE		73 mm and OVER	
Base metal P or S-No. to P or S-No.:	P-No.3 to P-No.3		PNo.1 ÷ 15F, 34, 41 ÷ 49 (see note 1)	
Filler metal or electrode specification(s) (SFA):	5.28	5.5		
Filler metal or electrode classification(s):	ER100S-G	E9018-G H4		
Filler metal F-No.:	6	4	6 - 1, 2, 3, 4 with BACKING	
With or without filler metal (GTAW or PAW):	WITH	N.A.	WITH - N.A.	
Consumables inserts (GTAW or PAW):	WITHOUT	N.A.	WITHOUT - N.A.	
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID	N.A.	SOLID & METAL CORED - N.A.	
Weld deposit "t" for each welding process:				
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 2 mm		GTAW: UP to 4 mm	
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 26 mm		SMAW: ALL	
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.		N.A.	
Welding position (1G,2G,6G,3F etc.):	1G		Groove: F	
			Fillet: F	
Vertical progression (uphill or downl	N.A.		N.A.	
Type of fuel gas (OFW):	N.A.		N.A.	
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.		WITH or WITHOUT - N.A.	
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.		N.A.	
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN	N.A.	DCEN	N.A.
Other:	NO		NO	

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: PQR 32/19 VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ■ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: PQR 32/19 UT)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **SATISFACTORY (note 2)** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: PQR 32/19 MT)**
Film or specimens evaluated by: **B&R QCM / Third part inspector** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: **Sigma Tre Lab** Laboratory test no.: **1464**
Welding supervised by: **B&R S.p.A. Welding Supervisor / Third part inspector**

Notes:
1) And unassigned metals of similar chemical composition to these metals
2) Mechanical tests performed by Sigma Tre Lab (See Laboratory Test Report n° 1907752 - 1907752)

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

I.W.T. A. Sandona' IT/IWT/170065A issue date 15/05/2017

PREPARED BY **A. SANDONA'**

BREMBANA & ROLLE S.P.A. ALBIGNASEGO (PD) ITALY Q.C. MANAGER M. GALLI DATE: / /

CHECKED AND APPROVED BY **B&R QCM: M. GALLI / Third part inspector: U.BREDA**

Date **26/06/2019**

BREMBANA&ROLLE

RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ)

(QW-301 Section IX ASME B.P.V Code)

W.O.P.Q. No. **S58 02/19**

Welder' s name: **BETTIN LUCIANO** Identification No.: **S58**

TEST DESCRIPTION

Identific. of WPS followed: **pWPS 32/19 (reference PQR 32/19)** ■ Test coupon ☐ Production weld

Specificat. of base metal(s): **SA 508 Gr.3 Cl.2** Thickness(mm): **88**

Base metal P or S-No.: **P-No. 3** to base metal P or S-No.: **P-No. 3** Position (2G,6G,3F,etc.): **1G**

■ Plate ☐ Pipe (enter diameter if pipe or tube): /

Filler metal (SFA) specification: **5.23** Filler metal or electrode classification: **F3**

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	MACHINE	MACHINE
Welding process:	SAW	SAW
Direct or remote visual control:	DIRECT	DIRECT
Automatic arc voltage control (GTAW):	N.A.	N.A.
Automatic joint tracking:	WITHOUT	WITH OR WITHOUT
Welding position (2G, 6G, 3F, etc.):	1G	F
Consumable inserts (GTAW or PAW):	N.A.	N.A.
Backing (metal, weld metal, etc.):	WITH	WITH
Single or multiple passes per side:	MULTIPASS	SINGLE AND MULTIPASS
Ø Limits:	PLATE	73 mm and OVER
Other:		

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: PQR 32/19 VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ■ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result
SIDE BEND	SATISFACTORY (note 1)		
SIDE BEND	SATISFACTORY (note 1)		
SIDE BEND	SATISFACTORY (note 1)		
SIDE BEND	SATISFACTORY (note 1)		

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: PQR 32/19 UT)**

Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**

Macro examination (QW-184): **SATISFACTORY (note 1)** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**

Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: PQR 32/19 MT)**

Film or specimens evaluated by: **B&R QCM / Third part inspector** Company: **Brembana & Rolle S.p.A.**

Mechanical tests conducted by: **Sigma Tre Lab** Laboratory test no.: **1464**

Welding supervised by: **B&R S.p.A. Welding Supervisor / Third part inspector**

Notes:

1) Mechanical tests performed by Sigma Tre Lab (See Laboratory Test Report n° 1907752 - 1907752)

I.W.T. A. Sandona' IT/WT/170065A issue date 15/06/2017

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY	CHECKED AND APPROVED BY	Date
A. SANDONA'	**B&R QCM: M. GALLI / Third part inspector: U.BREDA**	**26/06/2019**

BREMBANA & ROLLE S.p.A. ALBIGNASEGO (PD) - ITALY Q.C. MANAGER M.GALLI DATE: / /

BREMBANA&ROLLE

RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ)

(QW-301 Section IX ASME B.P.V Code)

W.P.Q. No. **S60 04/23**

Welder' s name: **TIMPONE PIERPAOLO** Identification No.: **S60**

TEST DESCRIPTION

Identific. of WPS followed: **23003-PQR-01** ■ Test coupon ☐ Production weld

Specificat. of base metal(s): **SA 387 Gr.11 Cl.2** Thickness(mm): **60**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES		RANGE QUALIFIED	
Welding process(es):	GTAW - SMAW		GTAW - SMAW	
Type (ie:manual,semi-auto) used:	MANUAL		MANUAL	
Backing (metal, weld metal,double welded, etc.):				
■ Plate ☐ Pipe (enter diameter if pipe or tube):	WITHOUT - WITH		WITH or WITHOUT - WITH	
Base metal P or S-No. to P or S-No.:	PLATE		73 mm and OVER	
	P-No.4 to P-No.4		PNo.1 ÷ 15F, 34, 41 ÷ 49	
			(see note 1)	
Filler metal or electrode specification(s) (SFA):	5.28	5.5		
Filler metal or electrode classification(s):	ER80S-G	E8018-B2		
Filler metal F-No.:	6	4	6 - 1, 2, 3, 4 with BACKING	
With or without filler metal (GTAW or PAW):	WITH	N.A.	WITH - N.A.	
Consumables inserts (GTAW or PAW):	WITHOUT	N.A.	WITHOUT - N.A.	
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID	N.A.	SOLID & METAL CORED - N.A.	
Weld deposit "t" for each welding process:				
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 2 mm		GTAW: UP to 4 mm	
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 23 mm		SMAW: ALL	
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.		N.A.	
Welding position (1G,2G,6G,3F etc.):	1G		Groove: F	
			Fillet: F	
Vertical progression (uphill or down!	N.A.		N.A.	
Type of fuel gas (OFW):	N.A.		N.A.	
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.		WITH or WITHOUT - N.A.	
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.		N.A.	
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN	N.A.	DCEN	N.A.
Other:	NO		NO	

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: 23003-PQR-01 VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ■ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: 23003-PQR-01 UT)**

Fillet weld-fracture test (QW-180): **N.A.** Length and percent of defects: **N.A.**

Macro examination (QW-184): **N.A.** Fillet size (mm): **N.A.** Concavity/convexity (mm): **N.A.**

Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: 23003-PQR-01 MT)**

Film or specimens evaluated by: **B&R W.E. / Third part inspector** Company: **Brembana & Rolle S.p.A.**

Mechanical tests conducted by: **Sigma Tre Lab** Laboratory test no.: **1464**

Welding supervised by: **B&R S.p.A. Welding Supervisor / Third part inspector**

BUREAU VERITAS ITALIA WELDING 14
IT FILE:
WITNESSED ☐ REVIEW ☐

Notes:

1) And unassigned metals of similar chemical composition to these metals

2) Mechanical tests performed by Sigma Tre Lab (See Laboratory Test Report n° 2023070766 - 2023070767)

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

I.W.T. International Institute of Welding A. Sandona' IT/IWT/170065A ref. issued date 19/05/20 Technical Qualification Welding

PREPARED BY **A. SANDONA'**

CHECKED AND APPROVED BY **N. TOSTO**

Date **30/08/2023**

BREMBANA&ROLLE

RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ)
(QW-301 Section IX ASME B.P.V Code)

W.O.P.Q. No. **S60 05/23**

Welder' s name: **TIMPONE PIERPAOLO** Identification No.: **S60**

TEST DESCRIPTION

Identific. of WPS followed: **23003-PQR-01** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 387 Gr.11 Cl.2** Thickness(mm): **60**
Base metal P or S-No.: **P-No. 4** to base metal P or S-No.: **P-No. 4** Position (2G,6G,3F,etc.): **1G**
■ Plate ☐ Pipe (enter diameter if pipe or tube): /
Filler metal (SFA) specification: **5.23** Filler metal or electrode classification: **EB2R**

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	MACHINE	MACHINE
Welding process:	SAW	SAW
Direct or remote visual control:	DIRECT	DIRECT
Automatic arc voltage control (GTAW):	N.A.	N.A.
Automatic joint tracking:	WITHOUT	WITH OR WITHOUT
Welding position (2G, 6G, 3F, etc.):	1G	F
Consumable inserts (GTAW or PAW):	N.A.	N.A.
Backing (metal, weld metal, etc.):	WITH	WITH
Single or multiple passes per side:	MULTIPASS	SINGLE AND MULTIPASS
Ø Limits:	PLATE	73 mm and OVER
Other:		

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: 23003-PQR-01 VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ■ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result
SIDE BEND	SATISFACTORY (note 1)		
SIDE BEND	SATISFACTORY (note 1)		
SIDE BEND	SATISFACTORY (note 1)		
SIDE BEND	SATISFACTORY (note 1)		

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: 23003-PQR-01 UT)**
Fillet weld-fracture test (QW-180): **N.A.** Length and percent of defects: **N.A.**
Macro examination (QW-184): **N.A.** Fillet size (mm): **N.A.** Concavity/convexity (mm): **N.A.**
Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: 23003-PQR-01 MT)**
Film or specimens evaluated by: **B&R W.E. / Third part inspector** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: **Sigma Tre Lab** Laboratory test no.: **1464**
Welding supervised by: **B&R S.p.A. Welding Supervisor / Third part inspector**

BUREAU VERITAS ITALIA WELDING 14
IT FILE
DATE
WITNESSED ☐ REVIEW ☑

Notes:
1) Mechanical tests performed by Sigma Tre Lab (See Laboratory Test Report n° 2023070766 - 2023070767)

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY **A. SANDONA'**
CHECKED AND APPROVED BY **N. TOSTO**
Date **30/08/2023**

BREMBANA&ROLLE	RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ) (QW-301 Section IX ASME B.P.V Code)	W.P.Q. No. S61 04/19

Welder' s name: **BENAISSOUN MONAIM** Identification No.: **S61**

TEST DESCRIPTION

Identific. of WPS followed: **pWPS 54/19 (reference PQR 54/19)** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 533 Gr.B Cl.2 - SA 516 Gr.70** Thickness(mm): **43**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW - SMAW	GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH	WITH or WITHOUT - WITH
■ Plate ☐ Pipe (enter diameter if pipe or tube):	PL. 43mm	73 mm and OVER
Base metal P or S-No. to P or S-No.:	P-No.1 to P-No.1	PNo.1 ÷ 15F, 34, 41 ÷ 49 (see note 1)
Filler metal or electrode specification(s) (SFA):	5.18 5.1	
Filler metal or electrode classification(s):	ER70S-3 E7018-1H4	
Filler metal F-No.:	6 4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 3 mm (see note 2)	GTAW: UP to 6 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 20 mm (see note 2)	SMAW: ALL
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	1G	Groove: F
		Fillet: F
Vertical progression (uphill or downhill):	N.A.	N.A.
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.	WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN N.A.	DCEN N.A.
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: PQR 54/19 VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ■ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: PQR 54/19 UT)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **SATISFACTORY (note 2)** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: PQR 54/19 MT)**
Film or specimens evaluated by: **B&R QCM / Third part inspector** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: **Sigma Tre Lab** Laboratory test no.: **1464**
Welding supervised by: **B&R S.p.A. Welding Supervisor / Third part inspector**

Notes:
1) And unassigned metals of similar chemical composition to these metals
2) Mechanical tests performed by Sigma Tre Lab (See Laboratory Test Report n° 1907852 - 1907853)

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY A. Sandona
A. SANDONA
IT/IWT/170065A
exp date 15.06.2017

CHECKED AND APPROVED BY
B&R QCM: M. GALLI / Third part inspector: U.BREDA

Date
30/08/2019

BREMBANA&ROLLE

RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ)
(QW-301 Section IX ASME B.P.V Code)

W.O.P.Q. No. **S61 01/20**

Welder' s name: **BENAISSOUN MOUNAIM** Identification No.: **S61**

TEST DESCRIPTION

Identific. of WPS followed: **CS SAW** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 516 Gr. 70** Thickness(mm): **38**
Base metal P or S-No.: **P-No. 1** to base metal P or S-No.: **P-No. 1** Position (2G,6G,3F,etc.): **1G**
■ Plate ☐ Pipe (enter diameter if pipe or tube): /
Filler metal (SFA) specification: **5.17** Filler metal or electrode classification: **EH12K**

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	MACHINE	MACHINE
Welding process:	SAW	SAW
Direct or remote visual control:	DIRECT	DIRECT
Automatic arc voltage control (GTAW):	N.A.	N.A.
Automatic joint tracking:	WITHOUT	WITH or WITHOUT
Welding position (2G, 6G, 3F, etc.):	1G	F
Consumable inserts (GTAW or PAW):	N.A.	N.A.
Backing (metal, weld metal, etc.):	WITH	WITH
Single or multiple passes per side:	MULTIPASS	SINGLE and MULTIPASS
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **No**
Fillet weld-fracture test (QW-180): **No** Length and percent of defects: /
Macro examination (QW-184): **No** Fillet size (mm): / Concavity/convexity (mm): **No**
Other tests: **UT SATISFACTORY (See report WPQ S61 01/20 UT)**
Film or specimens evaluated by: **Welding Engineer** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: / Laboratory test no.: /
Welding supervised by: **B&R S.p.A. Welding Supervisor**

