



Italia

CERTIFICATO DI QUALIFICA PROCEDIMENTO DI SALDATURA
 WELDING PROCEDURE RECORD TEST CERTIFICATE / ZERTIFIKAT ANERKENNUNG VON SCHWEISSVERFAHREN

WPQR

PROSAL-3048-2026

00077

Costruttore / Indirizzo: Officine Ceglia srl, Via Caboto 6/8, 42046, Reggiolo (RE)
 Manufacturer / Address - Hersteller / Anschrift:
Codice/norma: EN ISO 15614.1:2019 liv. 2
 Code/Testing Standard - Vorschrift/Prüfnorm:

Riferimento int. No.: 722414002
 Internal No / Interne No:
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pWPS del Costruttore: WPS 08R-2025 rev.0
 Manufacturer's pWPS:
 Hersteller Schweißanweisung:

PROCEDIMENTI DI SALDATURA:				
Welding Process(es) and Type(s) - Schweißprozeß(e) und Art:				
8.4.1 8.5.2.2	Procedimento / Tipo: Process - Schweißverfahren / Type - Sort:	135 <input type="checkbox"/> Manual <input type="checkbox"/> Partly Mechanized <input type="checkbox"/> Mechanized <input checked="" type="checkbox"/> Automatic	<input type="checkbox"/> Manual <input type="checkbox"/> Partly Mechanized <input type="checkbox"/> Mechanized <input type="checkbox"/> Automatic	<input type="checkbox"/> Manual <input type="checkbox"/> Partly Mechanized <input type="checkbox"/> Mechanized <input type="checkbox"/> Automatic EN ISO 4063
8.4.2	Posizione di saldatura: Welding position - Schweißposition: Campo di validità: Validity range - Gültigkeitsbereich:	PA PA		EN ISO 6947
8.4.3	Tipo di giunto: Type of Joint - Stoßart und Schweißart: Dettagli di saldatura: Weld details - Schweißen angeben: Campo di validità: Validity range - Gültigkeitsbereich:	<input checked="" type="checkbox"/> BW <input type="checkbox"/> FW <input type="checkbox"/> TBW <input type="checkbox"/> Branch connection with angle $\geq 60^\circ$ ss mb ss mb, bs	 --- ---	 I clause for sl/ml
METALLO BASE:				
Parent Metal - Grundwerkstoffes:				
8.3.1.1	Designazione: Classification - Klassifikation: UNS number - Werkstoff number: UNS number - Werkstoff number:	EN 10149-2 (Plate) S700MC 1.8974	EN 10149-2 (Plate) S700MC 1.8974	
8.3 Table 5	Sottogruppo: Subgroup - Untergruppe: Campo di validità: Validity range - Gültigkeitsbereich:	2.2 1-1, 2-1, 2-2, qualifies same sub-group and any lower sub-group within the same group	2.2	ISO / TR 15608
8.3.2.1 8.3.2.2 Table 7 Table 8 Table 9	Diametro esterno: Outside diameter - Rohraussendurchmesser: Campo di validità: Validity range - Gültigkeitsbereich: Spessore: Thickness - Dicke: Campo di validità: Validity range - Gültigkeitsbereich:	-- Diameter > 500 12 3 ÷ 24	-- Diameter > 500 12 3 ÷ 24	mm
METALLO D'APPORTO:				
Filler Metal - Zusatzwerkstoffes:				
8.4.4	Designazione: Classification - Klassifikation: Produttore: Manufacturer - Hersteller: Nome commerciale: Trade name - Handelsname:	EN ISO 16834-A G69 5 M21 Mn3Ni1CrMo --- --- ---	--- --- ---	
VdTUV Kennblattliste	Numero Kennblatt: Kennblatt number - Kennblatt nummer:	---	---	Only for AD2000 use
8.3.2.2 BW-TBW-BC Table 7	Spessore materiale depositato: Thickness filler metal - Schweißwerkstoff Dicke: Campo di validità: Validity range - Gültigkeitsbereich:	12 ≤ 24	--- ---	mm
8.3.2.2 FW "sl" Table 8	Altezza di gola: Throat Thickness - Kehlnahtdicke: Campo di validità: Validity range - Gültigkeitsbereich:	12 no restriction		

Luogo Location Ort	Data di Emissione Date of Issue Datum der Ausstellung	Ispettore Inspector's Name and Signature Name und Unterschrift des Inspektors	RT/Vice RT Name and Signature of technical manager/vice technical manager Name und Unterschrift des technischen Leiters/stellvertretenden technischen Leiters	Rappresentante del costruttore Name and Signature of Manufacturer's Representative Name und Unterschrift des Uterschrift
Milano	22/04/2026	E. MONEGO 	T. DA LIO 	



