

WELDER APPROVAL CERTIFICATE
ACCORDING TO UNI EN 287-1:2012



No. **13MI00702PO1**

Designation	UNI EN 287-1 135 P FW 1.1 S t5 PB sl		
Welder	RUGGIERI FRANCO		
Born in	GENOVA (GE)	on	30/03/1964
Identification	Method of Identification	C.F.	Stamp No. 1
Employed by	PHOENIX INTERNATIONAL S.R.L. - GENOVA (GE)		
WPS used by welder during welding of test coupon: 1/2013		Job knowledge: not tested	

Welding variables	Test piece	Range of approval
Welding process	135	135-138
Plate or pipe	P	Plates and pipes
Joint type	FW	Fillet weld
Material group(s) ISO/TR 15608	1.1	1.1, 1.2, 1.4
Welding consumables	Solid wire	Solid wire/electrode core: M
Material thickness (mm)	5	3 and over
Pipe outside diameter (mm)	N.A.	150 and over
Welding position(s)	PB	PA, PB
Weld details	sl	sl

Type of test							
Visual	Acceptable	Radiographic	Not tested	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Not tested	Fracture	Acceptable	Bend	Not tested		

This certificate is valid until	22 October 2015		
Issued at	GENOVA	on	22 October 2013

This certificate consist of 2 pages

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Form EN 287-1-12

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Via Corsica 12 - 16128 Genova



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WELDER APPROVAL CERTIFICATE
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No. **13MI00702PO2**

Designation	UNI EN 287-1 135 P FW 1.1 S t5 PB sl		
Welder	MANFREDINI FERNANDO		
Born in	NOVI LIGURE (AL)	on	12/12/1964
Identification	MNFFNN64T12F965K	Method of Identification	C.F. Stamp No. 2
Employed by	PHOENIX INTERNATIONAL S.R.L. - GENOVA (GE)		

WPS used by welder during welding of test coupon: 1/2013

Job knowledge: not tested

Welding variables	Test piece	Range of approval
Welding process	135	135-138
Plate or pipe	P	Plates and pipes
Joint type	FW	Fillet weld
Material group(s) ISO/TR 15608	1.1	1.1, 1.2, 1.4
Welding consumables	Solid wire	Solid wire/electrode core: M
Material thickness (mm)	5	3 and over
Pipe outside diameter (mm)	N.A.	150 and over
Welding position(s)	PB	PA, PB
Weld details	sl	sl

Type of test							
Visual	Acceptable	Radiographic	Not tested	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Not tested	Fracture	Acceptable	Bend	Not tested		

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WELDER APPROVAL CERTIFICATE
ACCORDING TO UNI EN 287-1:2012



No. **13MI00702PO3**

Designation	UNI EN 287-1 135 P BW 1.1 S t5 PA bs		
Welder	MANFREDINI FERNANDO		
Born in	NOVI LIGURE (AL)	on	12/12/1964
Identification	MNFFNN64T12F965K	Method of Identification	C.F. Stamp No. 2
Employed by	PHOENIX INTERNATIONAL S.R.L. - GENOVA (GE)		

WPS used by welder during welding of test coupon: **1/2013**

Job knowledge: **not tested**

Welding variables	Test piece	Range of approval
Welding process	135	135-138
Plate or pipe	P	Plates and pipes
Joint type	BW	Butt weld
Material group(s) ISO/TR 15608	1.1	1.1, 1.2, 1.4
Welding consumables	Solid wire	Solid wire/electrode core: M
Material thickness (mm)	5	3 to 10
Pipe outside diameter (mm)	N.A.	150 and over
Welding position(s)	PA	PA
Weld details	bs	ss mb,bs

Type of test							
Visual	Acceptable	Radiographic	Acceptable	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Not tested	Fracture	Not tested	Bend	Acceptable		

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WELDER APPROVAL CERTIFICATE
 ACCORDING TO UNI EN 287-1:2012



No. **13MI00702PO4**

Designation	UNI EN 287-1 135 P BW 1.1 S t2 PA ss nb		
Welder	RUGGIERI FRANCO		
Born in	GENOVA (GE)	on	30/03/1964
Identification	Method of Identification	C.F.	Stamp No. 1
Employed by	PHOENIX INTERNATIONAL S.R.L. - GENOVA (GE)		
WPS used by welder during welding of test coupon: 2/2013		Job knowledge: not tested	