Notes:

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY **A.SANDONA** A. Sandonà IT/IWT/170065A issue date 15.06.2017
CHECKED AND APPROVED BY **N.TOSTO**
Date **21.02.20**

BREMBANA&ROLLE	RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ) (QW-301 Section IX ASME B.P.V Code)	W.P.Q. No. S70 01/22

Welder' s name: **MICHAEL MANFO** Identification No.: **S70**

TEST DESCRIPTION

Identific. of WPS followed: **C.4253 WPS W02 / nozzle 4A** ■ Test coupon ☐ Production weld

Specificat. of base metal(s): **SA 387 Gr.11 Cl.2 to SA 336 F11 Cl.3** Thickness(mm): **66**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW - SMAW	GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH	WITH or WITHOUT - WITH
■ Plate ☐ Pipe (enter diameter if pipe or tube):	Plate	73 mm and OVER
Base metal P or S-No. to P or S-No.:	P-No.4 to P-No.4	PNo.1 ÷ 15F, 34, 41 ÷ 49 (see note 1)
Filler metal or electrode specification(s) (SFA):	5.28 5.5	
Filler metal or electrode classification(s):	ER80S-G E8018-B2 H4R	
Filler metal F-No.:	6 4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 3 mm	GTAW: UP to 6 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 63 mm	SMAW: Max. to be welded
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	1G	Groove: F (Ø≥73mm)
		Fillet/Tack weld: F
Vertical progression (uphill or downhill):	No	No
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.	WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN N.A.	DCEN N.A.
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (see report 1142-VT 4A)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **NO**

Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**

Macro examination (QW-184): **NO** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**

Other tests: **MT and UT SATISFACTORY (see reports 1142-MT 4A and 1142-UT 4A)**

Film or specimens evaluated by: **W.E. / Third Party inspector** Company: **B&R / Lloyd's register**

Mechanical tests conducted by: **NO** Laboratory test no.: **NO**

Welding supervised by: **B&R S.p.A. Welding Supervisor / Third Party inspector**

Notes:

1) And unassigned metals of similar chemical composition to these metals

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY	CHECKED AND APPROVED BY	Date
A. SANDONA'	**M. GALLI**	**19.09.2022**

BREMBANA&ROLLE

RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ)

(QW-301 Section IX ASME B.P.V Code)

W.P.Q. No. **S71 01/23**

Welder' s name: **TASINATO FEDERICO** Identification No.: **S71**

TEST DESCRIPTION

Identific. of WPS followed: **23014-PQR-01** ■ Test coupon ☐ Production weld

Specificat. of base metal(s): **SA 387 Gr.11 Cl.2** Thickness(mm): **75**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW - SMAW	GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH	WITH or WITHOUT - WITH
■ Plate ☐ Pipe (enter diameter if pipe or tube):	PLATE	73 mm and OVER
Base metal P or S-No. to P or S-No.:	P-No.4 to P-No.4	PNo.1 ÷ 15F, 34, 41 ÷ 49
		(see note 1)
Filler metal or electrode specification(s) (SFA):	5.28 5.5	
Filler metal or electrode classification(s):	ER80S-G E8018-B2	
Filler metal F-No.:	6 4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 2 mm	GTAW: UP to 4 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 42 mm	SMAW: ALL
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	1G	Groove: F
		Fillet: F
Vertical progression (uphill or downl	N.A.	N.A.
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.	WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN N.A.	DCEN N.A.
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: 23014-PQR-01 VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ■ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		

BUREAU VERITAS ITALIA WELDING 14
IT FILE
DATE
WITNESSED REVIEW

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: 23014-PQR-01 UT)**

Fillet weld-fracture test (QW-180): **N.A.** Length and percent of defects: **N.A.**

Macro examination (QW-184): **N.A.** Fillet size (mm): **N.A.** Concavity/convexity (mm): **N.A.**

Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: 23014-PQR-01 MT)**

Film or specimens evaluated by: **B&R W.E. / Third part inspector** Company: **Brembana & Rolle S.p.A.**

Mechanical tests conducted by: **Sigma Tre Lab** Laboratory test no.: **1464**

Welding supervised by: **B&R S.p.A. Welding Supervisor / Third part inspector**

Notes:

1) And unassigned metals of similar chemical composition to these metals

2) Mechanical tests performed by Sigma Tre Lab (See Laboratory Test Report n° 2023080297 - 2023080298)

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

International Institute of Welding A. Sandonà IT/IWI/1706651 issued 15/06/2017

PREPARED BY	CHECKED AND APPROVED BY	Date
A. SANDONA'	N.TOSTO	18/08/2023

BREMBANA&ROLLE

RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ)

(QW-301 Section IX ASME B.P.V Code)

W.O.P.Q. No. S71 02/23

Welder' s name: TASINATO FEDERICO Identification No.: S71

TEST DESCRIPTION

Identific. of WPS followed: 23014-PQR-01 ■ Test coupon ☐ Production weld

Specificat. of base metal(s): SA 387 Gr.11 Cl.2 Thickness(mm): 75

Base metal P or S-No.: P-No. 4 to base metal P or S-No.: P-No. 4 Position (2G,6G,3F,etc.): 1G

■ Plate ☐ Pipe (enter diameter if pipe or tube): /

Filler metal (SFA) specification: 5.23 Filler metal or electrode classification: EB2R

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	MACHINE	MACHINE
Welding process:	SAW	SAW
Direct or remote visual control:	DIRECT	DIRECT
Automatic arc voltage control (GTAW):	N.A.	N.A.
Automatic joint tracking:	WITHOUT	WITH OR WITHOUT
Welding position (2G, 6G, 3F, etc.):	1G	F
Consumable inserts (GTAW or PAW):	N.A.	N.A.
Backing (metal, weld metal, etc.):	WITH	WITH
Single or multiple passes per side:	MULTIPASS	SINGLE AND MULTIPASS
Ø Limits:	PLATE	73 mm and OVER
Other:		

RESULTS

Visual Examination of Completed Weld (QW-302.4): SATISFACTORY (See report n°: 23014-PQR-01 VT)

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ■ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result
SIDE BEND	SATISFACTORY (note 1)		
SIDE BEND	SATISFACTORY (note 1)		
SIDE BEND	SATISFACTORY (note 1)		
SIDE BEND	SATISFACTORY (note 1)		

BUREAU VERITAS ITALIA WELDING 14
IT FILE:
DATE
WITNESSED J REVIEW

Alternative radiographic examination result (QW-191): SATISFACTORY (See report n°: 23014-PQR-01 UT)

Fillet weld-fracture test (QW-180): N.A. Length and percent of defects: N.A.

Macro examination (QW-184): N.A. Fillet size (mm): N.A. Concavity/convexity (mm): N.A.

Other tests: MAGNETIC PARTICLE - SATISFACTORY (See report n°: 23014-PQR-01 MT)

Film or specimens evaluated by: B&R W.E. / Third part inspector Company: Brembana & Rolle S.p.A.

Mechanical tests conducted by: Sigma Tre Lab Laboratory test no.: 1464

Welding supervised by: B&R S.p.A. Welding Supervisor / Third part inspector

Notes:

1) Mechanical tests performed by Sigma Tre Lab (See Laboratory Test Report n° 2023080297 - 2023080298)

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

I.W.I. A. Sandona IT/IWT/1700 issued: 15062017 International Institute of Welding System Certification Body

PREPARED BY A. SANDONA' CHECKED AND APPROVED BY N. TOSTO Date 18/08/2023

BREMBANA&ROLLE

RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ)
(QW-301 Section IX ASME B.P.V Code)

W.P.Q. No. **S72 01/19**

Welder' s name: **PERONI CORRADO** Identification No.: **S72**

TEST DESCRIPTION

Identific. of WPS followed: **W06 (joint F5-Support brackets/Job 4169-0477)** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 516 Gr.70 to SA 765 Gr.IV** Thickness(mm): **25**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW - SMAW	GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH	WITH or WITHOUT - WITH
■ Plate ☐ Pipe (enter diameter if pipe or tube):	PL. 25mm	73 mm and OVER
Base metal P or S-No. to P or S-No.:	P-No.1 to P-No.1	PNo.1 ÷ 15F, 34, 41 ÷ 49 (see note 1)
Filler metal or electrode specification(s) (SFA):	5.18 5.1	
Filler metal or electrode classification(s):	ER70S-3 E7018-1H4	
Filler metal F-No.:	6 4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 4 mm (see note 2)	GTAW: UP to 8 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 21 mm (see note 2)	SMAW: ALL
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	2G	Groove: F - H
		Fillet: F - H
Vertical progression (uphill or downhill):	N.A.	N.A.
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.	WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN N.A.	DCEN N.A.
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: 4169-0477/F5/Support brackets VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: 4169-0477/F5/Support brackets UT)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **SATISFACTORY (note 2)** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: 4169-0477/F5/Support brackets MT)**
Film or specimens evaluated by: - Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: - Laboratory test no.: -
Welding supervised by: **B&R S.p.A. Welding Supervisor**

Notes:
1) And unassigned metals of similar chemical composition to these metals

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

I.W.I. A. Sandonà IT/IWT/170 rinn. dalla 15/06/2017

PREPARED BY **A. SANDONA'**

ALBINO NASEGO / PRESIDENT ITALY Q.C. MANAGER M. GALLI DATE: / /

CHECKED AND APPROVED BY **B&R QCM: M. GALLI / Third part inspector: U.BREDA**

Date **16/07/2019**

BREMBANA&ROLLE

RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ)
(QW-301 Section IX ASME B.P.V Code)

W.P.Q. No. **S73 01/23**

Welder' s name: **GIBBIN MIRKO** Identification No.: **S73**

TEST DESCRIPTION

Identific. of WPS followed: **WPS CS GTAW SMAW 6G** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 106 Gr.B** Thickness(mm): **23**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW - SMAW	GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):		
☐ Plate ■ Pipe (enter diameter if pipe or tube):	WITHOUT - WITH	WITH or WITHOUT - WITH
Base metal P or S-No. to P or S-No.:	8" (Ø 219 mm)	73 mm and OVER
	P-No.1 to P-No.1	PNo.1 ÷ 15F, 34, 41 ÷ 49 (see note 1)
Filler metal or electrode specification(s) (SFA):	5.18 5.1	
Filler metal or electrode classification(s):	ER70S-6 E7018-1H4	
Filler metal F-No.:	6 4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 2 mm	GTAW: UP to 4 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 21 mm	SMAW: Max. to be welded
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	6G	Groove: All (Ø≥73mm)
		Fillet/Tack weld: All (Ø≥73mm)
Vertical progression (uphill or downhill):	UPHILL	UPHILL
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.	WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN N.A.	DCEN N.A.
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

BUREAU VERITAS ITALIA WELDING 14
IT FILE
DATE
WITNESSED REVIEW

Alternative radiographic examination result (QW-191): **UT SATISFACTORY (See report n°: S73 01/23 UT)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **NO** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **NO**
Film or specimens evaluated by: **Welding Engineer** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: / Laboratory test no.: /
Welding supervised by: **B&R S.p.A. Welding Supervisor**

Notes:
1) And unassigned metals of similar chemical composition to these metals

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY A. SANDONA

CHECKED AND APPROVED BY N. TOSTO

Date **12.07.2023**

BREMBANA&ROLLE	RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ) (QW-301 Section IX ASME B.P.V Code)	W.O.P.Q. No. S73 02/20

Welder' s name: **GIBBIN MIRKO** Identification No.: **S73**

TEST DESCRIPTION

Identific. of WPS followed: **W02 Rev.0 (W.B. 4169-0478/W)** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 516 Gr.70** Thickness(mm): **38**
Base metal P or S-No.: **P-No. 1** to base metal P or S-No.: **P-No. 1** Position (2G,6G,3F,etc.): **1G**
■ Plate ☐ Pipe (enter diameter if pipe or tube):
Filler metal (SFA) specification: **5.23** Filler metal or electrode classification: **EA4**

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	MACHINE	MACHINE
Welding process:	SAW	SAW
Direct or remote visual control:	DIRECT	DIRECT
Automatic arc voltage control (GTAW):	N.A.	N.A.
Automatic joint tracking:	WITHOUT	WITH OR WITHOUT
Welding position (2G, 6G, 3F, etc.):	1G	F
Consumable inserts (GTAW or PAW):	N.A.	N.A.
Backing (metal, weld metal, etc.):	WITH	WITH
Single or multiple passes per side:	MULTIPASS	SINGLE AND MULTIPASS
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: S73/02-20/VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **UT SATISFACTORY (See report n°: S73/02-20/UT)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **NO** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **MT SATISFACTORY (See report n°:S73/02-20/MT)**
Film or specimens evaluated by: **Welding Engineer** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: Laboratory test no.:
Welding supervised by: **B&R S.p.A. Welding Supervisor**

Notes:

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY **A. SANDONA'** — A. Sandona IT/IWT/170065A issue date 15.06.2017

CHECKED AND APPROVED BY **N. TOSTO**

Date **08.01.2020**

674

ROLLE S.p.A. Albignasego (PD) ITALY	WELDERS PERFORMANCE QUALIFICATION (for manual and semiautomatic welding process) QW-484	WPQ 24 /N

ZANELLATO	OMAR	24	SMAW08	0
Surname	Name(s)	Stamp No.	WPS used	Rev.

