

Qualifications List

N°	DESCRIPTION	JOINT	THICKNESS mm	POS.	PQR	WPS	GTAW	SMAW	GMAW	SAW	PAW	T.T.	PROGRESS	HRc	Kv	TEMP.	PREHEATING	WELDER	WPQ
1	A564 TP 630 - A564 TP 630	Corner		2F	12001	12011	X	X					Successful				20°C	S 1	1
2	AISI 316L - AISI 316L	Butt	40	2G	12101	12111	X	X					Successful		YES	-196	16°C	S 1	2
3	A 350 LF2 - A350 LF1	Butt	40	2G	12201	12211	X	X					Successful		YES	-46	20°C	S 1	3
4	A564 TP 630 - AISI 316L	Corner		2F	12301	12311	X	X					Successful				20°C	S 1	4
5	STELLITE(GR6) on P8	Hard facing overlay (HFO)	3,5 Min.	1G	12401	12411	X						Successful				150°C	S 1	5
6	A564 TP 630 - A564 TP 630	Butt	30	2G	13002		X	X					Paused						
7	INCONEL 625 on P1	Hard facing overlay (HFO)	3,00 Min	1GR	13501	13511			X				Successful				60°C	S 1	7
8	INCONEL 625 on P1 (repair)	Hard facing overlay (HFO)	3,50 Min	1G	13601	13611		X					Successful				60°C	S 1	8
9	STELLITE(GR6) on P6	Hard facing overlay (HFO)	6,00 Min.	1G	13701	13711	X		X				Successful				300°C	S 1	9
10	309L on P5a	Corrosion resistant overlay (CRO)	3,00 Min.	1G	13801	13811	X						Successful				80°C	S 1	10
11	309L on P4	Corrosion resistant overlay (CRO)	3,00 Min.	1G	13901	13911	X						Successful				80°C	S 1	11
12	A564 TP 630 - A105	Butt	30	2G	13102	13112	X	X					Successful				20°C	S 1	12
13	STELLITE(GR6) on P1	Hard facing overlay (HFO)	6,00 Min.	1G	13202	13212	X		X				Successful				300°C	S 1	13
14	STELLITE(GR6) on P10H	Hard facing overlay (HFO)	6,00 Min.	1G	13302	13312	X		X				Successful				50°C	S 1	14
15	A747 CB7CU1 - A747 CB7CU1	Corner		2F	13402	13412	X	X					Successful				20°C	S 1	15
16	A747 CB7CU1 - A705 TP 630	Corner		2F	13502	13512	X	X					Successful				20°C	S 1	16
17	STELLITE(GR6) on A564 TP 630	Hard facing overlay (HFO)	6,00 Min.	1G	13602	13612	X		X				Successful				50°C	S 1	17
18	A182 F51 - A182 F51	Butt	40	2G	13702	13712	X	X					Successful				20°C	S 1	18
19	A182 F55 - A182 F316	Butt	40	2G	14001	14011	X	X					Successful				20°C	S 1	19
20	STELLITE(GR6) on P10H sp.<25	Hard facing overlay (HFO)	6,00 Min.	1G	14101	14111	X		X				Successful				50°C	S 1	20
21	STELLITE(GR21) on P4	Hard facing overlay (HFO)	6,00 Min.	1G	14201	14211	X						Successful				300°C	S 1	21
22	316L on P1	Corrosion resistant overlay (CRO)	6,00 Min.	1G	14301	14311			X				Successful				300°C	S 1	22
23	COLMONOY 5 on P8	Corrosion resistant overlay (CRO)	3,00 Min.	1G	14401	14411	X						Paused				150°C	S 1	23

Emissione

Francesco Di Gemino