

Welder's Name **Pippo Cappadona**

Identification No. **PB**

TEST DESCRIPTION

Identification no. of WPS followed	396	<input checked="" type="checkbox"/>	Test coupon	<input type="checkbox"/>	Production weld
Specification of base metal(s)	ASTM B 265 Unalloyed Titanium Grade 2		Thickness	8 mm.	

TESTING CONDITIONS AND QUALIFICATION LIMITS

Welding Variables (QW-350)	Actual Values	Range Qualified
Welding process(es) Type (ie; manual, semi-auto) used Backing (metal, weld metal, double-welded, etc.) <input type="checkbox"/> Plate <input checked="" type="checkbox"/> Pipe (enter diameter if pipe or tube) Base Metal P- or S-Number to P- or S-Number Filler metal or electrode specification(s) (SFA) (info. only) Filler metal or electrode classification(s) (info. only) Filler metal F-Number(s) Consumable insert (GTAW or PAW) Filler type (solid/metal or flux cored/powder) GTAW or PAW Deposited thickness for each process Process 1: GTAW 3 layers minimum <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No Process 2: - 3 layers minimum <input type="checkbox"/> Yes <input type="checkbox"/> No Position qualified (2G, 6G, 3F, etc.) Vertical progression (uphill or downhill) Type of fuel gas (OFW) Inert gas backing Transfer mode (spray/globular or pulse to short circuit) Current type/polarity (AC, DCEP, DCEN)	GTAW MANUAL none 50 mm. 51 5.16 - 51 none ER Ti 2 8 mm. 3 - 1G - - Ar 99,99% -	GTAW MANUAL - over 1 in. 51 1G - - Ar 99,99%

RESULTS

Visual Examination of Completed Weld (QW-302.4)	SATISFACTORY				
<input checked="" type="checkbox"/> Bend Test;	<input checked="" type="checkbox"/> Transverse root and face [QW-462.3(a)];	<input type="checkbox"/> Longitudinal root and face [QW-462.3(b)];	<input type="checkbox"/> Side (QW-462.2);		
<input type="checkbox"/> Pipe bend specimen, corrosion-resistant overlay [QW 462.5(c)]	<input type="checkbox"/> Plate bend specimen, corrosion-resistant overlay [QW-462.5(d)];				
<input type="checkbox"/> Macro test for fusion [QW-462.5(b)];	<input type="checkbox"/> Macro test for fusion [QW-462.5(e)]				

Type	Result	Type	Result	Type	Result

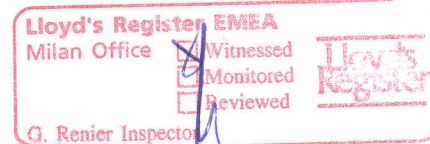
Alternative radiographic examination results (QW-191)	SATISFACTORY as per Italtest Cert. no. RT 1.0775/2009				
Fillet weld - fracture test (QW-180)	-	Length and percent of defects	x		
Macro examination (QW-184)	Fillet size (in/mm)	x	Concavity/convexity (in/mm.)		
Other tests	Macrographic examination x 4,5				
Film or specimens evaluated by	G. Grossi	Company	IRTEC		
Mechanical tests conducted by	IRTEC	Laboratory test no.	5940/09		
Welding supervised by	Stefano Angelini				

We certify that the statements in this record are correct and that the test coupons were prepared, welded, and tested in accordance with the requirements of Section IX of the ASME Boiler and Pressure Vessel Code.

Date issued 12 November 2009


Stefano Angelini
Manufacturer's Representative

by



G. Renier
Inspector to Lloyd's Register EMEA

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