QW	Essential Variables	Actual Values from Coupon or Production Weld	Qualified Ranges	
352-356	Process(s)	1: SMAW	1: SMAW	
Info. onl.	Base Material(s) T	SA106GR.B T: 23.01	to SA106GR.B T: 23.01	
403.18	P-No. to P-No.	1 to 1	P-No 1 to 11, 34, 41 to 49	
403.16	Plate /Pipe O.D. <73 or >73mm	8" (219.1mm)	> 2.7/8" (73mm) and plate	
405.1	Position	1: 6G	Groove	Fillet
	Plate and pipe over 24" (610mm) O.D.		1:ALL	1:ALL
	Pipe 73mm <= O.D. <= 610mm		1:ALL	1:ALL
	Pipe >= 73mm O.D		1:ALL	1:ALL
	Pipe unlimited O.D.		1:-	1:ALL
405.3	Vertical up or down	1: Upward	1: Upward	
402.4	Backing	1: ☒YES ☐NO 2: ☐YES ☐NO	1: With support	
404.30	t: Weld metal deposit	1: 20.1	1: up to max. to weld	
404.32	t: Limit (GMAW Short Circ.)	a) T<1/2":/ :/ 1.1XT b) T>1/2":/ :/ 2T-8"	/ max.	
409.2	Tranf. Mode Spray Puls. Clobular Short Circ.	n.a.	1: n.a.	
409.4	AC - DC (GTAW) only	n.a.	n.a.	
404.15	Chge F-No. SMAW except F4 = F1 - F4	1: F-No. 4	1: F-No.1 to 4	
404.22	± Insert (GTAW only)	☐ with ☐ without	n.a.	
404.23	Filler metal product form (GTAW)	n.a.	n.a.	
408.8	(-) Inert backing	1: n.a. 2: N.A.	1: n.a. 2: N.A.	
404.14	± Filler (GTAW)	1: n.a. 2: N.A.	1: n.a. 2: N.A.	

QW-161	GUIDED BEND TEST		
Type QW-462.3 (a) (b)	Results:	Type QW-462.2	Results:
/ (Face Bend)	/	N. 2 (Side Bend)	SATISFACTORY
/ (Root Bend)	/	N. 2 (Side Bend)	SATISFACTORY

QW-304 and QW-305 :	RADIOGRAPHIC TEST	Results: SATISFACTORY
QW-302.4:	VISUAL EXAMINATION	Results: SATISFACTORY

QW-181.2	FILLET WELD TEST	QW-462.4 (b) or (c)
Location of track or tear:		
Length: N.A. %		Results: N.A.

QW-184	MACRO EXAMINATION	QW-462.4 (b)
Length of indication: N.A.	Concavity: N.A.	Convexity: N.A.
Fillet leg size: N.A.	Results: N.A.	

Welding test conducted by: WELDER FOREMAN

Mechanical / radiographic tests conducted by: Q.C. INSP. - A. DONA' — Laboratory test no.: 24N/2009

We certify that the statements in this record are correct and that welds were prepared, welded and tested according to Section IX of the ASME Code.

Rolle s.p.a. — Organization / Manufacturer

ROLLE SPA ALBIGNASEGO - PD ITALY II LEVEL MT-PT-RT/ASNT TC 1A/SNT-TC Q.C. MANAGER A. DONA' DATE

Signature

SGS Italia S.p.A. SGS Italia S.p.A.

28 / 12 / 2009
Day Month Year

01 APR. 2010

BREMBANA & ROLLE S.p.A.
WELDING DEPT. - A. DONA'

☒ REVIEWED ☐ WITNESSED

BREMBANA&ROLLE	RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ) (QW-301 Section IX ASME B.P.V Code)	W.O.P.Q. No. S74 01/19

Welder' s name: **ZANELLATO OMAR** Identification No.: **S74**

TEST DESCRIPTION

Identific. of WPS followed: **W04 (Job 4169-0478 joint N05A)** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 765 Gr.II to SA 765 Gr.IV** Thickness(mm): **120**
Base metal P or S-No.: **P-No. 1** to base metal P or S-No.: **P-No. 1** Position (2G,6G,3F,etc.): **1G**
■ Plate ☐ Pipe (enter diameter if pipe or tube): /
Filler metal (SFA) specification: **5.23** Filler metal or electrode classification: **EA4**

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	MACHINE	MACHINE
Welding process:	SAW	SAW
Direct or remote visual control:	DIRECT	DIRECT
Automatic arc voltage control (GTAW):	N.A.	N.A.
Automatic joint tracking:	WITHOUT	WITH OR WITHOUT
Welding position (2G, 6G, 3F, etc.):	1G	F
Consumable inserts (GTAW or PAW):	N.A.	N.A.
Backing (metal, weld metal, etc.):	WITH	WITH
Single or multiple passes per side:	MULTIPASS	SINGLE AND MULTIPASS
Ø Limits:	PLATE	73 mm and OVER
Other:		

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: 4169-0478 N05A VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: 4169-0478 N05A UT)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **SATISFACTORY (note 1)** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: 4169-0478 N05A MT)**
Film or specimens evaluated by: **B&R QCM / Third part inspector** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: / Laboratory test no.: /
Welding supervised by: **B&R S.p.A. Welding Supervisor**

Notes:

I.W.T. A. Sandonà IT/IWT/170065/ issue date 15.06.2017

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY **A. SANDONA'**

BREMBANA & ROLLE S.p.A. ALBINO (BG) - ITALY Q.C. MANAGER M. GALLI DATE: / /

CHECKED AND APPROVED BY **B&R QCM: M. GALLI / Third part inspector: U.BREDA**

Date **29/06/2019**

BREMBANA&ROLLE	RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ) (QW-301 Section IX ASME B.P.V Code)	W.P.Q. No. S76 02/23

Welder' s name: **ANDREA DEVICENTI** Identification No.: **S76**

TEST DESCRIPTION

Identific. of WPS followed: **WPS CS GTAW SMAW 6G** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 106 Gr.B** Thickness(mm): **23**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW - SMAW	GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH	WITH or WITHOUT - WITH
☐ Plate ■ Pipe (enter diameter if pipe or tube):	8" (Ø 219 mm)	73 mm and OVER
Base metal P or S-No. to P or S-No.:	P-No.1 to P-No.1	PNo.1 ÷ 15F, 34, 41 ÷ 49 (see note 1)
Filler metal or electrode specification(s) (SFA):	5.18 5.1	
Filler metal or electrode classification(s):	ER70S-6 E7018-1H4	
Filler metal F-No.:	6 4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 2 mm	GTAW: UP to 4 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 21 mm	SMAW: Max. to be welded
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	6G	Groove: All (Ø≥73mm)
		Fillet/Tack weld: All (Ø≥73mm)
Vertical progression (uphill or downhill):	UPHILL	UPHILL
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.	WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN N.A.	DCEN N.A.
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **UT SATISFACTORY (See report n°: S76 02/23 UT)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **NO** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **NO**
Film or specimens evaluated by: **Welding Engineer** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: **/** Laboratory test no.: **/**
Welding supervised by: **B&R S.p.A. Welding Supervisor**

Notes:
1) And unassigned metals of similar chemical composition to these metals

BUREAU VERITAS ITALIA WELDING 14
IT FILE:
DATE:
WITNESSED

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY
A. SANDONA'

CHECKED AND APPROVED BY
N. TOSTO

Date
11.07.2023

S77

ROLLE SPA ALBIGNASEGO PADOVA	WELDING OPERATOR QUALIFICATION (automatic and machine welding) QW-360	WPQ 27 /H

LEKAJ	NICOLI	27	SAW01	0
Surname	First Name(s)	Stamp No.	WPS used	Rev.

QW	Welding Variables	Actual Values from Coupon or Production Weld	Qualified Ranges
	GENERAL VARIABLES		
Info. onl.	Pipe or Plate	Plate	Plate and pipe over 24"
Info. onl.	Base Material(s) / T	SA516 Gr.60 T: 25	to SA516 Gr.60 T: 25
Info. onl.	P-No to P-No	1 to 1	P-No 1 to 11, 34, 41 to 49
	AUTOMATIC - WELDING		
361.1(a)	Process(s)	N.A	N.A.
361.1(b)	Change from Autom. to Mach.	N.A.	N.A.
	MACHINE – WELDING		
361.2 (a)	Process(s)	SAW	SAW
361.2 (b)	Direct Vis ⇆ Remote Control	☒ Direct ☐ Remote	DIRECT
361.2 (c)	Autom. Volt. Control (GTAW)	N.A.	N.A.
361.2 (d)	Autom. Joint Tracking	☐ yes ☒ no	YES/NO
361.2 (e)	Welding Position	1G	Groove: F; Fillet: F
361.2 (f)	Consumable Inserts	☐ yes ☒ no	n.a.
361.2 (g)	Backing	☒ yes ☐ no	Weld metal
361.2 (h)	Single Pass Multiple Pass	☐ single ☒ multiple	Multiple / Single

QW-161 GUIDED BEND TEST

Type QW-462.3 (a) (b)	Results:	Type QW-462.2	Results:
(Face Bend)	/	no. 2 (Side Bend)	Satisfactory
(Root Bend)	/	no. 2 (Side Bend)	Satisfactory

QW-304 and QW-305 : RADIOGRAPHIC TEST Results: SATISFACTORY

QW-302.4: VISUAL EXAMINATION Results: SATISFACTORY

QW-181.2 FILLET WELD TEST QW-462.4 (b) or (c)

Location of track or tear:

Length: N.A. % Results: N.A.

QW-184 MACRO EXAMINATION QW-462.4 (b)

Length of indication: N.A. Concavity: N.A. Convexity: N.A.

Fillet leg size: N.A. Results: N.A.

Welding test conducted by: WELDER FOREMAN

Mechanical / radiographic tests conducted by: Q.C. INSP. - A. DONA' Laboratoy test no.: 27 H

We certify that the statements in this record are correct and that welds were prepared, welded and tested according to Section IX of the ASME Code.

ROLLE SPA ALBIGNASEGO - PD - ITALY II LEVEL MT-PT-RT/ASNT-TC-1A/ISIQ QC MANAGER A. DONA' DATE

Rolle s.p.a. Signature 28/12/2013

Organization / Manufacturer Day Month Year

SGS Italia S.p.A. SGS

BREMBANA & ROLLE S.p.A. 01 APR. 2014
WELDING DEPT. - A. DONA'
☒ REVIEWED ☐ WITNESSED

S27

ROLLE S.p.A. Albignasego (PD) ITALY	WELDERS PERFORMANCE QUALIFICATION (for manual and semiautomatic welding process) QW-484	WPQ 27 /I

LEKAJ	NICOLI	27	SMAW05	0
Surname	Name(s)	Stamp No.	WPS used	Rev.

QW	Essential Variables	Actual Values from Coupon or Production Weld	Qualified Ranges	
352-356	Process(s)	1: SMAW	1: SMAW	
Info. onl.	Base Material(s) T	SA106 Gr.B T: 11.07	to SA106 Gr.B T: 11.07	
403.18	P-No. to P-No.	1 Gr.1 to 1 Gr.1	P-No 1 to 11, 34, 41 to 49	
403.16	Plate /Pipe O.D. <73 or >73mm	2" (60.3mm)	> 1" (25mm)	
405.1	Position	1: 6G	Groove	Fillet
	Plate and pipe over 24" (610mm) O.D.		1:ALL	1:ALL
	Pipe 73mm <= O.D. <= 610mm		1:ALL	1:ALL
	Pipe > 73mm O.D		1:ALL	1:ALL
	Pipe unlimited O.D.		1:>25mm	1:ALL
405.3	Vertical up or down	1: Upward	1: Upward	
402.4	Backing	1: ☒YES ☐NO 2: ☐YES ☐NO	1: With backing	
404.30	t: Weld metal deposit	1: 8.07	1: 16.14	
404.32	t: Limit (GMAW Short Circ.)	a) T<1/2":/ :/ 1.1XT b) T>1/2":/ :/ 2T-8"	/ max.	
409.2	Tranf. Mode Spray Puls. Clobular Short Circ.	n.a.	1: n.a. 2: n.a.	
409.4	AC - DC (GTAW) only			
404.15	Chge F-No. SMAW except F4 = F1 - F4	1: F-No. 4 2:	1: F-No. 1 to 4 2:	
404.22	± Insert (GTAW only)	☐ with ☐ without	N.A.	
404.23	Filler metal product form (GTAW)	N.A.	N.A.	
408.8	(-) Inert backing	1: N.A. 2: N.A.	1: 2: N.A.	
404.14	± Filler (GTAW)	1: N.A. 2: N.A.	1: N.A. 2: N.A.	

QW-161	GUIDED BEND TEST		
Type QW-462.3 (a) (b)	Results:	Type QW-462.2	Results:
TRASV. (Face Bend)	SATISFACTORY	/ (Side Bend)	/
TRASV. (Root Bend)	SATISFACTORY	/ (Side Bend)	/

QW-304 and QW-305 :	RADIOGRAPHIC TEST	Results: SATISFACTORY
QW-302.4:	VISUAL EXAMINATION	Results: SATISFACTORY

QW-181.2	FILLET WELD TEST	QW-462.4 (b) or (c)
Location of track or tear:		
Length: N.A. %		Results: N.A.

QW-184	MACRO EXAMINATION	QW-462.4 (b)
Length of indication: N.A.	Concavity: N.A.	Convexity: N.A.
Fillet leg size: N.A.	Results: N.A.	

Welding test conducted by: WELDER FOREMAN

Mechanical / radiographic tests conducted by: Q.C. INSP. - A. DONA' Laboratoy test no.: 27 I

We certify that the statements in this record are correct and that welds were prepared, welded and tested according to Section IX of the ASME Code.

