

BUREAU VERITAS
Certification



Certificato di Conformità

Rilasciato a

C.M.I. DI BIANCHI SRL

SEDE LEGALE E OPERATIVA:
Via G. Marconi, 10/B
24040 FORNOVO SAN GIOVANNI (BG)

Bureau Veritas Italia S.p.A. certifica che il Sistema di Gestione di questa organizzazione è stato valutato e giudicato conforme ai requisiti della norma

ISO 9001:2008

in relazione al seguente scopo

Progettazione e costruzione di scambiatori di calore,
apparecchi a pressione, caldareria e carpenteria.

Settore/i EA di attività:	18
Data inizio validità:	26/02/2009
Revisione del:	25/02/2012
Scadenza:	24/02/2015

La validità del presente certificato è subordinata a sorveglianza periodica ed è consultabile sul sito www.bureauveritas.it

Ulteriori chiarimenti riguardanti lo scopo di questo certificato e l'applicabilità del sistema di gestione possono essere acquisiti contattando l'organizzazione.

Certificato N° IT231037



SGQ N° 009A
SGA N° 008D
PRD N° 009B
SCR N° 008F
FSMS N° 003I
PRS N° 076C

Member degli Accordi di Muto Riconoscimento EA e IAF
Signatory of EA and IAF Mutual Recognition Agreements

EUROPEAN WELDING FEDERATION



EOTC AGREEMENT GROUP for Welding, Joining, Cutting and Surfacing



Having met the education and training requirements of
EWF Guideline 'European Welding Specialist' and
by examination having satisfied the requirements of the
Governing Board of the Authorised National Body

is hereby awarded the diploma of

EUROPEAN WELDING SPECIALIST

Date 23/07/2002

Diploma EWS/IT, 50082

Dott. Ing. Angelo M. Giorgetti

Chairman,
Board of Examiners

Dott. Ing. Mauro Scasso

Head,
Training School



EWF Authorized National Body: Istituto Italiano della Saldatura, ITALY

Istituto Italiano della Saldatura, Divisione FOR, Genova - ITALY

Scheme Administration: EOTC AG

Scheme Control: EWF

EWF PARTICIPATING COUNTRIES

Austria • Belgium • Bulgaria • Croatia • Denmark • Finland • France • Germany • Hungary • Iceland • Ireland • Italy • Luxemburg • Netherlands • Norway
Poland • Portugal • Romania • Slovakia • Slovenia • Spain • Sweden • Switzerland • United Kingdom



INTERNATIONAL INSTITUTE OF WELDING

Having met the Education and Training requirements of IIW Guideline 'International Welding Specialist' and by examination having satisfied the requirements of the Examination Board of the IIW Authorised National Body

is hereby awarded the diploma of


INTERNATIONAL WELDING SPECIALIST

Date 31/03/2004


Diploma IWS/IT

50082

Prof. Ing. Alfredo Squarzoni


Chairman,
Governing Board

Dott. Ing. Luca Timossi


Chief Executive



IIW Authorized National Body: Istituto Italiano della Saldatura, ITALIA





QUALIFICATION CERTIFICATE FOR NON DESTRUCTIVE TESTING

Giuseppe Rivaroli

LEVEL III - N.D.T. - Q.A. CONSULTANT

This is to certify that:

MR. BIANCHI WALTER

of:

C.M.I. di Bianchi S.r.l. - FORNOVO SAN GIOVANNI (BG)

has been examined and qualified as N.D.T. LEVEL II in accordance with the REQUIREMENTS OF PERSONNEL QUALIFICATION PROCEDURE N° "POWP Rev. 0" AND THE AMERICAN SOCIETY FOR NON DESTRUCTIVE TESTING SNT-TC -1A THE LATEST CODE ACCEPTED EDITION.

This certificate expires as indicated or upon termination of employment

RIVAROLI GIUSEPPE
MEC. ENG. LEVEL III BY EXAM
ASNT CERT. N. 27936
UNI EN 473 - CERT. N. 394

**EXAMINER - NDT
LEVEL III**

C.M.I. di BIANCHI SRL

Via G. Marconi, 10/B

24040 FORNOVO S.G. (BG)

Tel. 0363-351176 - Fax 0363-353351

GENERAL - MANAGER

N.D.T. 1585/RG-11

**CERTIFICATE
NUMBER**

Endorsements - The Holder of this Certificate has been Certified as N.D.T. Level II in the General - Specific and Practical Requirements for the N.D.T. Methods specified below:

