

1 **WELDING PROCEDURE APPROVAL TEST CERTIFICATE**

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3 Manufacturer's welding procedure: WPQR ARCOI 01 (18.10.2010) Inspection Authority APRAGAZ  
 Delegate: Eng. D. Naessens (E.W.E.)  
 Angelo Quirini (CSQ)  
 4 Procedure reference n°: / Reference n°: 1001/P11873/009/RI  
 Report n°: 116165  
 5 Manufacturer: ARCO IMPIANTI S.R.L.  
 6 Address: Via dell'Unione Europea, 83/A – 70051 Barletta (BAT)



7 Code / Testing standard: UNI EN ISO 15614-1

8 Date of welding: 18.10.2010

9 **RANGE OF APPROVAL**

	Weld test	Range of approval
10 Welding process:	141 + 111	141 + 111
11 Joint type:	BW	BW , FW
12 Parent metal group:	ASTM A 106.B/API5L Grade B - Group 1.2.	Group 1 to Group 1
13 Parent metal thickness [mm]:	7.11	3 to 14,22
14 Pipe outside diameter [mm]:	168.3	≥ 84,15
15 Filler metal type / designation	141 : AWS A5.18 ER 70S-6 / EN ISO 636-A:W 46 4 W3Si1 111 : AWS A 5.1: ER 7018-1 H4R/ISO 2560-A:E 42 5 B 32 H5	141 : same type 111 : same type
16 Gas / Flux:	141 : Ar 99,99 % (EN14175 – I1)	141 : EN14175 – I1
17 Type of welding current:	141 : DC- 111 : DC+	141 : DC- 111 : DC+
18 Welding positions:	H-L045	All positions, except PG & J-L045
19 Preheat:	>20°C	> 20°C
20 Post weld heat treatment:	//	//

21 OTHER INFORMATION: /

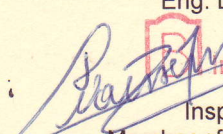
22 We certify that the tests were prepared, welded and tested in accordance with the requirements of the code / testing standard indicated above.

Brussels, on 06/12/10

23 Location: Taranto (CSQ)

Date of issue: 09.11.2010

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Eng. D. Naessens  
  
**APRAGAZ**  
 Ing. Didier NAESSENS  
 E.W.E. - Auditor  
 Inspecting Authority  
 Member of CEOC Organization