ROLLE S.p.A. ALBIGNASEGO - PD - ITALY II LEVEL MT-PT-RT-UT-TC-VT-EN473 Q.C. MANAGER A. DONA'

Rolle s.p.a. — Organization / Manufacturer — Signature — 28 / 12 / 2013 — Day Month Year

SGS Italia S.p.A.

BREMBANA & ROLLE S.p.A.
WELDING DEPT. - A. DONA'
☒ REVIEWED ☐ WITNESSED
01 APR. 2014

BREMBANA&ROLLE

RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ)

(QW-301 Section IX ASME B.P.V Code)

W.P.Q. No. **S79 02/19**

Welder' s name: **PADOVANI SIMONE** Identification No.: **S79**

TEST DESCRIPTION

Identific. of WPS followed: **W11 (joint F5-Lifting lug/B&R Job 4169-0487)** ■ Test coupon ☐ Production weld

Specificat. of base metal(s): **SA 516 Gr.70 to SA 516 Gr.70** Thickness(mm): **50**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW - SMAW	GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH	WITH or WITHOUT - WITH
■ Plate ☐ Pipe (enter diameter if pipe or tube):	PL. 50mm	73 mm and OVER
Base metal P or S-No. to P or S-No.:	P-No.1 to P-No.1	PNo.1 ÷ 15F, 34, 41 ÷ 49 (see note 1)
Filler metal or electrode specification(s) (SFA):	5.18 5.1	
Filler metal or electrode classification(s):	ER70S-3 E7018-1H4	
Filler metal F-No.:	6 4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 4 mm (see note 2)	GTAW: UP to 8 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 46 mm (see note 2)	SMAW: ALL
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	2G	Groove: F - H
		Fillet: F - H
Vertical progression (uphill or downhill):	N.A.	N.A.
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.	WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN N.A.	DCEN N.A.
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: 4169-0478/F5/Lifting lug VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: 4169-0478/F5/Lifting lug UT)**

Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**

Macro examination (QW-184): **SATISFACTORY (note 2)** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**

Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: 4169-0478/F5/Lifting lug MT)**

Film or specimens evaluated by: - Company: **Brembana & Rolle S.p.A.**

Mechanical tests conducted by: - Laboratory test no.: -

Welding supervised by: **B&R S.p.A. Welding Supervisor**

Notes:

1) And unassigned metals of similar chemical composition to these metals

I.W.I. A. Sandonà IIW/IWI/170065A issued il 15.06.2017

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY	CHECKED AND APPROVED BY	Date
A. SANDONA'	**B&R QCM: M. GALLI / Third part inspector: U.BREDA**	**22/08/2019**

ALBIGNASEGO (PD) - ITALY Q.C.MANAGER M.GALLI DATE: / /

BREMBANA&ROLLE

RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ)
(QW-301 Section IX ASME B.P.V Code)

W.P.Q. No. **S83 01/19**

Welder' s name: **SCRAULECH MORENO** Identification No.: **S83**

TEST DESCRIPTION

Identific. of WPS followed: **W06 (joint F5-Support brackets/Job 4169-0477)** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 516 Gr.70 to SA 765 Gr.IV** Thickness(mm): **25**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW - SMAW	GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH	WITH or WITHOUT - WITH
■ Plate ☐ Pipe (enter diameter if pipe or tube):	PL. 25mm	73 mm and OVER
Base metal P or S-No. to P or S-No.:	P-No.1 to P-No.1	PNo.1 ÷ 15F, 34, 41 ÷ 49 (see note 1)
Filler metal or electrode specification(s) (SFA):	5.18 5.1	
Filler metal or electrode classification(s):	ER70S-3 E7018-1H4	
Filler metal F-No.:	6 4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 4 mm (see note 2)	GTAW: UP to 8 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 21 mm (see note 2)	SMAW: ALL
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	2G	Groove: F - H Fillet: F - H
Vertical progression (uphill or downhill):	N.A.	N.A.
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.	WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN N.A.	DCEN N.A.
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: 4169-0477/F5/Support brackets VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: 4169-0477/F5/Support brackets UT)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **SATISFACTORY (note 2)** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: 4169-0477/F5/Support brackets MT)**
Film or specimens evaluated by: - Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: - Laboratory test no.: -
Welding supervised by: **B&R S.p.A. Welding Supervisor**

Notes:
1) And unassigned metals of similar chemical composition to these metals

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

I.W.T. A. Sandonà IT/WT/170065A esecutivo 15/05/2017

PREPARED BY **A. SANDONA'**

ALBIGNASEGO (PD) ITALY Q.C. MANAGER M. GALLI DATE: / /

CHECKED AND APPROVED BY **B&R QCM: M. GALLI / Third part inspector: U.BREDA**

Date **16/07/2019**

BREMBANA&ROLLE

RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ)
(QW-301 Section IX ASME B.P.V Code)

W.P.Q. No. **S84 01/22**

Welder' s name: **LUCATO FABIO** Identification No.: **S84**

TEST DESCRIPTION

Identific. of WPS followed: **WPS S84 01/22** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 333 Gr.6** Thickness(mm): **13.5**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW	GTAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT	WITH or WITHOUT
☐ Plate ■ Pipe (enter diameter if pipe or tube):	114.3 mm (4")	73 mm (2"7/8) and OVER
Base metal P or S-No. to P or S-No.:	P-No.1 to P-No.1	PNo.1 ÷ 15F, 34, 41 ÷ 49 (see note 1)
Filler metal or electrode specification(s) (SFA):	5.18	
Filler metal or electrode classification(s):	ER70S-3	
Filler metal F-No.:	6	6
With or without filler metal (GTAW or PAW):	WITH	WITH
Consumables inserts (GTAW or PAW):	WITHOUT	WITHOUT
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID	SOLID & METAL CORED
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ■ Yes ☐ No	GTAW: 13,5 mm	GTAW: UP to 27 mm
Process 2: ____ 3 layers min. ☐ Yes ☐ No		
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	2G	Groove: F-H Fillet: F-H
Vertical progression (uphill or downl	N.A.	N.A.
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT	WITH or WITHOUT
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN	DCEN
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: S84 01-22/VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **UT SATISFACTORY (See report n°: S84 01-22/UT)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **NO** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **MT SATISFACTORY (See report n°: S84 01-22/MT)**
Film or specimens evaluated by: **Q.C. Manager** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: **/** Laboratory test no.: **/**
Welding supervised by: **B&R S.p.A. Welding Supervisor**

Notes:
1) And unassigned metals of similar chemical composition to these metals

☑ LROA verification ltd ☐ 0094 ☐
☐ Witnessed ☑ Monitored ☐ Reviewed
GIANLUCA CESTARI
Ref. No.: 16408 · AI
Office: Milan 01/04/2022
LRQA

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY **A. SANDONA** — CHECKED AND APPROVED BY **M. GALLI (Q.C.M.)** — Date **01.04.2022**

BREMBANA&ROLLE

RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ)
(QW-301 Section IX ASME B.P.V Code)

W.O.P.Q. No. **S88 01/22**

Welder' s name: **CIOBANU VALENTIN** Identification No.: **S88**

TEST DESCRIPTION

Identific. of WPS followed: **W01 (Job 4261 joint L4A)** ☐ Test coupon ■ Production weld
Specificat. of base metal(s): **SA 516 Gr.70** Thickness(mm): **105**
Base metal P or S-No.: **P-No. 1** to base metal P or S-No.: **P-No. 1** Position (2G,6G,3F,etc.): **1G**
■ Plate ☐ Pipe (enter diameter if pipe or tube):
Filler metal (SFA) specification: **5.17** Filler metal or electrode classification: **EH12K**

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	MACHINE	MACHINE
Welding process:	SAW	SAW
Direct or remote visual control:	DIRECT	DIRECT
Automatic arc voltage control (GTAW):	N.A.	N.A.
Automatic joint tracking:	WITHOUT	WITH OR WITHOUT
Welding position (2G, 6G, 3F, etc.):	1G	F
Consumable inserts (GTAW or PAW):	N.A.	N.A.
Backing (metal, weld metal, etc.):	WITH	WITH
Single or multiple passes per side:	MULTIPASS	SINGLE AND MULTIPASS
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **UT SATISFACTORY (See report n°: 4261-UT/L4A)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **NO** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **NO**
Film or specimens evaluated by: **Welding Engineer** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: Laboratory test no.:
Welding supervised by: **B&R S.p.A. Welding Supervisor**

BUREAU VERITAS ITALIA WELDING 14
IT FILE:
DATE
WITNESSED REVIEW

Notes:

We certify that the statements in this record are correct and that the test welds were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY: **A. SANDONA** CHECKED AND APPROVED BY: **M. GALLI** Date: **15.11.2022**

BREMBANA&ROLLE	RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ) (QW-301 Section IX ASME B.P.V Code)	W.O.P.Q. No. S90 01/19

Welder' s name: **MELATO TIZIANO** Identification No.: **S90**

TEST DESCRIPTION

Identific. of WPS followed: **pWPS 54/19 (reference PQR 54/19)** ☐ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 533 Gr.B Cl.2 - SA 516 Gr.70** Thickness(mm): **43**
Base metal P or S-No.: **P-No. 3** to base metal P or S-No.: **P-No. 1** Position (2G,6G,3F,etc.): **1G**
■ Plate ☐ Pipe (enter diameter if pipe or tube): /
Filler metal (SFA) specification: **5.17** Filler metal or electrode classification: **EH12K**

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	**MACHINE**	**MACHINE**
Welding process:	**SAW**	**SAW**
Direct or remote visual control:	**DIRECT**	**DIRECT**
Automatic arc voltage control (GTAW):	**N.A.**	**N.A.**
Automatic joint tracking:	**WITHOUT**	**WITH OR WITHOUT**
Welding position (2G, 6G, 3F, etc.):	**1G**	**F**
Consumable inserts (GTAW or PAW):	**N.A.**	**N.A.**
Backing (metal, weld metal, etc.):	**WITH**	**WITH**
Single or multiple passes per side:	**MULTIPASS**	**SINGLE AND MULTIPASS**
Ø Limits:	**PLATE**	**73 mm and OVER**
Other:		

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: PQR 54/19 VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ■ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result
SIDE BEND	**SATISFACTORY (note 1)**		
SIDE BEND	**SATISFACTORY (note 1)**		
SIDE BEND	**SATISFACTORY (note 1)**		
SIDE BEND	**SATISFACTORY (note 1)**		

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: PQR 54/19 UT)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **SATISFACTORY (note 1)** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: PQR 54/19 MT)**
Film or specimens evaluated by: **B&R QCM / Third part inspector** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: **Sigma Tre Lab** Laboratory test no.: **1464**
Welding supervised by: **B&R S.p.A. Welding Supervisor / Third part inspector**

30/8/2019

Notes:

1) Mechanical tests performed by Sigma Tre Lab (See Laboratory Test Report n° 1907852 - 1907853)

UB

I/We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

International Institute of Welding A. Sandonà IIW/IWE 11/17/0 issue date 15.06.2017

PREPARED BY	CHECKED AND APPROVED BY	Date
A. SANDONA'	**B&R QCM: M. GALLI / Third part inspector: U.BREDA**	**30/08/2019**

BREMBANA & ROLLE S.P.A. QC MANAGER M GALLI DATE: / /

BREMBANA&ROLLE	RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ) (QW-301 Section IX ASME B.P.V Code)	W.P.Q. No. S91 01/18

Welder' s name: **DONA' ANDREA** Identification No.: **S91**

TEST DESCRIPTION

Identific. of WPS followed: **W01 (Job 4178 reference joint L1)** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 516 Gr.70** Thickness(mm): **20**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES	RANGE QUALIFIED
Welding process(es):	GTAW - SMAW	GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL	MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH	WITH or WITHOUT - WITH
■ Plate ☐ Pipe (enter diameter if pipe or tube):	PLATE	73 mm and OVER
Base metal P or S-No. to P or S-No.:	P-No.1 to P-No.1	PNo.1 ÷ 15F, 34, 41 ÷ 49 (see note 1)
Filler metal or electrode specification(s) (SFA):	5.18 5.1	
Filler metal or electrode classification(s):	ER70S-6 E7018-1H4	
Filler metal F-No.:	6 4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:		
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 2 mm	GTAW: UP to 4 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 5 mm	SMAW: UP to 10 mm
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.	N.A.
Welding position (1G,2G,6G,3F etc.):	1G	Groove: F
		Fillet: F
Vertical progression (uphill or down!	N.A.	N.A.
Type of fuel gas (OFW):	N.A.	N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.	WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.	N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN N.A.	DCEN N.A.
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: PQR 96/18 VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ■ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: PQR 96/18 RT)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **SATISFACTORY (note 2)** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: PQR 96/18 MT)**
Film or specimens evaluated by: **B&R QCM / Third part inspector** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: **/** Laboratory test no.:
Welding supervised by: **B&R S.p.A. Welding Supervisor**

Lloyd's Register Verification Limited
Marco Bonamici
Authorised Inspector
Witnessed ☐ Reviewed ☑
Date: Mar 27 19

Notes:

1) And unassigned metals of similar chemical composition to these metals
2) Mechanical tests performed by C.T.R. s.r.l. Element Group (See Laboratory Test Report n° 183549-1)

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY	CHECKED AND APPROVED BY	Date
A. SANDNA'	**B&R QCM: M. GALLI / Third part inspector: U.BREDA**	**14/12/2018**

IWT A. Sandna IIW/IWT-170065/A issue date 15.06.2017 International Welding Technologist Personal Qualification System

BREMBANA&ROLLE

RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ)
(QW-301 Section IX ASME B.P.V Code)