VT METHOD	PT METHOD	MT METHOD	RT METHOD	UT METHOD
QUAL. DATE //	QUAL. DATE //	QUAL. DATE //	QUAL. DATE //	QUAL. DATE <u>24.02.2011</u>
EXP. DATE //	EXP. DATE //	EXP. DATE //	EXP. DATE //	EXP. DATE <u>24.02.2016</u>



QUALIFICATION CERTIFICATE FOR NON DESTRUCTIVE TESTING

Giuseppe Rivaroli

LEVEL III - N.D.T. - Q.A. CONSULTANT

This is to certify that:

.....

of:

.....
C.M.I. S.r.l. - Forno San Giovanni (BG)

has been re-examined and re-qualified as N.D.T. LEVEL II in accordance with the REQUIREMENTS OF PERSONNEL QUALIFICATION PROCEDURE
N° "POWP Rev 0" AND THE AMERICAN SOCIETY FOR NON DESTRUCTIVE TESTING SNT-TC -1A THE LATEST CODE ACCEPTED EDITION.

This certificate expires as indicated or upon termination of employment

RIVAROLI GIUSEPPE
MEC. ENG LEVEL III BY EXAM
ASNT CERT. N. 27936
UNI EN 473 - CERT. N. 177 N/PND/C

.....
**EXAMINER - NDT
LEVEL III**

C.M.I. di BIANCHI SRL
Via G. Marconi, 10/B
24040 FORNOV. S.G. (BG)
Tel. 0363-351176 - Fax 0363-353351

.....
GENERAL - MANAGER

.....
N.D.T. 1793/RG-12

.....
**CERTIFICATE
NUMBER**

Endorsments - The Holder of this Certificate has been Certified as N.D.T. Level II in the General - Specific and Practical Requirements for the N.D.T. Methods specified below:

VT METHOD	PT METHOD	MT METHOD	RT METHOD	UT METHOD
QUAL. DATE	QUAL. DATE <u>24.10.2012</u>	QUAL. DATE <u>24.10.2012</u>	QUAL. DATE	QUAL. DATE
EXP. DATE	EXP. DATE <u>24.10.2017</u>	EXP. DATE <u>24.10.2017</u>	EXP. DATE	EXP. DATE



QUALIFICATION CERTIFICATE FOR NON DESTRUCTIVE TESTING

Giuseppe Rivaroli

LEVEL III - N.D.T. - Q.A. CONSULTANT

This is to certify that:

of: C.M.I. S.r.l. - Forno San Giovanni (BG)

has been re-examined and re-qualified as N.D.T. LEVEL II in accordance with the REQUIREMENTS OF PERSONNEL QUALIFICATION PROCEDURE

N° "POWP Rev 0" AND THE AMERICAN SOCIETY FOR NON DESTRUCTIVE TESTING SNT-TC -1A THE LATEST CODE ACCEPTED EDITION.

This certificate expires as indicated or upon termination of employment

RIVAROLI GIUSEPPE
MEC. ENG LEVEL III BY EXAM
ASNT CERT. N. 27936
UNI EN 473 - CERT. N. 17115/PND/C

EXAMINER - NDT
LEVEL III

C.M.I. di BIANCHI SRL
Via G. Marconi, 19/B
24040 FORNOVO S.G. (BG)
Tel. 0363-351176 - Fax 0363-353361

GENERAL - MANAGER

N.D.T. 1759/RG-12

CERTIFICATE
NUMBER

Endorsments - The Holder of this Certificate has been Certified as N.D.T. Level II in the General - Specific and Practical Requirements for the N.D.T. Methods specified below:

VT METHOD	PT METHOD	MT METHOD	RT METHOD	UT METHOD
QUAL. DATE <u>23.05.2012</u>	QUAL. DATE //	QUAL. DATE //	QUAL. DATE //	QUAL. DATE //
EXP. DATE <u>23.05.2017</u>	EXP. DATE //	EXP. DATE //	EXP. DATE //	EXP. DATE //

Certificato

Certificate

01 202 I/Z-10 4133/01

di idoneità di personale addetto alle prove non distruttive
of eligibility of NDT personnel

in conformità alle norme UNI EN 473, ISO 9712
ed ai sensi della Direttiva PED 97/23/CE
This certificate is issued according to UNI EN 473, ISO 9712 and PED 97/23/EC

