



Welder/Welding Operator Performance Qualification (WPQ)
W-YY-25-XXXX

Welder's name : _____ I.D. no. _____ Stamp no. _____
 Welding process(es) used: **GMAW** Type **PARTLY MECHANISED** Date Welded **2025-06-16**
 Identification of WPS followed by welder during welding of test coupon **135BW_12** WPQ No. **WP-03-25-0066**
 Base material(s) welded: **EN 10025-2:S355J2+N/EN 10025-2:S355J2+N** Thickness **12.0 mm**

Manual Variables (QW-350)	Actual Values	Range Qualified
Type of weld joint	Plate	Plate and Pipe
P-No. to P-No. (QW-403)	P-No 1 Group 2 to P-No. 1 Group 2	P-No. 1 through P-No.15F P-No. 34 and P-No. 41 through P-No. 49
Pipe diameter - groove (mm)	N/A	≥ 73 mm (F); over 610 mm/plate
Backing ** (QW-402)	No backing used	With or without backing
Filler metal specification.(SFA)	A5.18	All A 5.18
AWS classification (info.)	ER 70S-6	
Filler metal F-Number	6	All F-No. 6
Consumable insert	N/A	N/A
Thickness of Test	12.0 mm	≤ 24.0 mm
Welding position (QW-405)	1G	F
Weld progression	N/A	N/A
Backing gas (QW-408)	Without	With and Without
GMAW transfer mode (QW-409)	Short/Spray	Short/Spray, globular, pulsed-spray
GTAW welding current/polarity	N/A	N/A
SMAW welding current/polarity	N/A	N/A
Machine Variables (QW-360)	Actual Variables	Range Qualified
Direct / remote visual control	N/A	N/A
Automatic voltage control	N/A	N/A
Automatic joint tracking	N/A	N/A
Welding position	N/A	N/A
Consumable insert	N/A	N/A
Backing **	N/A	N/A
Single/multiple pass per side	Multiple	Single/Multiple

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Notes:
 Fillet Welds: All base material thicknesses, fillet sizes and diameters
 **Welds with backing include fillets and double-welded joints.
 The root pass, when removed to sound weld metal in preparation for welding the second side and the cover or wash pass may be up or down (QW405.3)

Guided Bend Test Results			
Figure Number and Type	Result	Figure Number and Type	Result
1 - FACE	No Defect Found	3 - ROOT	No Defect Found
2 - FACE	No Defect Found	4 - ROOT	No Defect Found
None	None	None	None

Visual examination results (QW-302.4) and QW-194) **Acceptable – Report No. 1282GA RT/25**
 Radiographic test results (QW-304 and QW 305)

Fillet Weld - Fracture test **N/A** Length and percent of defects _____
 Macro test fusion _____ Fillet leg size _____ Concavity / convexity _____

Welding test conducted by **Mr. Luca Cappelli – ITEC SRL**
 Mechanical tests conducted by **ITEC SRL – Montemurlo - Italy** Laboratory test no. _____

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 Code.
 Organization:

COVEN SRL

Mr. Name



Name / For the manufacturer

Name / Signature Inspector *
The Authorized Expert of ITEC SRL

Name / Signature Supervisor *
Notified Body ITEC SRL

Inspection within production test reviewed point on behalf Certification ITEC SRL Body for acc. Article 12 of the PED 2014/68/UE, of the ITEC SRL e. V Ident No. 2761	Date Welded		
	Validity Of The Qualification		
	Issued	PRATO - Italy	on