W.O.P.Q. No. **S91 02/18**

Welder' s name: **DONA' ANDREA** Identification No.: **S91**

TEST DESCRIPTION

Identific. of WPS followed: **W01 (Job 4178 reference joint L1)** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 516 Gr.70** Thickness(mm): **20**
Base metal P or S-No.: **P-No. 1** to base metal P or S-No.: **P-No. 1** Position (2G,6G,3F,etc.): **1G**
■ Plate ☐ Pipe (enter diameter if pipe or tube): /
Filler metal (SFA) specification: **5.17** Filler metal or electrode classification: **EH12K**

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	MACHINE	MACHINE
Welding process:	SAW	SAW
Direct or remote visual control:	DIRECT	DIRECT
Automatic arc voltage control (GTAW):	N.A.	N.A.
Automatic joint tracking:	WITHOUT	WITH OR WITHOUT
Welding position (2G, 6G, 3F, etc.):	1G	F
Consumable inserts (GTAW or PAW):	N.A.	N.A.
Backing (metal, weld metal, etc.):	WITH	WITH
Single or multiple passes per side:	MULTIPASS	SINGLE AND MULTIPASS
Ø Limits:	PLATE	73 mm and OVER
Other:		

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: PQR 96/18 VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ■ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result
SIDE BEND	SATISFACTORY (note 1)		
SIDE BEND	SATISFACTORY (note 1)		
SIDE BEND	SATISFACTORY (note 1)		
SIDE BEND	SATISFACTORY (note 1)		

Lloyd's Register Verification Limited
Marco Benamici
Authorised Inspector - N. No. 15444 A
☐ Witnessed ☑ Reviewed
Date: 14.12.18

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: PQR 96/18 RT)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **SATISFACTORY (note 1)** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: PQR 96/18 MT)**
Film or specimens evaluated by: **B&R QCM / Third part inspector** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: / Laboratory test no.: /
Welding supervised by: **B&R S.p.A. Welding Supervisor**

Notes:

1) Mechanical tests performed by C.T.R. s.r.l. Element Group (See Laboratory Test Report n° 183549-1)

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY	CHECKED AND APPROVED BY	Date
A. SANDNA'	**B&R QCM: M. GALLI / Third part inspector: U.BREDA**	**14/12/2018**

International Institute of Welding - A. Sandnà - IT/AW/1/170065A - Issue date 15.06.2017

BREMBANA&ROLLE	RECORD OF WELDER PERFORMANCE QUALIFICATION TESTS (WPQ) (QW-301 Section IX ASME B.P.V Code)	W.P.Q. No. S92 04/19

Welder' s name: **BONGOU JEAN** Identification No.: **S92**

TEST DESCRIPTION

Identific. of WPS followed: **pWPS 53/19 (reference PQR 53/19)** ■ Test coupon ☐ Production weld
Specificat. of base metal(s): **SA 533 Gr.B Cl.2 - SA 516 Gr.60** Thickness(mm): **35**

TESTING CONDITIONS AND QUALIFICATION LIMITS

WELDING VARIABLES (QW-350)	ACTUAL VALUES		RANGE QUALIFIED
Welding process(es):	GTAW - SMAW		GTAW - SMAW
Type (ie:manual,semi-auto) used:	MANUAL		MANUAL
Backing (metal, weld metal,double welded, etc.):	WITHOUT - WITH		WITH or WITHOUT - WITH
■ Plate ☐ Pipe (enter diameter if pipe or tube):	PL. 35mm		73 mm and OVER
Base metal P or S-No. to P or S-No.:	P-No.1 to P-No.3		PNo.1 ÷ 15F, 34, 41 ÷ 49 (see note 1)
Filler metal or electrode specification(s) (SFA):	5.18	5.1	
Filler metal or electrode classification(s):	ER70S-3	E7018-1H4	
Filler metal F-No.:	6	4	6 - 1, 2, 3, 4 with BACKING
With or without filler metal (GTAW or PAW):	WITH	N.A.	WITH - N.A.
Consumables inserts (GTAW or PAW):	WITHOUT	N.A.	WITHOUT - N.A.
Filler type (solid/metal or flux cored/powder) (GTAW or PAW):	BARE SOLID	N.A.	SOLID & METAL CORED - N.A.
Weld deposit "t" for each welding process:			
Process 1: GTAW 3 layers min. ☐ Yes ■ No	GTAW: 3 mm (see note 2)		GTAW: UP to 6 mm
Process 2: SMAW 3 layers min. ■ Yes ☐ No	SMAW: 32 mm (see note 2)		SMAW: ALL
Weld deposit "t" for S.Circ.Arc.(GMAW-FCAW):	N.A.		N.A.
Welding position (1G,2G,6G,3F etc.):	1G		Groove: F
			Fillet: F
Vertical progression (uphill or downhill):	N.A.		N.A.
Type of fuel gas (OFW):	N.A.		N.A.
Inert gas backing (GTAW or PAW or GMAW-FCAW):	WITHOUT - N.A.		WITH or WITHOUT - N.A.
Transfer mode (spray/globular or pulse to short)(GMAW-FCAW):	N.A.		N.A.
GTAW current type/polarity (AC, DCEP, DCEN):	DCEN	N.A.	DCEN N.A.
Other:	NO		NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY (See report n°: PQR 53/19 VT)**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ■ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		
SIDE BEND	SATISFACTORY (note 2)		

Alternative radiographic examination result (QW-191): **SATISFACTORY (See report n°: PQR 53/19 UT)**
Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**
Macro examination (QW-184): **SATISFACTORY (note 2)** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**
Other tests: **MAGNETIC PARTICLE - SATISFACTORY (See report n°: PQR 53/19 MT)**
Film or specimens evaluated by: **B&R QCM / Third part inspector** Company: **Brembana & Rolle S.p.A.**
Mechanical tests conducted by: **Sigma Tre Lab** Laboratory test no.: **1464**
Welding supervised by: **B&R S.p.A. Welding Supervisor / Third part inspector**

Notes:
1) And unassigned metals of similar chemical composition to these metals
2) Mechanical tests performed by Sigma Tre Lab (See Laboratory Test Report n° 1908478 - 1908479)

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY **A. SANDONA'** — CHECKED AND APPROVED BY **B&R QCM: M. GALLI / Third part inspector: U.BREDA** — Date **28/08/2019**

IWT A. Sandonà IT/IWT/170065A issue date 15.06.2017

BREMBANA & ROLLE S.p.A. Q.C. MANAGER M. GALLI

BREMBANA&ROLLE

RECORD OF WELDING OPERATOR PERFORMANCE QUALIFICATION TESTS (WOPQ)

(QW-301 Section IX ASME B.P.V Code)

W.O.P.Q. No. **S100 01/22**

Welder' s name: **MIOTTO DENNIS** Identification No.: **S100**

TEST DESCRIPTION

Identific. of WPS followed: **W01 (Job 4261 joint L1A)** ☐ Test coupon ■ Production weld

Specificat. of base metal(s): **SA 516 Gr.70** Thickness(mm): **105**

Base metal P or S-No.: **P-No. 1** to base metal P or S-No.: **P-No. 1** Position (2G,6G,3F,etc.): **1G**

■ Plate ☐ Pipe (enter diameter if pipe or tube):

Filler metal (SFA) specification: **5.17** Filler metal or electrode classification: **EH12K**

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING AUTOMATIC WELDING EQUIPMENT

WELDING VARIABLES (QW-361.1)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (Automatic):		
Welding process:		
Filler metal (EBW or LBW):		
Type of laser for LBW (Co2 to YAG, etc.):		
Continuos drive or inertia welding (FW):		
Vacuum or out of vacuum (EBW):		

TESTING CONDITIONS AND QUALIFICATION LIMITS WHEN USING MACHINE WELDING EQUIPMENT

WELDING VARIABLES (QW-361.2)	ACTUAL VALUES	RANGE QUALIFIED
Type of welding (machine):	MACHINE	MACHINE
Welding process:	SAW	SAW
Direct or remote visual control:	DIRECT	DIRECT
Automatic arc voltage control (GTAW):	N.A.	N.A.
Automatic joint tracking:	WITHOUT	WITH OR WITHOUT
Welding position (2G, 6G, 3F, etc.):	1G	F
Consumable inserts (GTAW or PAW):	N.A.	N.A.
Backing (metal, weld metal, etc.):	WITH	WITH
Single or multiple passes per side:	MULTIPASS	SINGLE AND MULTIPASS
Other:	NO	NO

RESULTS

Visual Examination of Completed Weld (QW-302.4): **SATISFACTORY**

☐ Bend test; ☐ Trans.root and face QW-462.3(a); ☐ Long.root and face QW-462.3(b); ☐ Side bend QW-462.2;
☐ Pipe bend spec.,corrosion-resist.overlay QW-462.5(c); ☐ Plate bend spec.,corrosion-resist.overlay QW-462.5(d);
☐ Macro test for fusion QW-462.5(b); ☐ Macro test for fusion QW-462.5(e).

Type	Result	Type	Result

Alternative radiographic examination result (QW-191): **UT SATISFACTORY (See report n°: 4261-UT/L1A)**

Fillet weld-fracture test (QW-180): **NO** Length and percent of defects: **NO**

Macro examination (QW-184): **NO** Fillet size (mm): **NO** Concavity/convexity (mm): **NO**

Other tests: **NO**

Film or specimens evaluated by: **Welding Engineer** Company: **Brembana & Rolle S.p.A.**

Mechanical tests conducted by: Laboratory test no.:

Welding supervised by: **B&R S.p.A. Welding Supervisor**

Notes:

BUREAU VERITAS ITALIA WELDING 14
IT FILE:
DATE:
WITNESSED J REVIEW J

We certify that the statements in this record are correct and that the test weld were prepared, welded and tested in accordance with the requirements of the Section IX of the ASME Code BPV

PREPARED BY: A. SANDONÀ — CHECKED AND APPROVED BY: M. GALLI — Date: 20.10.2022

International Institute of Welding — IWE/IWT 170065A — Rilasciato il 15.06.2017

BREMBANA & ROLLE S.p.A. — Q.C. MANAGER M. GALLI — DATE: / /

BREMBANA&ROLLE

QUALIFIED WELDERS LOG YEAR 2024 "Albignasego/Marghera"

Document Nr. WL-01 rev.0
09-01-2018

Prepared by - Preparato da
Approved by - Approvato da
Date - Data 07/03/24

Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
	S51													
CATOZZO DAVIDE	S52	GTAW			X									
		SMAW	X	X	X	X								
		SAW		X		X								
		ESW	X			X								
		GMAW SEMIAUT.	X											
		GTAW MACH.			X									
		FCAW			X									
CICALA EMANUELE	S53	GTAW		X										
		SMAW		X	X	X								
		GMAW SEMIAUT.		X										
		SAW		X	X	X								
DIOMBANA SITA	S54	GTAW		X										
		SMAW	X			X								
		GMAW SEMIAUT.		X										
		SAW	X	X	X	X								
		GMAW MACHINE			X									
BALLOTTA ANDREA	S55	GTAW		X		X								
		SMAW	X		X	X								
		GMAW SEMIAUT.		X										
		SAW	X	X	X									
		ESW	X			X								
TUIVERI FEDERICO	S56	GTAW		X										
		SMAW		X	X	X								
LAZZARO FAUSTO	S57	GTAW			X									
		SMAW		X	X									
		SAW	X	X		X								
		GMAW SEMIAUT.	X											
		ESW		X	X	X								
		FCAW	X			X								
BETTIN LUCIANO	S58	GTAW	X			X								
		SMAW	X	X	X	X								
		SAW	X	X	X	X								
		GMAW SEMIAUT.		X										
		ESW	X											

Note: The card is updated every three months at least - Lascheda è aggiornata con scadenza minima trimestrale

BREMBANA&ROLLE

QUALIFIED WELDERS LOG YEAR 2024 "Albignasego/Marghera"

Document Nr. WL-01 rev.0
09-01-2018

Prepared by - Preparato da
Approved by - Approvato da
Date - Data 07/03/24

Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
MARTIN PARIDE	S59	SMAW	X			X								
		SAW	X	X	X	X								
		GMAW SEMIAUT.			X									
		ESW		X		X								
TIMPONE PIERPAOLO	S60	GTAW		X		X								
		SMAW	X	X	X	X								
		GMAW SEMIAUT.		X										
		SAW	X		X									
BENAISSOUN MONAIM	S61	SMAW	X	X		X								
		SAW		X	X	X								
		GMAW SEMIAUT.	X											
		FCAW	X			X								
		ESW			X									
GARZOTTO MIRKO	S62	GTAW	X		X	X								
		SMAW		X										
		GMAW SEMIAUT.	X											
LUGATO LUCA	S63	SAW	X	X	X	X								
DAL LAGO DAVIDE	S64	GTAW		X	X	X								
		SMAW	X	X		X								
		GMAW SEMIAUT.	X		X									
		GTAW H.W.	X		X									
RUSSO VINCENZO	S65	SAW	X	X	X	X								
VUJIC PEDRAG	S66	SAW		X		X								
		ESW	X	X	X									
STORACI FEDERICO	S67	GTAW		X	X	X								
		SMAW		X	X	X								
FILIPPONE MASSIMILIANO	S68	GTAW	X			X								
		SMAW		X		X								
		GMAW SEMIAUT.		X	X									
		GMAW MACHINE	X		X									

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QUALIFIED WELDERS LOG YEAR 2024 "Albignasego/Marghera"

