



Qualification test certificate for

☒ welding operators

☐ weld setter

according EN ISO 14732:2013

welding procedure specification: FW 03.24

Certificate No: IT/24/P/0428

Reference No. (if applicable): 74-C-24000235

Examiner: D.Tempesti

Name:

Welder sign:

Method of Identification: Identity card

Examining body: TÜV AUSTRIA GMBH
1230 Vienna, Deutschstraße 10

Identification no.:

Recognized third party organization according article 20, 24 and annex I 3.1.2. of directive 2014/68/EU

Date and place of birth:

Employer: EREDI DI MAGGIONI NATALE S.r.l. - Varedo (MB)

Code/testing standard: EN ISO 14732:2013

Functional knowledge: ☒ acceptable

☐ not acceptable (cross where applicable)

Job knowledge: ☒ acceptable

☐ not tested (cross where applicable)

Weld details	Range of qualification
Welding process: 135	135
Welding equipment: FRONIUS TPS 320i s+OMRON TMEX	Same type of welding equipment
Welding unit:	

Details for mechanized welding:

Visual control: ☒ direct ☐ remote	Direct visual control
Automatic arc length control: ☐ yes ☒ no	With and without automatic arc length control
Automatic joint tracking: ☐ yes ☒ no	With and without automatic joint tracking
Welding position: PB	PB
☒ Single run technique ☐ Multi run technique	Single run technique
Material backing: ☐ yes ☒ no	With and without material backing
Consumable insert: ☐ yes ☒ no	With and without consumable insert

Details for automatic welding:

Joint sensor: ☐ yes ☐ no	
Arc sensor control: ☐ yes ☐ no	
☐ Single run technique ☐ Multi run technique	

Additional information is available on welding procedure specification No: FW 03-24

The qualification is based on:	Certification body: TÜV AUSTRIA GMBH
welding procedure test (see 4.1a)) ☒	
pre-production welding test (see 4.1b)) ☐	
standard test piece (see 4.1c)) ☐	
production test or production sample testing (see 4.1d)) ☐	
Results of the qualification test see document No. 24/0938RP01 Quality Control S.r.l.	Name and signature: Ing. Polichetti Mariano
	Place of issue: Erbusco (BS)
	Date of issue: 17/07/2024
	Place of welding: Varedo (MB)
	Date of welding: 28/05/2024
	Valid until: 28/05/2030

Validity according 5.3: ☒ a) ☐ b) ☐ c)

Re-validation for qualification by employer/welding coordinator for the following 6 months (see clause 5.2):

Date	Signature	Position or title	Date	Signature	Position or title

CERTIFICATO DI QUALIFICA PROCEDIMENTO DI SALDATURA WELDING PROCEDURE QUALIFICATION RECORD

Specifica procedura di saldatura: Welding procedure specification:	FW 03-24 (WPQR FW 03-24)	Organismo di ispezione: Inspecting authority:	TÜV AUSTRIA GMBH
Riferimento N.: Reference No:	74-C-24000235	Rapporto N.: Report No:	BS/RE/DT/24/0425
Fabbricante: Manufacturer:	EREDI di MAGGIONI NATALE S.r.l.	Indirizzo: Address:	Via Sondrio, 7/9 – 20813 Varedo (MB)
Norma applicata*: Applied standard*:	EN ISO 15614-1: 2017 + A1:2019, Level 2	Altre norme e/o specifiche applicabili: Other standards and specifications:	---
Data di saldatura: Date of welding:	28/05/2024	* ambito di accreditamento dell'organismo di controllo Scope of accreditation of the inspection body	

CAMPO DI VALIDITA' RANGE OF APPROVAL

Processo(i) di sald. e grado di meccaniz.: Welding process(es) and degree of mech.:	135 fully mechanized
Modalità di trasferimento: Transfer mode:	Spray, globular, pulsed
Tipo di giunto saldato: Joint type:	FW in any type of joint
Passata singolo o multipla: Single run or multi run:	Single run
Materiale(i) base (ISO/TR 15608): Parent metal (ISO/TR 15608):	1 – 1 The equal or lower specified minimum yield strength steels are qualified
Spessore(i) del materiale base [mm]: Parent metal thickness [mm]:	1,75 to 5,0
Spessore(i) del mat. depositato [mm]: Deposited metal thickness [mm]:	n.a.
Diametro(i) esterno(i) del tubo(i) [mm]: Pipe outside diameter(s) [mm]:	>500 (>150 in the PC, in PF rotated position or in PA rotated position)
Altezza di gola "a" [mm]: Design throat thickness "a" [mm]:	2,8 to 5,6 (single run)
Tipo(i) materiale(i) d'apporto / desig.: Filler material type / designation:	ENISO 14341-A G3Si1 filler material covers other filler materials as long as they have same designation, equivalent mech. properties, same nominal chemical composition and the same or lower hydrogen content.
Marca materiale(i) d'apporto Filler material tradename:	No restriction
Gas di protezione / flusso: Gas / Flux:	ENISO14175-M20 addition or deletion of max. 0,1% of any gas component is allowed; a deviation of max. ±20%(relative) of the nominal composition of the CO ₂ content is allowed
Protezione al rovescio: Gas backing:	optional
Tipo di corrente e polarità: Type of welding current and polarity:	DC-EP , pulsed
Posizione(i) di saldatura: Welding position(s):	All positions except PG, PJ and J-L045
Apporto termico [kJ/mm]: Heat input [kJ/mm]:	No restriction
Preriscaldamento [°C]: Preheating [°C]:	Min. 5
Temperatura tra le passate [°C]: Interpass temperature [°C]:	n.a.
Post riscaldamento [°C]: Post heating [°C]:	n.a.
Trattamento termico dopo saldatura: Post weld heat treatment:	n.a.
Altre informazioni: Other information:	Neither impact nor hardness requirements are specified Welding equipment : FRONIUS TPS 320i + OMRON TMEX

☒ **Si conferma che l'imparzialità secondo KRL 006 è stata verificata.**
It is hereby confirmed that the impartiality according to KRL 006 is given.

17/07/2024

Erbusco (BS)

Data di emissione
Date of issue

Luogo
Location

Organismo notificato 0408 / Notified Body 0408
TÜV AUSTRIA GMBH

TÜV AUSTRIA GMBH

Notifizierte Stelle/Notified Body 0408

FM-INE-FT-VP-0100a

Rev. 17

Seite 1 von 3 / Page 1 of 3

Auszugsweise Vervielfältigung nur mit Genehmigung der TÜV AUSTRIA GMBH gestattet.
Alle Konformitätsbewertungstätigkeiten erfolgen gemäß QM-System der
TÜV AUSTRIA GMBH

Excerpt duplication only with permission of TÜV AUSTRIA GMBH.
All conformity assessment activities were carried out in accordance with the QM-system of
TÜV AUSTRIA GMBH..

Deutschstraße 10
1230 Wien / Austria
Tel.: +43 (0)504 54
Mail: info@tuv.at
Web: <http://www.tuv.at>




Ing. Polichetti Mariano

