

# CGN

Direzione e Stabilimento: Loc. Scaravella 20018 Sedriano (MI)  
 tel. 0290111023 fax 0290110610 e-mail: [cgnet@aginet.it](mailto:cgnet@aginet.it)

**MANUFACTURER'S RECORD OF WELDER  
 WELDING OPERATOR QUALIFICATION TEST (WPQ)**

QW-301, Section IX, ASME Boiler and Pressure Vessel Code

**QUALIFICATION TEST No. 01-2019 - MD**

Welder's name **MAGISTRELLI DANIELE** (Cuggiono - il 10/05/1986) Clock No. - Stamp No. **SD**

Welding process(es) used **GMAW (Gas Metal Arc Welding)** Type **Semi-Automatic**

Identification of WPS followed by welder during welding of test coupon **01-2019** Rev. **00** Date **09/01/2020**

Base material(s) welded **EN 10025-2 S235 JR** Thickness mm: **10,00 mm** Diameter: **Plate**

Filler metal specification (SFA) Class ( QW-404) **SFA 5.18 AWS ER 70S-6**

**MANUAL OR SEMIAUTOMATIC FOR EACH PROCESS (QW-350 and QW-380)**

	Actual Values	Range Qualified
	Backing (metal,weld metal,welded from both sides,flux etc.) (QW-402) Material : ASME P.No. to P.No. (QW-403) (x) Plate ( ) Pipe - thk.: 10,00 mm - Dia.: --- mm	yes P 1 G 1 to P 1 G 1 Plate
Filler metal specification (F.No) <u>6</u> (QW-404)	6	6
Consumable insert for GTAW or PAW	None	None
Filler metal variety	Solid	solid & metalcored
Weld deposit thickness for each welding process	10,0 mm	≤ 20,0 mm
T Limit short Circuit Arc (QW-404)	Short Arc Not Used	Not Applicable
Welding position (QW-405)	1G	F - Flat
Progression (uphill/downhill)	Not Applicable	Not Applicable
Backing gas for GTAW,PAW or GMAW; fuel gas for OFW (QW-408)	without	with or without
GMAW transfer mode (QW-409)	Pulsed Spray Arc	Pulsed Spray and globular arc
GTAW welding current type/polarity (QW-409)	Not Applicable	Not Applicable
GTAW with or without filler metal (QW-404.14)	Not Applicable	Not Applicable

**MACHINE WELDING VARIABLES FOR THE PROCESS USED (QW-360 and QW-380)**

	Actual Values	Range Qualified
Direct/remote visual control	-	-
Automatic voltage control (GTAW)	-	-
Automatic joint tracking	-	-
Welding position	-	-
Consumable insert	-	-
Single or multiple passes for side/ Backing	-	-

**GUIDED BEND TEST RESULT**

Guide Bend Test Type ( )QW-462.2 (Side) Result ( )QW-462.3(a)(Trans.R&F)Type ( )QW-462.3(b)(Long.R&F)Result

YES - Satisfactory -

Visual examination result (QW-302.4) Satisfactory - Test Report Quality Control n° 19/2439RP01 sheet 2 of 8

Radiographic test result (QW-304 and QW-305) Satisfactory - Test Report Quality Control n° 19/2439RP01 sheet 4 of 8  
 (For alternative qualification of groove welds by radiography)

Fillet weld-Fracture test - Lenght and percent of defects - mm

Macro test fusion - fillet leg test - mm. X - mm. Concavity/convexity - mm.

Welding test conducted by C.G.N. & TUV Austria Services GMBH

Tests conducted by Quality Control -TUV Austria Services GMBH Laboratory test No. 19/2439RP01

We certify that 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 Code.

Organization

Witnessed by  Reviewed

Date 09 / 01 /2020

By **L. Crotti** 09.01.2020