Document Nr. WL-01 rev.0
09-01-2018

Prepared by - Preparato da	
Approved by - Approvato da	
Date - Data	07/03/24

Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
LAZZARIN GUERRINO	S69	GTAW	X		X	X								
		SMAW	X		X	X								
		SAW	X		X	X								
		ESW		X	X									
		GMAW SEMIAUT.			X									
		FCAW		X										
MANFO MICHAEL	S70	GTAW	X			X								
		SMAW	X	X	X	X								
		GMAW SEMIAUT.	X		X									
		SAW		X		X								
		GMAW MACHINE			X									
	S71													
PERONI CORRADO	S72	GTAW	X	X	X	X								
		SMAW	X	X	X	X								
MIRKO GIBBIN	S73	GTAW		X		X								
		SMAW		X		X								
		SAW	X		X									
		ESW	X			X								
		GMAW SEMIAUT.			X									
ZANELLATO OMAR	S74	SMAW	X	X	X	X								
		SAW		X	X	X								
		GMAW SEMIAUT.	X											
		GTAW	X			X								
BELLOMIA FRANCESCO	S75	SMAW		X		X								
		SAW		X	X	X								
		GMAW SEMIAUT.	X											
		ESW			X	X								
DEVICIENTI ANDREA	S76	GTAW		X	X	X								
		SMAW	X	X	X	X								
		GMAW SEMIAUT.	X											
		FCAW		X										
		SAW												

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Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
LEKAJ NICOLI	S77	SMAW	X			X								
		SAW	X		X	X								
		ESW		X	X									
		GMAW SEMIAUT.		X										
SALVO' CLAUDIO	S78	SMAW	X		X									
		SAW		X		X								
		ESW	X			X								
		GMAW SEMIAUT.		X										
PADOVANI SIMONE	S79	GTAW	X		X									
		SMAW	X	X	X	X								
		GMAW SEMIAUT.		X										
		GMAW MACHINE	X			X								
ZORAN ERMAN	S80	SMAW	X		X	X								
		SAW	X	X										
	S81													
	S82													
SCHRAULECH MORENO	S83	GTAW	X	X	X	X								
		SMAW	X	X	X	X								
LUCATO FABIO	S84	GTAW		X	X									
		SMAW	X		X	X								
	S85	GTAW												
		SMAW												
	S86	SMAW												
		SAW												
	S87													
CIOBANU VALENTIN	S88	GTAW	X			X								
		SMAW		X		X								
		SAW	X	X	X	X								
		GMAW SEMIAUT.			X									
		ESW			X									
FERRO CRISTIAN	S89	GTAW		X		X								
		SMAW		X	X	X								
		SAW		X	X	X								
		GMAW SEMIAUT.		X										

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Approved by - Approvato da
Date - Data 07/03/24

Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
MELATO TIZIANO	S90	SMAW		X	X									
		SAW	X	X	X	X								
DONÀ ANDREA	S91	GTAW		X										
		SMAW	X	X		X								
		SAW	X		X	X								
		ESW			X									
BONGOU JEAN	S92	GTAW	X	X		X								
		SMAW	X	X		X								
		SAW			X									
	S93													
DI NATALE GIOSUÉ	S94	GTAW		X										
		SMAW		X	X	X								
		SAW		X	X									
ALAIN MILOTIC	S95	SAW		X	X	X								
		ESW	X	X	X									
	S96													
	S97													
	S98													
	S99													
MIOTTO DENNIS	S100	SMAW		X	X	X								
		SAW	X	X	X	X								
	S101													

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QUALIFIED WELDERS LOG YEAR 2023 "Albignasego/Marghera"

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Prepared by - Preparato da														
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Date - Data				10/03/23			09/06/23							
Welder's name Nome del saldatore	**Stamp**	**Process Procedimento**	January	February	March	April	May	June	July	August	September	October	November	December
	S51													
CATOZZO DAVIDE	S52	GTAW	X			X			X					
		SMAW	X		X	X	X	X	X					
		SAW	X		X			X						
		ESW		X				X						
		GMAW SEMIAUT.		X	X	X	X		X					
		GTAW MACH.		X										
		FCAW		X			X		X					
	S53													
DIOMBANA SITA	S54	GTAW	X			X			X					
		SMAW	X		X	X	X	X						
		GMAW SEMIAUT.		X			X							
		SAW	X		X		X	X	X					
		GMAW MACHINE		X	X	X								
BALLOTTA ANDREA	S55	GTAW	X			X			X					
		SMAW		X	X		X	X	X					
		GMAW SEMIAUT.		X			X		X					
		SAW	X		X	X		X						
		ESW	X		X	X	X							
	S56													
LAZZARO FAUSTO	S57	GTAW			X				X					
		SMAW		X	X	X	X	X						
		SAW	X		X	X	X	X	X					
		GMAW SEMIAUT.		X		X			X					
		ESW	X	X	X		X	X	X					
		FCAW	X				X							
BETTIN LUCIANO	S58	GTAW		X					X					
		SMAW	X		X	X	X	X						
		SAW	X	X	X	X	X	X	X					
		GMAW SEMIAUT.		X			X		X					
		ESW			X			X						

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QUALIFIED WELDERS LOG YEAR 2023 "Albignasego/Marghera"

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Prepared by - Preparato da													
Approved by - Approvato da													
Date - Data				10/03/23			09/06/23						
Welder's name Nome del saldatore	**Stamp**	**Process Procedimento**	January	February	March	April	May	June	July	August	September	October	November	December
MARTIN PARIDE	S59	SMAW		X		X		X						
		SAW	X		X			X	X					
		GMAW SEMIAUT.		X			X		X					
		ESW	X	X	X	X	X	X	X					
TIMPONE PIERPAOLO (from June)	S60							X						
								X	X					
								X						
BENAISSOUN MONAIM	S61	GTAW		X		X			X					
		SMAW		X		X	X	X						
		SAW	X	X	X		X	X	X					
		GMAW SEMIAUT.	X			X			X					
		FCAW			X			X						
		ESW	X		X	X	X	X						
GARZOTTO MIRKO	S62	GTAW			X			X						
		SMAW		X				X						
		GMAW SEMIAUT.	X			X								
LUCATO LUCA (from February)	S63	SAW		X	X	X	X	X	X					
DAL LAGO DAVIDE (from June)	S64	GTAW						X	X					
		SMAW						X	X					
		GMAW SEMIAUT.												
VINCENZO ROSSO (from February)	S65	SAW		X	X	X	X	X	X					
VUJIC PEDRAG (from February)	S66	SAW		X		X		X	X					
		ESW		X			X	X						
	S67													
FILIPPONE MASSIMILIANO	S68	GTAW		X			X							
		SMAW	X		X		X		X					
		GMAW SEMIAUT.	X	X		X		X						
		GTAW MACHINE		X	X	X			X					

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QUALIFIED WELDERS LOG YEAR 2023 "Albignasego/Marghera"

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Prepared by - Preparato da													
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Date - Data			10/03/23			09/06/23							
Welder's name Nome del saldatore	**Stamp**	**Process Procedimento**	January	February	March	April	May	June	July	August	September	October	November	December
LAZZARIN GUERRINO	S69	GTAW		X			X							
		SMAW	X		X	X	X	X						
		SAW	X		X			X	X					
		ESW	X			X	X	X	X					
		GMAW SEMIAUT.		X		X			X					
		FCAW			X			X						
MANFO MICHAEL	S70	GTAW			X			X						
		SMAW	X		X	X	X	X	X					
		GMAW SEMIAUT.		X			X							
		SAW	X	X	X	X			X					
		Cross TACK.		X	X		X	X						
	S71													
PERONI CORRADO	S72	GTAW		X	X	X		X						
		SMAW	X	X	X	X	X	X	X					
MIRKO GIBBIN	S73	GTAW		X		X		X						
		SMAW	X	X	X	X	X	X	X					
		SAW	X	X	X		X		X					
		ESW	X		X	X	X	X						
		GMAW SEMIAUT.		X			X							
ZANELLATO OMAR (from February)	S74	SMAW		X	X		X	X	X					
		SAW	X	X	X	X	X	X	X					
		GMAW SEMIAUT.	X			X			X					
		GTAW		X				X	X					
BELLOMIA FRANCESCO	S75	SMAW	X			X		X						
		SAW	X	X	X	X	X	X	X					
		GMAW SEMIAUT.		X			X							
		ESW		X	X		X	X						
DEVICIENTI ANDREA	S76	GTAW	X		X		X		X					
		SMAW	X	X	X	X			X					
		GMAW SEMIAUT.	X	X		X								
		FCAW			X				X					
		SAW		X			X							

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QUALIFIED WELDERS LOG YEAR 2023 "Albignasego/Marghera"

Document Nr. WL-01 rev.0
09-01-2018

Prepared by - Preparato da			Rus Gee.			Rus Gee.							
Approved by - Approvato da													
Date - Data			10/03/23			09/06/23							
Welder's name Nome del saldatore	**Stamp**	**Process Procedimento**	January	February	March	April	May	June	July	August	September	October	November	December
LEKAJ NICOLI	S77	SMAW	X		X		X		X					
		SAW	X		X	X		X						
		ESW	X	X	X	X	X	X						
		GMAW SEMIAUT.		X			X							
SALVO' CLAUDIO	S78	SMAW	X		X	X		X	X					
		SAW	X	X	X			X						
		ESW		X			X							
		GMAW SEMIAUT.		X			X							
PADOVANI SIMONE	S79	GTAW			X				X					
		SMAW	X	X	X	X	X	X	X					
		GMAW SEMIAUT.	X	X		X	X	X						
		GMAW MACHINE		X			X							
ZORAN ERMAN	S80	SMAW		X		X		X						
		SAW	X	X	X	X	X		X					
	S81													
	S82													
SCHRAULECH MORENO	S83	GTAW		X		X	X	X						
		SMAW	X	X	X	X	X	X	X					
LUCATO FABIO	S84	GTAW	X	X		X	X	X	X					
		SMAW		X	X				X					
GALLO MICHAEL	S85	GTAW												
		SMAW												
FAWZI MOHAMED	S86	SMAW												
		SAW												
	S87													
CIOBANU VALENTIN	S88	GTAW			X		X		X					
		SMAW	X	X		X	X	X	X					
		SAW	X	X	X	X		X	X					
		GMAW SEMIAUT.	X				X							
		ESW		X	X		X	X						
RIZZATI ANTONELLO	S89	GTAW	X		X	X		X						
		SMAW	X		X			X	X					
		SAW		X			X							
		GMAW SEMIAUT.												

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QUALIFIED WELDERS LOG YEAR 2023 "Albignasego/Marghera"

Document Nr. WL-01 rev.0
09-01-2018

Prepared by - Preparato da			Flavio Gelli			Flavio Gelli							
Approved by - Approvato da													
Date - Data			10/03/23			09/06/23							
Welder's name Nome del saldatore	**Stamp**	**Process Procedimento**	January	February	March	April	May	June	July	August	September	October	November	December
MELATO TIZIANO	S90	SMAW		X	X		X	X						
		SAW	X	X	X	X	X	X	X					
DONÀ ANDREA	S91	GTAW	X			X		X						
		SMAW	X	X	X	X		X	X					
		SAW	X	X	X		X	X	X					
		ESW		X			X							
BONGOU JEAN	S92	GTAW	X	X		X		X	X					
		SMAW	X	X	X	X	X	X	X					
		SAW			X		X							
	S93													
LEBARKY AYOUB	S94	GTAW			X			X						
		SMAW	X		X	X	X	X	X					
		SAW		X		X	X		X					
ALAIN MILOTIC (from February)	S95	SAW		X	X	X	X	X	X					
		ESW		X		X		X						
	S96													
	S97													
	S98													
	S99													
MIOTTO DENNIS	S100	SMAW	X	X	X		X	X	X					
		SAW	X	X	X	X	X	X	X					
	S101													

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Date - Data															
Welder's name Nome del saldatore	**Stamp**	**Process Procedimento**	January	February	March	April	May	June	July	August	September	October	November	December
	S51													
CATOZZO DAVIDE	S52	GTAW										X		X
		SMAW								X	X	X	X	X
		SAW								X			X	X
		ESW									X			
		GMAW SEMIAUT.									X			
		GTAW MACH.												
		FCAW										X		X
	S53													
DIOMBANA SITA	S54	GTAW									X		X	
		SMAW								X	X	X	X	
		GMAW SEMIAUT.								X			X	
		SAW								X		X		X
		GMAW MACHINE									X			X
BALLOTTA ANDREA	S55	GTAW									X			X
		SMAW								X	X	X	X	X
		GMAW SEMIAUT.											X	
		SAW								X		X	X	
		ESW								X	X	X		X
	S56													
LAZZARO FAUSTO	S57	GTAW												X
		SMAW								X				X
		SAW									X	X	X	
		GMAW SEMIAUT.										X		
		ESW									X	X		X
		FCAW								X			X	
BETTIN LUCIANO	S58	GTAW									X			
		SMAW								X	X	X	X	X
		SAW								X		X		X
		GMAW SEMIAUT.											X	
		ESW									X			

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Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
MARTIN PARIDE	S59	SMAW								X			X	
		SAW								X		X		X
		GMAW SEMIAUT.									X		X	
		ESW								X	X	X		X
TIMPONE PIERPAOLO SAW from August	S60	GTAW									X			X
		SMAW								X	X	X	X	X
		GMAW SEMIAUT.								X				X
		SAW											X	
BENAISSOUN MONAIM	S61	GTAW								X	X		X	
		SMAW								X	X	X	X	X
		SAW										X		X
		GMAW SEMIAUT.									X			
		FCAW									X			
		ESW								X				X
GARZOTTO MIRKO	S62	GTAW									X	X		
		SMAW									X			X
		GMAW SEMIAUT.								X			X	
LUGATO LUCA	S63	SAW									X	X	X	
* DAL LAGO DAVIDE GTAW from 08.09.23	S64	GTAW									X	X		X
		SMAW									X	X		X
		GMAW SEMIAUT.								X			X	
RUSSO VINCENZO	S65	SAW									X	X	X	X
VUJIC PEDRAG	S66	SAW									X	X	X	
		ESW								X				X
	S67													
FILIPPONE MASSIMILIANO	S68	GTAW									X		X	
		SMAW									X	X	X	X
		GMAW SEMIAUT.								X		X		X
		GMAW MACHINE								X			X	