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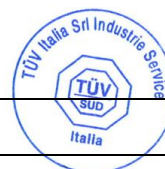
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TIPO DI PROTEZIONE:		EN ISO 14175		---	---
Type of protection - Zündschutzart:					
8.5.1 12x	Designazione: Designation / Bezeichnung:	M21	---	---	
	Produttore: Manufacturer - Hersteller:	---	---	---	
	Nome commerciale: Trade name - Handelsname:	---	---	---	
	Numero Kennblatt: Kennblatt number - Kennblatt nummer:	---	---	---	Only for AD2000 use
VdTUV Kennblattliste					
8.5.2.1 13x 8.5.3.1 14x	Dritto: Straight - Gerade:	Ar + CO ₂	---	---	%
	Portata: Flow rate - Fließrate:	15 - 18	---	---	lt/min
8.5.4 15x	Plasma: Plasma:	---	---	---	%
	Portata: Flow rate - Fließrate:	---	---	---	lt/min
13x 8.5.6 14x 15x	Rovescio: Backing - Unterstützung:	---	---	---	%
	Portata: Flow rate - Fließrate:	---	---	---	lt/min
8.4.10	Deidrogenazione: Post-Heating - Post-Heizung:		---		
8.4.11	Trattamento termico dopo saldatura: Post-Weld Heat Treatment: Wärmenachbehandlung:	Gradiente di riscaldamento: Heating Rate - Aufheizrate:	---		°C/h
		Tempo di mantenimento: Holding Time - Haltedauer:	---		min
		Temperatura di mantenimento: Hold Temperature - Haltetemperatur:	---		°C
		Gradiente di raffreddamento: Cooling Rate - Abkühlrate:	---		°C/h
	Temperatura minima di lavoro: Minimum allowable temperature: Betriebstemperatur jedoch nicht tiefer als:	[if required - see value impact test]			°C

VARIABILI NON ESSENZIALI - NOT ESSENTIAL VARIABLES - NICHT WESENTLICHE VARIABLEN

Elettrodo di Tungsteno: Tungsten Electrode:	---	---	---	EN ISO 6848
Dimensioni: Size - Durchmesser:	---	---	---	mm
Nome del Saldatore: Welder's Name - Name des Schweißers:	Vincenzo Ceglia	---	---	
Punzone: Stamp - Stempeln:	VC	---	---	
Saldatrice: Welding equipment - Schweißgeräte:	FRONIUS	intelligent revolution TPS 500i	---	
	ABB	irc5 Single n. 2600-122539	---	
Materiale d'apporto Ø: Filler Metal - Zusatzmetall Ø:	---	---	---	mm
Altre Informazioni: Other information - Weitere Informationen:	Sample 09001		---	



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Milano	22/04/2026	E. MONEGO



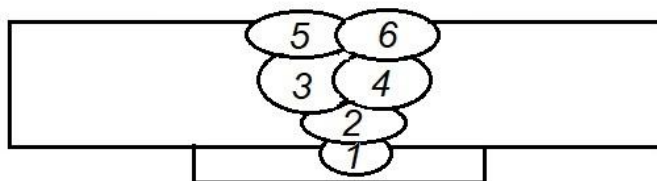
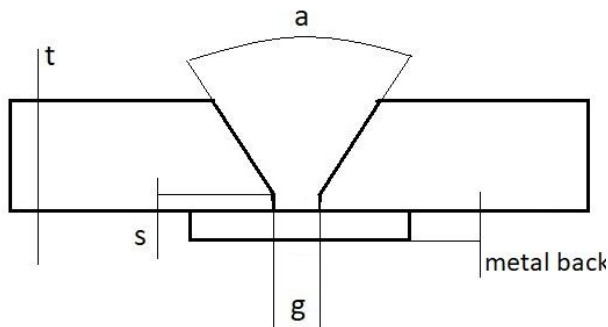
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Disegno Giunto / Joint Design / Gestaltung | **Sequenza Saldatura / Welding Sequence / Schweißfolge**



t= 12mm; a=70°; s=1mm; g=3mm

Passata Layer Lage	Proced. Process Prozeß	Materiale d'apporto Filler Metal Zusatzmetall	Passata / Arco / Polarità Layer / Arc / Current Kabeltyp / Lichtbogen / Stromart	Prerisc Preheat Vorheiz. [°C min]	Interp. Interp. Zwische. [°C max]	Volts [V]	Ampere [A]	Avanzam. Travel speed Reisegeschw. [mm/min]	A.T.S. Heat Input Wärmeeinbring. [kJ/mm] 8.4.7 [%]
1	135	G 69 5 M21Mn3Ni1CrMo	String Spray DC-EP	≥15° C	---	26	240	360	0,83
2+N	135	G 69 5 M21Mn3Ni1CrMo	Weave Spray DC-EP	---	≤ 150°C	27	290	540	0,70
									± 25