Welding variables	Test piece	Range of approval
Welding process	135	135-138
Plate or pipe	P	Plates and pipes
Joint type	BW	Butt weld
Material group(s) ISO/TR 15608	1.1	1.1, 1.2, 1.4
Welding consumables	Solid wire	Root: Solid wire Fill/Cap: Solid wire/electrode core: M
Material thickness (mm)	2	2 to 4
Pipe outside diameter (mm)	N.A.	150 and over
Welding position(s)	PA	PA
Weld details	ss nb	ss nb,ss mb,bs

Type of test							
Visual	Acceptable	Radiographic	Acceptable	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Not tested	Fracture	Not tested	Bend	Acceptable		

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WELDER APPROVAL CERTIFICATE
 ACCORDING TO UNI EN 287-1:2012



No. **13MI00702PO5**

Designation	UNI EN 287-1 135 P BW 1.1 S t2 PA ss nb		
Welder	MANFREDINI FERNANDO		
Born in	NOVI LIGURE (AL)	on	12/12/1964
Identification	MNFFNN64T12F965K	Method of Identification	C.F. Stamp No. 2
Employed by	PHOENIX INTERNATIONAL S.R.L. - GENOVA (GE)		

WPS used by welder during welding of test coupon: **2/2013**

Job knowledge: **not tested**

Welding variables	Test piece	Range of approval
Welding process	135	135-138
Plate or pipe	P	Plates and pipes
Joint type	BW	Butt weld
Material group(s) ISO/TR 15608	1.1	1.1, 1.2, 1.4
Welding consumables	Solid wire	Root: Solid wire Fill/Cap: Solid wire/electrode core: M
Material thickness (mm)	2	2 to 4
Pipe outside diameter (mm)	N.A.	150 and over
Welding position(s)	PA	PA
Weld details	ss nb	ss nb,ss mb,bs

Type of test							
Visual	Acceptable	Radiographic	Acceptable	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Not tested	Fracture	Not tested	Bend	Acceptable		

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WELDER APPROVAL CERTIFICATE
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No. **13MI00702PO6**

Designation	UNI EN 287-1 135 P FW 1.1 S t2 PB sl		
Welder	RUGGIERI FRANCO		
Born in	GENOVA (GE)	on	30/03/1964
Identification	Method of Identification	C.F.	Stamp No. 1
Employed by	PHOENIX INTERNATIONAL S.R.L. - GENOVA (GE)		

WPS used by welder during welding of test coupon: **2/2013**

Job knowledge: **not tested**

Welding variables	Test piece	Range of approval
Welding process	135	135-138
Plate or pipe	P	Plates and pipes
Joint type	FW	Fillet weld
Material group(s) ISO/TR 15608	1.1	1.1, 1.2, 1.4
Welding consumables	Solid wire	Solid wire/electrode core: M
Material thickness (mm)	2	2 to 3
Pipe outside diameter (mm)	N.A.	150 and over
Welding position(s)	PB	PA, PB
Weld details	sl	sl

Type of test							
Visual	Acceptable	Radiographic	Not tested	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Acceptable	Fracture	Not tested	Bend	Not tested		

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WELDER APPROVAL CERTIFICATE
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No. **13MI00702PO7**

Designation	UNI EN 287-1 135 P FW 1.1 S t2 PB sl		
Welder	MANFREDINI FERNANDO		
Born in	NOVI LIGURE (AL)	on	12/12/1964
Identification	MNFFNN64T12F965K	Method of Identification	C.F. Stamp No. 2
Employed by	PHOENIX INTERNATIONAL S.R.L. - GENOVA (GE)		

WPS used by welder during welding of test coupon: **2/2013**

Job knowledge: **not tested**

Welding variables	Test piece	Range of approval
Welding process	135	135-138
Plate or pipe	P	Plates and pipes
Joint type	FW	Fillet weld
Material group(s) ISO/TR 15608	1.1	1.1, 1.2, 1.4
Welding consumables	Solid wire	Solid wire/electrode core: M
Material thickness (mm)	2	2 to 3
Pipe outside diameter (mm)	N.A.	150 and over
Welding position(s)	PB	PA, PB
Weld details	sl	sl

Type of test							
Visual	Acceptable	Radiographic	Not tested	Magnetic particle	Not tested	Penetrant	Not tested
Macro	Acceptable	Fracture	Not tested	Bend	Not tested		

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