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Prepared by - Preparato da															
Approved by - Approvato da															
Date - Data												08/08/23		01/12/23	
Welder's name Nome del saldatore	**Stamp**	**Process Procedimento**	January	February	March	April	May	June	July	August	September	October	November	December
LAZZARIN GUERRINO	S69	GTAW SMAW SAW ESW GMAW SEMIAUT. FCAW								X X X	X	X X	X X X	X X
MANFO MICHAEL	S70	GTAW SMAW GMAW SEMIAUT. SAW GMAW MACHINE								X X	X X	X X X	X X X	X X
	S71													
PERONI CORRADO	S72	GTAW SMAW								X	X X	X X	X X	X X
MIRKO GIBBIN	S73	GTAW SMAW SAW ESW GMAW SEMIAUT.								X X	X X X	X X	X X	X X
ZANELLATO OMAR	S74	SMAW SAW GMAW SEMIAUT. GTAW								X	X X	X X X	X X	X X
BELLOMIA FRANCESCO	S75	SMAW SAW GMAW SEMIAUT. ESW								X X	X X	X X X	X X X	
DEVICIENTI ANDREA	S76	GTAW SMAW GMAW SEMIAUT. FCAW SAW								X X	X X	X X X	X X X	X X

Note: The card is updated every three months at least - Lascheda è aggiornata con scadenza minima trimestrale

BREMBANA&ROLLE

QUALIFIED WELDERS LOG YEAR 2023 "Albignasego/Marghera"

Document Nr. WL-01 rev.0
09-01-2018

Prepared by - Preparato da																
Approved by - Approvato da																
Date - Data												08/09/23		07/12/23		
Welder's name Nome del saldatore	**Stamp**	**Process Procedimento**	January	February	March	April	May	June	July	August	September	October	November	December		
LEKAJ NICOLI	S77	SMAW SAW ESW GMAW SEMIAUT.								X	X X	X X	X X	X		
SALVO' CLAUDIO	S78	SMAW SAW ESW GMAW SEMIAUT.								X X	X X	X X	X X	X		
PADOVANI SIMONE	S79	GTAW SMAW GMAW SEMIAUT. GMAW MACHINE								X X X	X X	X X	X X X X	X X		
ZORAN ERMAN	S80	SMAW SAW								X	X	X	X	X		
	S81															
	S82															
SCHRAULECH MORENO	S83	GTAW SMAW								X	X X	X X	X	X X		
LUCATO FABIO	S84	GTAW SMAW								X	X	X X	X	X X		
	S85	GTAW SMAW														
	S86	SMAW SAW														
	S87															
CIOBANU VALENTIN	S88	GTAW SMAW SAW GMAW SEMIAUT. ESW								X X	X X	X X X	X	X X X		
	S89															

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QUALIFIED WELDERS LOG YEAR 2023 "Albignasego/Marghera"

Document Nr. WL-01 rev.0
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Prepared by - Preparato da
Approved by - Approvato da
Date - Data

Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
MELATO TIZIANO	S90	SMAW SAW									X X	X X		X X
DONÀ ANDREA	S91	GTAW SMAW SAW ESW								X	X X	X X	X X	X
BONGOU JEAN	S92	GTAW SMAW SAW								X	X X	X X	X X	X X
	S93													
LEBARKY AYOUB * DIMESSO DAL SETTEMBRE	S94	GTAW SMAW SAW								X	X X			
ALAIN MILOTIC	S95	SAW ESW									X X	X	X	X
	S96													
	S97													
	S98													
	S99													
MIOTTO DENNIS	S100	SMAW SAW								X X	X X	X	X X	X
	S101													

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QUALIFIED WELDERS LOG YEAR 2022 "Albignasego/Marghera"

Document Nr. WL-01 rev.0
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Prepared by - Preparato da															
Approved by - Approvato da															
Date - Data			10/03/22			10/06/22			09/09/22			09/12/22			
Welder's name Nome del saldatore	**Stamp**	**Process Procedimento**	January	February	March	April	May	June	July	August	September	October	November	December
	S51														
CATOZZO DAVIDE	S52	GTAW			X		X					X		
		SMAW		X		X	X	X	X	X	X		X	X
		SAW	X		X				X			X		
		ESW				X					X			X
		GMAW SEMIAUT.	X	X			X			X		X		
		GTAW MACH.		X					X				X	
		FCAW			X	X				X	X			X
FORIN MAURO	S53	GTAW												
		SMAW												
		SAW												
		GMAW SEMIAUT.												
DIOMBANA SITA	S54	GTAW		X		X			X		X		X	
		SMAW	X	X	X		X	X		X	X	X		X
		GMAW SEMIAUT.	X			X			X		X		X	
		SAW		X	X		X	X		X		X		X
BALLOTTA ANDREA	S55	GTAW	X			X	X			X			X	
		SMAW		X	X		X		X	X		X		X
		GMAW SEMIAUT.	X			X		X				X		
		SAW	X	X	X		X		X	X	X		X	X
		ESW						X		X	X	X	X	X
BRUNELLO MAURO	S56	GTAW		X	X		X	X		X		X	X	X
		SMAW	X	X	X	X		X	X		X	X	X	X
		GMAW SEMIAUT.			X				X	X		X		
		FCAW	X			X					X			
LAZZARO FAUSTO	S57	GTAW		X		X		X		X			X	
		SMAW	X		X	X		X	X		X		X	X
		SAW	X	X	X		X		X	X		X		
		GMAW SEMIAUT.	X		X		X	X			X	X		X
		ESW	X			X	X		X			X	X	
		FCAW		X			X			X			X	
BETTIN LUCIANO	S58	GTAW			X			X				X		
		SMAW	X	X		X		X	X		X		X	X
		SAW	X	X	X	X	X		X	X	X	X	X	X
		GMAW SEMIAUT.		X				X				X		
		ESW			X				X				X	

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QUALIFIED WELDERS LOG YEAR 2022 "Albignasego/Marghera"

Document Nr. WL-01 rev.0
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Prepared by - Preparato da															
Approved by - Approvato da															
Date - Data				10/05/22			10/06/22			08/09/22			09/12/22		
Welder's name Nome del saldatore	**Stamp**	**Process Procedimento**	January	February	March	April	May	June	July	August	September	October	November	December
MARTIN PARIDE	S59	SMAW		X		X	X			X		X		X
		SAW			X		X	X			X	X	X	X
		GMAW SEMIAUT.		X					X	X			X	
		ESW			X		X		X		X	X	X	X
SAVOGIN DANIELE	S60	GTAW	X	X		X		X		X		X	X	X
		SMAW		X	X	X	X		X	X	X	X	X	X
		SAW			X			X			X			X
		GMAW SEMIAUT.	X	X			X		X			X		
		FCAW			X			X			X			
		GMAW MACH.		X		X			X				X	
BENAISSOUN MONAIM	S61	GTAW		X			X		X		X		X	
		SMAW			X			X		X		X		X
		SAW		X		X	X		X	X	X	X	X	
		GMAW SEMIAUT.	X	X		X		X			X		X	X
		FCAW			X				X					X
		ESW				X		X		X		X	X	
GARZOTTO MIRKO	S62	GTAW	X		X			X				X		X
		SMAW	X	X					X					X
		GMAW SEMIAUT.			X					X				
CICALA EMANUELE	S63	GTAW												
		SMAW												
		SAW												
		GMAW												
SETTE FIORENZO	S64	GTAW		X	X			X	X		X		X	
		SMAW	X	X	X	X		X		X	X	X	X	X
		GMAW SEMIAUT.	X				X		X			X		
GARBIN LORENZO	S65	GTAW			X									
		SMAW	X	X	X		X		X	X				
		GMAW SEMIAUT.	X		X	X				X				
	S66													
PIVA PAOLO	S67	GTAW	X											
		SMAW				X		X		X		X	X	
		SAW		X	X		X		X		X	X		
		GMAW SEMIAUT.	X	X	X									
		FCAW			X									

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QUALIFIED WELDERS LOG YEAR 2022 "Albignasego/Marghera"

Document Nr. WL-01 rev.0
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Prepared by - Preparato da
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Date - Data

10/03/22 | 20/06/22 | 05/09/22 | 09/12/22

Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
(from October) ~~ZANIRATO DAMIANO~~ FILIPPONE ALESSANDRO	S68	GTAW												
		SMAW										X	X	X
		GMAW SEMIAUT.										X		X
		~~FCAW~~											X	
		~~SAW~~												
LAZZARIN GUERRINO	S69	GTAW		X	X			X			X			
		SMAW	X	X	X	X		X	X	X		X	X	X
		SAW		X	X		X	X		X	X	X		X
		ESW	X			X			X			X	X	
		GMAW SEMIAUT.			X			X			X			X
		FCAW		X			X			X			X	
MANFO MICHAEL	S70	GTAW		X				X		X				
		SMAW	X		X		X	X	X		X		X	X
		GMAW SEMIAUT.	X				X			X		X		X
		SAW		X	X			X	X		X	X	X	
NICOLINI ANTONIO	S71	GTAW												
		SMAW	X		X		X		X		X		X	X
		SAW	X	X	X		X	X		X	X	X	X	X
		ESW		X		X			X	X			X	
		GMAW SEMIAUT.		X		X		X				X		
PERONI CORRADO	S72	GTAW	X	X	X		X			X		X		X
		SMAW	X	X	X	X		X	X		X	X	X	X
MIRKO GIBBIN	S73	GTAW		X		X			X		X		X	
		SMAW	X	X	X		X	X		X		X	X	X
		SAW	X	X	X	X		X	X		X	X		X
		ESW			X		X			X	X		X	
		GMAW SEMIAUT.		X		X			X			X		
ZANELLATO OMAR	S74	SMAW	X	X		X				X	X		X	
		SAW	X	X	X		X	X	X	X	X	X	X	X
		GMAW SEMIAUT.		X			X			X		X		
BELLOMIA FRANCESCO	S75	SMAW		X	X			X		X			X	X
		SAW	X			X	X		X		X	X		X
		GMAW SEMIAUT.		X		X				X			X	
DEVICIENTI ANDREA	S76	GTAW	X	X		X	X		X		X	X	X	
		SMAW		X	X			X	X	X		X	X	X
		GMAW SEMIAUT.	X			X		X	X		X			X
		FCAW			X				X				X	
		SAW		X			X	X				X		

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QUALIFIED WELDERS LOG YEAR 2022 "Albignasego/Marghera"

Document Nr. WL-01 rev.0
09-01-2018

Prepared by - Preparato da
Approved by - Approvato da
Date - Data

10/03/22 | 10/06/22 | 08/09/22 | 03/11/22

Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
LEKAJ NICOLI	S77	SMAW												
		SAW	X	X	X		X	X	X	X	X	X	X	X
		ESW	X			X			X		X		X	X
		GMAW SEMIAUT.		X			X	X	X			X		
SALVO' CLAUDIO	S78	SMAW		X	X			X			X	X		X
		SAW	X		X		X	X	X		X		X	
		ESW		X		X		X		X		X		X
		GMAW SEMIAUT.	X	X			X		X	X			X	
PADOVANI SIMONE	S79	GTAW			X					X			X	
		SMAW	X	X	X	X		X	X		X	X	X	
		GMAW SEMIAUT.	X	X			X			X		X		
		GMAW MACHINE		X	X			X			X			
ZORAN ERMAN	S80	SMAW			X		X			X			X	
		SAW		X			X		X			X		
	S81													
	S82													
SCHRAULECH MORENO	S83	GTAW	X	X	X	X		X		X	X		X	X
		SMAW	X	X	X		X		X		X	X	X	X
LUCATO FABIO	S84	GTAW		X			X		X	X	X		X	
		SMAW	X		X	X		X		X		X		X
GALLO MICHAEL	S85	GTAW		X			X				X		X	
		SMAW	X		X				X			X	X	X
FAWZI MOHAMED	S86	SMAW		X	X			X		X	X	X	X	
		SAW			X	X	X	X	X		X			X
CIOBANU VALENTIN	S88	GTAW	X			X			X				X	
		SMAW		X	X		X	X		X	X		X	X
		SAW	X	X		X			X			X		X
		GMAW SEMIAUT.		X	X			X				X		
RIZZATI ANTONELLO	S89	GTAW			X			X				X		
		SMAW		X			X			X			X	
		SAW			X				X				X	
		GMAW SEMIAUT.	X			X				X				X

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QUALIFIED WELDERS LOG YEAR 2022 "Albignasego/Marghera"

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Prepared by - Preparato da															
Approved by - Approvato da															
Date - Data			16/03/22			10/06/22			08/09/22			09/12/22			
Welder's name Nome del saldatore	**Stamp**	**Process Procedimento**	January	February	March	April	May	June	July	August	September	October	November	December
MELATO TIZIANO	S90	SMAW SAW												
DONÀ ANDREA	S91	GTAW SMAW SAW ESW												
BONGOU JEAN	S92	GTAW SMAW SAW												
	S93													
LEBARKY AYOUB	S94	GTAW SMAW SAW												
	S95													
	S96													
	S97													
	S98													
	S99													
MIOTTO DENNIS	S100	SMAW SAW												
	S101													

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Qualified Welders Log Year 2024 Valbrembo Plant

Doc. No.: WL-BG-2024

Prepared by - Preparato da

Approved by - Approvato da

Date - Data 28/3/24

Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
Bonacina Dario	S01	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		GMAW MACH.												
		GTAW MACH.												
		FCAW												
		SAW												
Scirocco Nicola	S02	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		GMAW MACH.												
		FCAW												
		GTAW MACH.												
Parikkathra Suneesan	S03	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		FCAW												
		SAW												
Belligerante Rosario	S04	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		FCAW												
		SAW												
		GTAW MACH.												
		GMAW MACH.												
		ESW												
Previtali Roberto	S05	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		SAW												
		ESW												
Giustinoni Cristian	S06	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		SAW												
		ESW												