CONTROLLI NON DISTRUTTIVI – NON DESTRUCTIVE TESTS – NICHT ZERSTÖRENDE PRÜFUNGEN

	Effettuato ed accettabile Performed and acceptable – Ausgeführt und bestanden
Visivo – Visual test – Sichtprüfung	SU26090C014001VTREVO
Liquidi penetranti – Penetrant test – Kerbzugprüfung	SU26090C014001PTREVO
Magnetoscopia – Magnetoscopic test – Magnetoskopischer test	---
Radiografia – Radiographic test – Radiographische untersuchung	---
Ultrasuoni – Ultrasonic test – Ultraschallprüfung	SU26090C014001UTREVO
---	---

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ANALISI CHIMICA – CHEMICAL ANALYSIS – CHEMISCHE ANALYSE

C	Mn	Si	Cr	Ni	Mo	Cu	V	Co	---	---	---	---	---	---	---	%
---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---

FERRITE CONTENUTA (FN) – FERRITE CONTENT – FERRIT-INHAL

Richiesta: Requirement – Anforderung:	---	%
Rilevata: Investigate – Untersuchen:	---	%

PROVA DI TRAZIONE – TENSILE TESTS – ZUGPRÜFUNG

Temperatura – Temperature – Temperatur: **20 °C**

N. No. Nr.	Posizione Location Lage	Dimensioni Dimensions Abmessungen [mm x mm]	Re [MPa]	Rp 0,2/1,0 [MPa]	Rm [MPa]	A [%]	Z [%]	Osservazioni Remarks Bemerkungen
1	TW	25 X 12,3	---	---	855,7	---	---	BM
2	TW	25 X 11,9	---	---	836,2	---	---	BM
---	---	---	---	---	---	---	---	---
---	---	---	---	---	---	---	---	---

TW: Trasversale – Transversal.
 LW: Longitudinale – Longitudinal – in Längsrichtung.

SU26090C014001TTREVO

PROVA DI PIEGA – BEND TEST – BIEGEPRÜFUNG

Temperatura – Temperature – Temperatur: **20 °C**

N. No. Nr.	Posizione Location Lage	Dimensioni Dimensions Abmessungen [mm x mm]	Mandrino Spindle Spindel [mm]	Distanza rulli Distances rollers Abstandsrollen [mm]	Angolo Angle Winkel [°]	Esito Results Ergebnisse	Osservazioni Remarks Bemerkungen
SSB1 09001	SBB	10X12	40	70	180°	Satisfactory	---
SSB2 09001	SBB	10X12	40	70	180°	Satisfactory	---
SSB3 09001	SBB	10X12	40	70	180°	Satisfactory	---
SSB4 09001	SBB	10X12	40	70	180°	Satisfactory	---

SBB: Trasversali laterali – Transversal side – Transversal seite.
 TFB: Trasversali al dritto – Transversal face – Transversal gesicht.
 TRBB: Trasversali al rovescio – Transversal root – Transversaler Wurzelbiegetest.

SU26090C014001PIREVO

PROVA DI RESILIENZA – IMPACT TEST – AUFPRALLPRÜFUNG

Energia – Energy – Energie: **450 Joule**

N. No. Nr.	Posizione Location Lage	Dimensioni Dimensions Abmessungen [mm x mm]	Intaglio Notch Kerb	Temperatura Temperature Temperatur [°C]	Valore Value Wert [J]	Shear [%]	Exp lat Exp lat Sei Aus [mm]	Valore Value Wert [J]	Shear [%]	Exp lat Exp lat Sei Aus [mm]	Valore Value Wert [J]	Shear [%]	Exp lat Exp lat Sei Aus [mm]	Media Average Durch.
1	VWT	10X10	V	-40°	76	---	---	70	---	---	82	---	---	76
2	VHT	10X10	V	-40°	78	---	---	84	---	---	86	---	---	83
---	---	---	---	---	---	---	---	---	---	---	---	---	---	---

VWT: Trasversali center line – Transversal in center line – Transversal in der Mittellinie.
 VHT: Trasversali ZTA – Transversal in HAZ – Transversal in der WEZ.
 FLT: Trasversali fusion line – Transversal fusion line – Transversaler Transversal in der Fusionslinie.
 T: Trasversale materiale base – Transversal base metal – Querbasismetall.
 L: Longitudinale materiale base – Longitudinal base metal – Längslage im Grundwerkstoff.