Sig.	Titolo/ <i>Titel</i>	Cognome/ <i>Last name</i>	Nome/ <i>First Name</i>	Bergamo (BG)	1973-12-18
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Metodo <i>Method</i>	Livello <i>Level</i>	Valido fino <i>Expiring date</i>	Settore industriale & di prodotto <i>Industrial & product sector</i>	Metodo <i>Method</i>	Livello <i>Level</i>	Valido fino <i>Expiring date</i>	Settore industriale & di prodotto <i>Industrial & product sector</i>
RT	2	06/2015	A, PED; c, t, f, w, wp	RT*	---	---	---
UT	2	02/2016	A, PED; c, t, f, w, wp	UT*	---	---	---
PT	2	10/2014	A, PED; c, t, f, w, wp	VT	2	05/2014	A, PED; c, t, f, w, wp
MT	2	12/2014	A, PED; c, t, f, w, wp	---	---	---	---

- A:** Fabbricazione di metalli / *Metal production and manufacturing*
B: Prova pre-servizio e in servizio di attrezzature, impianti e strutture / *Service of preliminary & operation testing of equipment, systems & buildings*
C: Manutenzione ferroviaria / *Railway maintenance*
D: Aerospaziale / *Air and space travel*
PED: Direttiva sulle attrezzature a pressione 97/23/CE / *Pressure Equipment Directive 97/23/EC*
(c) Getti / *Castings* **(f)** Fucinati / *Forged pieces* **(w)** Prodotti saldati / *Welded products* **(wp)** Prodotti lavorati / *Rolled products*
(t) Tubi e condotte, inclusi i prodotti piatti per la fabbricazione di tubi saldati / *Pipes including flat products from which welded pipes are manufactured*
- RT:** Radiografia / *Radiographic testing*
RT*: Limitazione interpretazione lastre radiografiche / *Limited to radiographic film evaluation*
VT: Metodo visivo / *Visual inspections*
UT: Ultrasuoni / *Ultrasonic testing*
UT*: Controllo spessimetrico / *Thickness measuring*
MT: Particelle magnetiche / *Magnetic particle testing*
PT: Liquidi penetranti / *Liquid penetrant testing*
ET: Correnti indotte / *Eddy current testing*
LT: Rivelazione di fughe / *Leak testing*

TÜV Rheinland Certification Body for NDT Personnel of
TÜV Rheinland Industrie Service GmbH
Am Grauen Stein D - 51105 Cologne
Contact in Italy: +39.035 49 33 147


Dott. Ing. Guido Maines
Mijan, 2011.07.05

Entità terza riconosciuta ai sensi dell'Art. 13 della direttiva 97/23/CE, numero di Notifica 0035
Organismo di certificazione per personale PND accreditato secondo EN ISO/IEC 17024:2004, da EA Membro BMWi (ZLS-ZP-040/05)
*Recognized independent testing office according to Article 13 of the Pressure Equipment Directive 97 / 23 / EC, Id. No. 0035
Accredited Certification Body for NDT-Personnel according to EN ISO/IEC 17024, by EA Member BMWi (Reg. No. ZLS-ZP-040 /05)*

WELDER NAME BIANCHI OMAR **Identificazione No.** //// **STAMP No.** BO

Test Description

Identification of pWPS followed by welder during welding of test coupon: pWPS N°119 Test coupon Production Weld
 Welding process (es) used a) GTAW - b) SMAW - c) SAW Type a) MANUAL - b) MANUAL - c) MACHINE
 Specification of base metal (s): ASTM / ASME A (SA) - 387 Gr.5 CL2 Thickness 13,00 mm.

