

EUROZETA S.r.l.

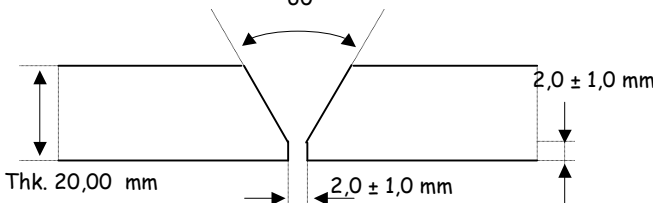
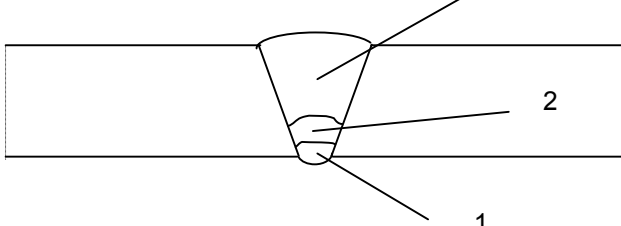
Via Drione,10 – 24060 – CASAZZA (BG)

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PROCEDURE QUALIFICATION RECORD (PQR)
ACCORDING TO ASME CODE SECT. IX
QW-483

sheet 1 of 2

Company Name :		EUROZETA S.r.l. - 24060 - CASAZZA (BG)							
Procedure Qualification Record PQR No. :		02- 2012 Rev. 00			Date :	12/09/2012			
WPS No. :		02- 2012 Rev. 00 dated 21/06/2012							
Welding Process(es) :		GMAW		Types :		Partially Mechanized			
Joints (QW 402)		Joint Design: 60°		Details :		3 - n			
		2,0 ± 1,0 mm				1			
Thk. 20,00 mm		Plate Thk. 20,0 mm		Groove design used					
BASE METAL (QW-403)				POSTWELD HEAT TREATMENT (QW-407)					
Material Spec.		EN 10025-2 S755 JR		Temperature :		-----			
Material Spec.		EN 10025-2 S275 J2		Time :		-----			
P. No. & Group		---- Group ---- To P. No.---- Group ----		Other :		-----			
Range Thickness :		5,0 to 40,00 mm (Low Temp 16,0 to 40,0 mm)		GAS (QW-408) % composition					
Diameter :		≥ 73,0 mm		Gas(es)		(Mixture) Flow Rate			
Other :				Shielding :		Argon + CO₂ 82% + 18% 13 l / min			
FILLER METALS (QW-404)		GMAW 1 st Pass	GMAW 2 nd Pass	GMAW 3-n Pass	Backing :		none none none		
SFA Specification :		5.18		Shielding :		none none none			
AWS Classification :		ER 70S-6		ELECTRICAL CHARACTERISTICS (QW-409)					
Filler Metal F. No. :		6		Polarity :		1st & 2nd Pass Pulsed / Reverse (+) Other Passes DC / Reverse (+)			
Weld Metal Analys. A. No. :		1		Amperes :		Volts :			
Size of Electrodes (mm) :		Solid Wire Ø 1,2 mm		1) GMAW = 170 2) GMAW = 180 3-n) GMAW = 195		25 25 25			
Wire Trade Name :		LAFILI LA/S6N		TugstenElectrode Size :		n/a			
Deposited Weld Metal (mm)		2,0 mm	2,0 mm	16,0 mm	Other :			Max Heat Input : GMAW 1,342 KJ/ mm	
Other :		GMAW process : t pass < 13 mm							
POSITION (QW-405)				TECHNIQUE (QW-410)					
Position of Groove		2G		Travel Speed (cm/min.) :		1) GMAW : 19 cm / min 2 & 3-n) GMAW : 23 cm / min			
Weld Progression (Uph. Dow.)		n/a		String or Weave Bead :		String			
PREHEAT (QW-406)				Oscillation :		NO			
Preheat Temperature :		10° C. minimun		Multipass or Single Pass (for Side)		Multiple			
Interpass Temperature :		280° C. max.		Single or Multiple Electrodes :		Single			
Preheat maintenance :		N/A		Other		QW 410.64 "use of tthermal process": N/A Stand off distance : 15 – 20 mm			

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PROCEDURE QUALIFICATION RECORD (PQR) ACCORDING TO ASME CODE SECT. IX QW-483

sheet 2 of 2 (PQR 02-2012 Rev.00)

Tensile Test (QW - 150)

Specimen No.	Size (mm)	Direction	Area (N/mm ²)	Ult.Total Load (N/mm ²)	Ult.Unit Stress (N/mm ²)	Charact.of Fail & Location
02	19,5 x 19,0	T	370,5	194500	525	Out of weld – Ductile fracture
02	19,6 x 19,0	T	372,4	196500	528	Out of weld – Ductile fracture (S275 JR Side)

Guided Bend Test (QW - 160)

Specimen No.	Type and Figure No.	Result
02	Transversal – Side (180/4T)	Satisfactory
02	Transversal – Side (180/4T)	Satisfactory
02	Transversal – Side (180/4T)	Satisfactory
02	Transversal – Side (180/4T)	Satisfactory

Toughness Test (QW - 170)

Specimen No.	Direction	Notch Type	Test Temp.	Impact Value (joule)	Dimensions	Note
02	T	KV	-20 °C	57 – 63 – 50	10 X 10 x 55	Weld metal
02	T	KV	-20 °C	30 – 30 – 29	10 X 10 x 55	HAZ – S275 JR Side
02	T	KV	-20 °C	38 – 35 – 41	10 X 10 x 55	HAZ – S275 J2 Side

Fillet Weld Test (QW - 180)

Result-Satisfactory (yes/no) : ---	Penetr.into Parent Metal (yes/no) : ---
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Other Test

Type of Test :	Macrographic examination , Certificate Quality Control No. 1735RP001/12 sheet 6 of 7
Other :	X-Ray Certificate Quality Control No. 1735RP001/12 sheet 4 of 7
	Hardness test in BM, HAZ, WM , Certificate Quality Control No. 1735RP001/12 sheet 7 of 7
	Mechanical test , Certificate Quality Control No. 1735RP001/12 sheet 5 of 7
	Visual Examination test Certificate Quality Control No. 1735RP001/12 sheet 2 of 7

Welder' s Name :	ZGURA DORU	Clock No. :	---	Stamp No. :	ZD
Welder' s Name :	-----	Clock No. :	---	Stamp No. :	-----
Test Conducted by	EUROZETA S.r.l. – AIB VINCOTTE	Laboratory Test No.	Quality Control No. 1735RP001/12		

We certify that the statement in the record are correct and that the test welds were prepared,welded and tested in accordance with the requirements of Sect.IX of the ASME Code.

Prepared by : EUROZETA S.r.l.	AIB VINCOTTE INTERNATIONAL
Date : 12/09/2012	