SU26090C014001ITREVO

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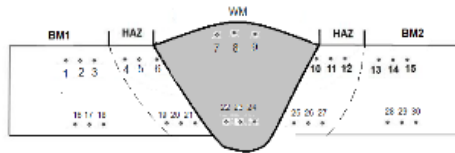
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PROVA DI DUREZZA – HARDNESS TEST – HÄRTEPRÜFUNG

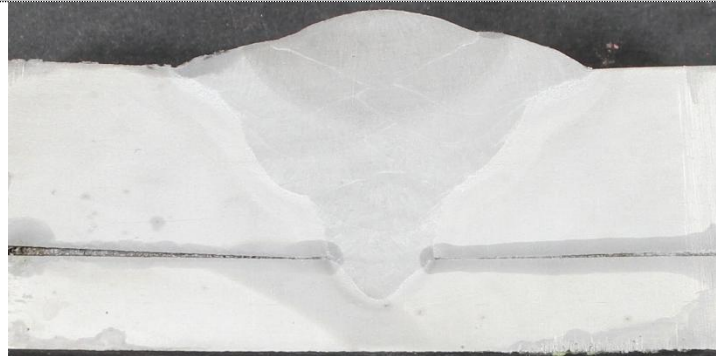
Tipo – Type – Art: **HV₁₀**
 Requisiti – Requirements – Anforderungen: **≤ 380**

Materiale Base Base Metal / Grundwerkstoff			ZTA HAZ / WEZ				Zona Fusa Weld Metal / Schweißgut			ZTA HAZ / WEZ			Materiale Base Base Metal / Grundwerkstoff					
1	2	3	4	5	6	Indent. Suppl.	Indent. Suppl.	7	8	9	Indent. Suppl.	Indent. Suppl.	10	11	12	13	14	15
253	269	273	254	257	256	---	---	265	260	262	---	---	228	224	227	259	263	255
16	17	18	19	20	21	Indent. Suppl.	Indent. Suppl.	22	23	24	Indent. Suppl.	Indent. Suppl.	25	26	27	28	29	30
268	270	274	267	256	264	---	---	270	262	273	---	---	231	226	230	252	267	249
1	2	3	4	5	6	Indent. Suppl.	Indent. Suppl.	7	8	9	Indent. Suppl.	Indent. Suppl.	10	11	12	13	14	15
---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---

SU26090C014001HTREVO



MACROGRAFIA – MACROGRAPHY – MAKROGRAFIE



MICROGRAFIA – MICROGRAPHY – MICROGRAFIE

Inserire foto micro (se eseguite)

Attacco – Etching – Ätzen: Nital 10%

Ingrandimento – Magnification – Vergrößerung: 3x

Risultato – Result – Resultat: SU26090C014001MAREVO

Attacco – Etching – Ätzen: ---

Ingrandimento – Magnification – Vergrößerung: ---

Risultato – Result – Resultat: ---

Tutte le verifiche preliminari prescritte al Cap. 8.2 della procedura PSAL_01 in rev. corrente sono state eseguite dall'esaminatore:

All preliminary checks have been performed by the examiner in accordance with the Ch. 8.2 of the procedure PSAL_01 in current rev.:
 Alle vorläufigen Tests wurden vom Prüfer entsprechend Kap. 8.2 Prüfanweisung PSAL_01 bei der gegenwärtigen Revision durchgeführt:

Luogo / Data della saldatura:

Reggiolo (RE), 18/03/2026

Location / Date of Welding – Ort / Datum derSchweißung:R

Il tallone è stato saldato in presenza di:

IWS Enrico Monego

Test piece was welded in the presence of – Prüfstück wurde geschweißt in Anwesenheit von:

Le prove sono state eseguite in conformità alle norme:

see page 1/5

The tests have been performed in accordance with the specifications – Die Prüfungen wurden entsprechend den Prüfgrundlagen durchgeführt:

Si certifica che i saggi di prova sono stati preparati, saldati e controllati con esito soddisfacente in conformità ai requisiti del codice/norma di prova sopra indicato.

We certify that the statements in this record are correct and that the test welds were prepared, welded and tested in accordance with the requirements of the code/standard above mentioned.

Hiermit wird bestätigt, daß die Prüfungsschweißungen in Übereinstimmung mit den Anforderungen der vorbezeichneten Vorschriften bzw. Prüfnormen zufriedenstellend vorbereitet, geschweißt und geprüft wurden.

Allegati - Annex - Anlage

WPS n°: 08R-2025 REV 0

Mill certificate n°: SSAB NR.75867K-001 del 17/04/2024

Filler Metal Certificate n°: SIAT nr.1462/2025/A del 14/03/2025

Note:

1 Qualifica valida ai sensi della direttiva PED, Allegato 1, punto 3.1.2 – TÜV Italia Srl – Organismo Notificato 0948 / Welding procedure in according to PED, Annex 1, point 3.1.2 – TÜV Italia Srl – Notified Body 0948

2 - Il presente documento è conforme anche ai requisiti previsti dalla EN ISO 15614-1:2019 liv. 1 / This document also complies with the requirements of EN ISO 15614-1: 2019 liv. 1

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