Testing condition and Qualification Limits

QW-350	Welding Variables for Welders	Actual values	Range Qualified
QW-402.4	Backing (metal, weld metal, welded from both sides, etc.)	WITHOUT	WITH OR WITHOUT
QW-403.16	<input checked="" type="checkbox"/> Plate <input type="checkbox"/> Pipe (enter diameter, if pipe)	13 mm.	PIPES $\phi > " 73$ mm. " and PLATES
QW-403.18	Base Metal ASME P or S - N° / Gr.N° 5B / 1 to ASME P or S - N° / Gr.N° 5B / 1		P-N° 1 trough P-N° 11; P-N° 34; P-N° 41 trough P-N° 47; THE CORRESPONDING S - N°. AND UNASSIGNED METALS OF SIMILAR CHEMICAL COMPOSITION TO THESE METALS .
	Welding Process (es)	<u>a) GTAW</u> <u>b) SMAW</u>	
QW-404.14	With or Without Filler Metal	WITH <u>////</u>	a) WITH
QW-404.15	Filler metal F - N°.	6 4	a) All F-N°6; b) F-N° 4 and Lower
QW-404.18	Filler metal or electrode specification (s) (SFA)	SFA 5.28 - '96 SFA 5.5 -'96	////
QW-404.18	Filler metal or electrode classification (s)	ER 80S - B6 E 8015-B6L	////
QW-404.22	Consumable insert for GTAW or PAW	N.A. N.A.	////
QW-404.23	Filler Type (solid / metal or flux cored / power) (GTAW or PAW)	Solid rod Stick	a) Solid rod; b) Stick
QW-404.30	Deposit tickness for each process		
	Process 1: GTAW 3 layers minimum <input type="checkbox"/> Yes <input checked="" type="checkbox"/> No	2,5 mm. <u>////</u>	Groove: up to 5,0 mm.; Fillet: All Groove: up to 16,0 mm.; Fillet: All
	Process 2: SMAW 3 layers minimum <input checked="" type="checkbox"/> Yes <input type="checkbox"/> No	<u>////</u> 8 mm.	
QW-404.32	t Limit Short Circuit Arc	N.A. <u>////</u>	////
QW-405.1	Qualified Welding position (1G, 5G, etc.)	1 G	GROOVE: F - FILLET: F
QW-405.3	Vertical welding	N.A.	N.A.
QW-408.8	Inert gas backing (GTAW, PAW, GMAW)	WITH <u>////</u>	a) WITH
		<u>////</u> WITH	b) on root when performing SMAW
QW-409.4	GTAW current type / polarity (AC; DCEP; DCEN)	DCEN <u>////</u>	a) DCEN
QW-409.2	Transfer mode (spray/globular or pulse to short circuit - GMAW)	N.A. <u>////</u>	a) N.A.

Bend Tests	Results	Results	Results	
QW-302.4	Visual examination of completed weld	<input checked="" type="checkbox"/> OK	QW-462.5 (c) Pipe bend speciment, corrosion - resistant overly	<input type="checkbox"/> NO
QW-462.2	Side	<input checked="" type="checkbox"/> OK	QW-462.5 (d) Plate bend speciment, corrosion - resistant overly	<input type="checkbox"/> NO
QW-462.3 (a)	Transverse Root and Face	<input type="checkbox"/> //	QW-462.5 (b) Macro test for fusion	<input type="checkbox"/> NO
QW-462.3 (b)	Longitudinal Root and Face	<input type="checkbox"/> //	QW-462.5 (e) Macro test for fusion	<input type="checkbox"/> NO
QW-191	Alternative radiographic examination Results	<input type="checkbox"/> //	QW-304 and QW-305 Radiografic test results	<input checked="" type="checkbox"/> OK

QW-180 Fillet weld - fracture test: NONE Length and percent of defects NO DEFECT
QW-184 Macro Examination: Report N° 5269/08 Sheet 2 di 2 Fillet leg size mm. X mm. Convexity or concavity
 Other Test: Micro Examination: Report N° ////
 Chemical Analysis: Report N° ////
 Film or Specimens evaluated by: IRTEC s.r.l. Company: IRTEC s.r.l. Report N° 5226/08
 Mechanical test Test conducted by: IRTEC s.r.l. Laboratory-test No. 5269/08 sheet 1/2 di 3 - PWHT N° 5264/08
 Welding Supervised by: G.LUZI -- B.V.

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 Section IX of the ASME Code BPV **MANUFACTURER** **INSPECTING AUTHORITY**
BUREAU VERITAS 1370

Date 01/07/2008

C.M.I.
 di Bianchi & Ripamonti S.n.c.





**BUREAU
VERITAS**



QUALIFICA PROCEDIMENTO SALDATURA WELDING PROCEDURE QUALIFICATION RECORD

In accordo alla norma EN ISO 15614-1:2004

According to EN ISO 15614-1:2004

Presso il costruttore / delivered to the manufacturer : **C.M.I. di Bianchi**

dopo esecuzione dei talloni di saldatura / after execution of the welded test piece

il (data) / the (date) : **17/06/2008** luogo / location : **FORNOVO S.G. (BG)**

in presenza di / in the presence of : **Mr. G. Luzi - Bureau Veritas - Milan**

Si certifica che la procedura di saldatura, in accordo alla specifica di saldatura (pWPS) allegata dal costruttore, ha dato esito soddisfacente, in accordo con i requisiti della norma EN ISO 15614-1:2004

Which certified that the welding procedure, according to the preliminary welding procedure specification (pWPS) in annex stated by the manufacturer, has given satisfactory results, in accordance with the requirements of the standard EN ISO 15614-1:2004

Verbale emesso il / Record issued the : **01/07/2008**

Con riferimento a / with the reference (WPQR Nr.) : **MIL - 08 - B - 390**

Nome, Data e firma dell'Ispettore autorizzato / Name, date and signature of the authorised examiner :