Note: The card is updated every three months at least - La scheda è aggiornata con scadenza minima trimestrale

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Qualified Welders Log Year 2024 Valbrembo Plant

Doc. No.: WL-BG-2024

Prepared by - Preparato da
Approved by - Approvato da
Date - Data 29/3/24

Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
Bruno Pietro	S07	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		FCAW												
	S08													
Donghi Francesco	S09	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW MACH..												
Gargantini Massimiliano	S10	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		SAW												
		ESW												
Joseph Joy	S11	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		SAW												
Imperatore Gennaro	S12	GTAW												
		GTAW MACH.												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												

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Qualified Welders Log Year 2024 Valbrembo Plant

Doc. No.: WL-BG-2024

Prepared by - Preparato da

Approved by - Approvato da

Date - Data 28/3/24

Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
La Pietra Astolfo	S13	GTAW	2		X	X	X							
		GTAW SEMIAUT.	1			2								
		SMAW PNo. 1	1		X	X	X							
		SMAW PNo. 8	1		X	2								
		SMAW PNo. 43		1	X		X							
	S14													
Bonzi Michele	S15	GTAW	1		X	X								
		SMAW PNo. 1	1		X	2	X							
		SMAW PNo. 8	1		X	2	X							
		SMAW PNo. 43			X									
		GMAW SEMIAUT.	1		X									
		GMAW MACH.		1		X								
		GTAW MACH.			X	X								
		SAW	1		X	X								
		ESW		1		X								
Magli Alessandro	S16	GTAW			X	X	X							
		SMAW PNo. 1	1		X	X								
		SMAW PNo. 8		1		X								
		SMAW PNo. 43	1			X	X							
		GTAW MACH.		1	X	X	X							
		GTAW SEMIAUT.			X									
		SAW		1		X								
		GMAW MACH.			X									
		GMAW SEMIAUT.	1		X									
		FCAW			X									
		ESW		1	X									
Iordache Valentin	S17	GTAW		1		X	X							
		SMAW PNo. 1	1		X	X	X							
		SMAW PNo. 8		1	X	X								
		SMAW PNo. 43			X									
		GMAW SEMIAUT.	1			X								
		FCAW		1		X	X							
Stan Georgel	S18	GTAW	1			X								
		SMAW PNo. 1		1	X	X	X							
		SMAW PNo. 8			X									
		SMAW PNo. 43	1		X									
		GMAW SEMIAUT.		1		X	X							
		FCAW		1	X	X	X							
		GTAW SEMIAUT.		1										

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Qualified Welders Log Year 2024 Valbrembo Plant

Doc. No.: WL-BG-2024

Prepared by - Preparato da
Approved by - Approvato da
Date - Data 2P/3/24

Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
Pribescu Constantin	S20	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		ESW												
		SAW												
Ruggeri Andrea	S21	GTAW												
		GTAW MACH.												
		GTAW SEMIAUT.												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		FCAW												
Rota Danilo	S22	GTAW												
		SMAW PNo. 1												
Moyottil Suresh Babu	S23	GTAW												
		SMAW PNo. 1												
	S24													
Ravasio Federico	S25	GTAW												
		GTAW MACH.												
		GTAW SEMIAUT.												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		FCAW												
		SAW												
Miceli Diego	S28	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		SAW												
		ESW												
		GTAW MACH.												
		GMAW MACH.												
Gambirasio Mattia	S30	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		FCAW												

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BREMBANA&ROLLE

Qualified Welders Log Year 2024 Valbrembo Plant

Doc. No.: WL-BG-2024

Prepared by - Preparato da

Approved by - Approvato da

Date - Data 28/3/24

Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
Pezzoli Mauro	S14	GTAW		1	X									
		SMAW PNo. 1	2		X	1	1							
		GMAW SEMIAUT.		1		1								
		FCAW			X		X							
		SAW		1	X	X	X							
		ESW			X	X	X							
Ruzzini Valerio	S31	SAW	1	1	X	X	X							
		ESW	1	2	X	X	X							
Dragosinoiu Vasile Valentin	S33	GTAW			X		X							
		SMAW PNo. 1	1		X	X	X							
		GMAW SEMIAUT.		1		X								
		FCAW		1		X								
		SAW	1	1	X	X	X							
		ESW			X	X	X							
Spataru Florian Claudiu	S34	GTAW	1			X								
		SMAW PNo. 1	1		X	X								
		GMAW SEMIAUT.	1			X								
		FCAW		1			X							
		SAW		1	X	X	X							
		ESW	1		X	X	X							
Gotti Stefano	S38	GTAW	1	1		X								
		SMAW PNo. 1			X	X	X							
		GMAW SEMIAUT.	1	1		X								
		FCAW		1			X							
		SAW	1		X	X	X							
		ESW		1	X	X	X							

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Qualified Welders Log Year 2023 Valbrembo Plant

Doc. No.: WL-BG-2023

Prepared by - Preparato da															
Approved by - Approvato da															
Date - Data			23/03/2023			28/06/2023			20/09/2023			27/12/2023			
Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
Bonacina Dario	S01	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		GMAW MACH.												
		GTAW MACH.												
		FCAW												
		SAW												
Scirocco Nicola	S02	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		GMAW MACH.												
		FCAW												
		GTAW MACH.												
Parikkathra Suneesan	S03	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		FCAW												
		SAW												
Belligerante Rosario	S04	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		FCAW												
		SAW												
		GTAW MACH.												
		GMAW MACH.												
		ESW												
Previtali Roberto	S05	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		SAW												
		ESW												
Giustinoni Cristian	S06	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		SAW												
		ESW												

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Qualified Welders Log Year 2023 Valbrembo Plant

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Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December		
Bruno Pietro	S07	GTAW														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														
		GMAW SEMIAUT.														
		FCAW														
	S08															
Donghi Francesco	S09	GTAW														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														
		GMAW MACH..														
Gargantini Massimiliano	S10	GTAW														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														
		SAW														
		ESW														
Joseph Joy	S11	GTAW														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														
		SAW														
Imperatore Gennaro	S12	GTAW														
		GTAW MACH.														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														

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Qualified Welders Log Year 2023 Valbrembo Plant

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Date - Data			23/03/2023			28/06/2023			20/09/2023						27/12/2023		
Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
La Pietra Astolfo	S13	GTAW												
		GTAW SEMIAUT.												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
	S14													
Bonzi Michele	S15	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		GMAW MACH.												
		GTAW MACH.												
		SAW												
		ESW												
Magli Alessandro	S16	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GTAW MACH.												
		GTAW SEMIAUT.												
		SAW												
		GMAW MACH.												
		GMAW SEMIAUT.												
		FCAW												
		ESW												
Iordache Valentin	S17	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		FCAW												
Stan Georgel	S18	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		FCAW												
		GTAW SEMIAUT.												

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Qualified Welders Log Year 2023 Valbrembo Plant

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Date - Data			23/03/2023			28/06/2023			20/09/2023			27/12/2023				
Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December		
Filipperi Fabio	S19	ESW														
		SAW														
Pribescu Constantin	S20	GTAW														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														
		ESW														
		SAW														
	S21															
	S22															
	S23															
	S24															
Ravasio Federico	S25	GTAW														
		GTAW MACH.														
		GTAW SEMIAUT.														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														
		GMAW SEMIAUT.														
		FCAW														
		SAW														
Miceli Diego	S28	GTAW														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														
		SAW														
		ESW														
		GTAW MACH.														
		GMAW MACH.														
Gambirasio Mattia	S30	GTAW														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														
		GMAW SEMIAUT.														
		FCAW														

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Qualified Welders Log Year 2023 Valbrembo Plant

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Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
Pezzoli Mauro	S14	GTAW												
		SMAW PNo. 1												
		GMAW SEMIAUT.												
		FCAW												
		SAW												
		ESW												
Ruzzini Valerio	S31	SAW												
		ESW												
Dragosinoiu Vasile Valentin	S33	GTAW												
		SMAW PNo. 1												
		GMAW SEMIAUT.												
		FCAW												
		SAW												
		ESW												
Spataru Florian Claudiu	S34	GTAW												
		SMAW PNo. 1												
		GMAW SEMIAUT.												
		FCAW												
		SAW												
		ESW												
Gotti Stefano	S38	GTAW												
		SMAW PNo. 1												
		GMAW SEMIAUT.												
		FCAW												
		SAW												
		ESW												

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Qualified Welders Log Year 2022 Valbrembo Plant

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Date - Data			23/03/2022			17/06/2022			23/09/2022			27/12/2022			
Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
Bonacina Dario	S01	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		GMAW MACH.												
		GTAW MACH.												
		FCAW												
		SAW												
Grasso Stefano	S02	GTAW												
		GTAW SEMIAUT.												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		SAW												
		ESW												
		GMAW SEMIAUT.												
		GMAW MACH.												
		FCAW												
		GTAW MACH.												
Parikkathra Suneesan	S03	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		FCAW												
		SAW												
Belligerante Rosario	S04	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		FCAW												
		SAW												
		GTAW MACH.												
		GMAW MACH.												
		ESW												
Andrea Rallo	S06	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		SAW												

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Qualified Welders Log Year 2022 Valbrembo Plant

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Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December		
Bruno Pietro	S07	GTAW														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														
		GMAW SEMIAUT.														
		FCAW														
Magli Antonio	S08	GTAW														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														
		GMAW SEMIAUT.														
		GMAW MACH.														
		GTAW MACH.														
		FCAW														
		SAW														
		ESW														
Moussa Thiam	S09	GTAW														
		SMAW PNo. 1														
		SAW														
Gargantini Massimiliano	S10	GTAW														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														
		SAW														
		ESW														
Joseph Joy	S11	GTAW														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														
		SAW														
Imperatore Gennaro	S12	GTAW														
		GTAW MACH.														
		SMAW PNo. 1														
		SMAW PNo. 8														
		SMAW PNo. 43														

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Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December		
La Pietra Astolfo	S13	GTAW	X	X	X		X		X			X		X		
		GTAW SEMIAUT.	X	X	X	X	X			X			X			
		SMAW PNo. 1		X	X	X		X		X			X			
		SMAW PNo. 8	X	X			X		X		X			X		
		SMAW PNo. 43	X		X		X	X		X			X			
Sortino Sebastiano	S14	GTAW	X	X	X			X				X				
		GTAW SEMIAUT.		X		X	X		X			X		X		
		SMAW PNo. 1	X	X	X		X	X		X	X		X			
		SMAW PNo. 8	X	X		X	X		X			X				
		SMAW PNo. 43	X	X	X			X	X			X		X		
Magli Alessandro	S16	GTAW		X			X					X				
		SMAW PNo. 1			X	X		X		X			X	X		
		SMAW PNo. 8	X	X	X		X	X	X		X		X	X		
		SMAW PNo. 43	X	X		X				X	X	X	X			
		GTAW MACH.		X	X	X		X	X							
		GTAW SEMIAUT.		X				X	X		X			X		
		SAW	X	X	X		X			X			X	X		
		GMAW MACH.		X		X		X			X					
		GMAW SEMIAUT.		X		X	X			X		X				
		FCAW	X	X	X		X	X	X			X				
		ESW	X	X			X			X	X		X	X		
Iordache Valentin	S17	GTAW		X		X				X						
		SMAW PNo. 1	X	X	X		X	X	X		X			X		
		SMAW PNo. 8	X	X	X		X			X		X	X			
		SMAW PNo. 43			X	X	X	X		X			X			
		GMAW SEMIAUT.	X	X		X	X		X			X	X			
		FCAW		X	X			X		X	X	X		X		
Stan Georgel	S18	GTAW		X			X	X	X			X		X		
		SMAW PNo. 1	X	X	X		X			X		X		X		
		SMAW PNo. 8	X	X	X	X	X	X	X		X		X			
		SMAW PNo. 43	X	X		X	X			X		X				
		GMAW SEMIAUT.	X			X		X	X	X			X	X		
		FCAW		X	X		X				X		X			
		GTAW SEMIAUT.	X		X	X		X	X			X	X	X		
Pribescu Constantin	S20	GTAW		X			X	X		X			X			
		SMAW PNo. 1			X				X			X		X		
		SMAW PNo. 8	X			X	X			X		X				
		SMAW PNo. 43	X			X		X	X					X		
		ESW	X	X	X		X			X		X		X		
		SAW	X	X	X		X	X	X	X	X			X		

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Qualified Welders Log Year 2022 Valbrembo Plant

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Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
Maraja Xhuliano	S20	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		FCAW												
Ravasio Federico	S25	GTAW												
		GTAW MACH.												
		GTAW SEMIAUT.												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		FCAW												
		SAW												
Miceli Diego	S28	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		SAW												
		ESW												
		GTAW MACH.												
		GMAW MACH.												
Regazzoni Francesco	S29	GTAW												
		GTAW MACH.												
		GTAW SEMIAUT.												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		FCAW												
Gambirasio Mattia	S30	GTAW												
		SMAW PNo. 1												
		SMAW PNo. 8												
		SMAW PNo. 43												
		GMAW SEMIAUT.												
		FCAW												

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Qualified Welders Log Year 2022 Valbrembo Plant

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Approved by - Approvato da

Date - Data 23/09/2022 — 27/12/2022

Welder's name Nome del saldatore	Stamp	Process Procedimento	January	February	March	April	May	June	July	August	September	October	November	December
Previtali Roberto	S05	GTAW												
		SMAW PNo. 1									X	X	X	X
		SMAW PNo. 8									X			X
		SMAW PNo. 43										X		
		GMAW SEMIAUT.											X	X
		SAW										X		X
		ESW									X		X	X
Filipperi Fabio	S19	SAW							X	X	X	X	X	X

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