

M.T.I.
di Laita A. & C

ELENCO QUALIFICHE PROCEDIMENTO DI SALDATURA

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BASE MATERIAL	PERFORMED BY	PQR N°	RULE	ENTE CERTIFICATORE	WPS N°	PN° -Gr.N°	PROCESS	TYPE	MAX. THK. RANGE	OTHER TYPE QUALIFIED	PWHT	KV	QUAL. SALD
ASTM A 106 B + ASTM A106 B	M.T.I. di LAITA A & C.	QP 01	ASME sect. IXa	LLOYDS REGISTER OF SHIPPING MILANO	SL 01/87	1 - 1 1 - 1	GTAW + SMAW	BW	UP TO 14,22 mm	FILLETT WELD SOCHET WELD BRANCH WELD	N.A.	NO	X
ASTM A312 TP321 + ASTM A312 TP321	M.T.I. di LAITA A & C.	QP 02	ASME sect. IXa	LLOYDS REGISTER OF SHIPPING MILANO	SL 02/87	8 - 1 8 - 1	GTAW + SMAW	BW	UP TO 14,22 mm	FILLETT WELD SOCHET WELD BRANCH WELD	N.A.	NO	X
ASTM A 516 GR 60+ ASTM A 516 GR 70	M.T.I. di LAITA A & C.	1/93	ASME sect. IXa	LLOYDS REGISTER OF SHIPPING MILANO	1/93	1 - 1 TO 1 - 2	FCAW	BW	<= 200 mm	FILLETT WELD SOCHET WELD BRANCH WELD	N.A.	0 ° C.	X
ASTM A 516 GR 60+ ASTM A 516 GR 70	M.T.I. di LAITA A & C.	2/93	ASME sect. IXa	LLOYDS REGISTER OF SHIPPING MILANO	2/93	1 - 1 TO 1 - 2	GTAW+SMAW+SAW	BW	UP TO 203 mm	FILLETT WELD SOCHET WELD BRANCH WELD	N.A.	0 ° C.	X
SA240 TP316L +SA240 TP316L	M.T.I. di LAITA A & C.	QPOG198	ASME sect. IXa	LLOYDS REGISTER OF SHIPPING MILANO	1/98	8 - 1	GTAW+ SMAW+ SAW	BW	UP TO 60 mm	FILLETT WELD SOCHET WELD BRANCH WELD	N.A.		X
ASTM A 106 GR B	M.T.I. di LAITA A & C.	1,02	ASME sect. IXa	LLOYDS REGISTER OF SHIPPING MILANO	1,02	1 - 1	GTAW+ SMAW+SAW	BW	UP TO 42,88 mm	FILLETT WELD SOCHET WELD BRANCH WELD	YES		X
ASTM A 312 TP 316L	M.T.I. di LAITA A & C.	01/03 RES	ASME sect. IXa	LLOYDS REGISTER OF SHIPPING MILANO	01/03	8 - 1 8 - 1	GTAW	BW	UP TO 6,60 mm	FILLETT WELD SOCHET WELD BRANCH WELD	N.A.	- 196 ° C.	X
ASTM A 312 TP 316L	M.T.I. di LAITA A & C.	02/03 RES.	ASME sect. IXa	LLOYDS REGISTER OF SHIPPING MILANO	02/03	8 - 1 8 - 1	GTAW + SMAW	BW	UP TO 12,7 mm	FILLETT WELD SOCHET WELD BRANCH WELD	N.A.	- 196 ° C.	X
ASTM A 312 TP 316L	M.T.I. di LAITA A & C.	03/03 RES	ASME sect. IXa	LLOYDS REGISTER OF SHIPPING MILANO	03/03	8 - 1	GTAW+SMAW +SAW	BW	UP TO 25,4 MM	FILLETT WELD SOCHET WELD BRANCH WELD	N.A.	- 196 ° C.	X
ASME SA350 LF2	M.T.I. di LAITA A & C.	04-03 LF2	ASME SECT IXa	RW TUV Legnano	04-03A	PN°1 Gr 2	GTAW + SMAW	BW	UP TO14,22 mm	FILLETT WELD SOCHET WELD BRANCH WELD	NA	- 46 ° C	X

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ASME SA350 LF2	M.T.I. di LAITA A & C.	05-03 LF2	ASME SECT Ixa	RW TUV Legnano	05-03	PN°1 Gr 2	GTAW +SMAW +SAW	BW	UP TO 70,0 mm	FILLETT WELD SOCHET WELD BRANCH WELD	NA	- 46 °C	x
ASME SA350 LF2	M.T.I. di LAITA A & C.	06-03 LF2	ASME SECT Ixa	RW TUV Legnano	06-03	PN°1 Gr 2	FCAW + SAW	BW	UP TO 70,0 mm	FILLETT WELD SOCHET WELD BRANCH WELD	NA	- 46 °C	x
ASTM A 694 F60 TO ALLOY 625 ROD + CLADDING ER NiCrMo3	M.T.I. di LAITA A & C.	03/2004	ASME SECT. IX°	DNV MILANO	03/2004	S N° 1 Gr,2 to P N° 45	GTAW	SEAL WELD	7 mm MAX		NO	NO	x
ASME SA 350 LF2 TO ASME SA 333 Gr. 6	M.T.I. di LAITA A & C.	01-05	ASME SECT. IX°	TUV	01-05	PN° 1 Gr. 2 TO PN° 1 Gr. 1	GTAW + SMAW	BW	UP TO 10,16 mm	FILLETT WELD SOCHET WELD BRANCH WELD	NO	- 46 °C	x
ASTM A 312 TP 310 MoLN UNS 31050	M.T.I. di LAITA A & C.	01/2006	ASME SECT. IX°	RW TUV	01/06	PN° 8 GR. 2	GTAW + SMAW	BW	UP TO 11,20 mm	FILLETT WELD SOCHET WELD BRANCH WELD	NO	- 196°C.	x
ASTM A 516 GR 70	M.T.I. di LAITA A & C.	02,2006 PWHT	ASME SECT. IX°	Lloyd Register Milano	02,2006 pwht	PN° 1 GR. 2	GTAW + SMAW + FCAW	BW	UP TO 70 mm	FILLETT WELD SOCHET WELD BRANCH WELD	YES	- 46 °C	x
ASME SA 335 Gr. P22 + ASME SA 106 Gr. B	M.T.I. di LAITA A & C.	01-2007	ASME SECT. IX°	TUV Rheinland Italia	01-2007 P22-A106.B	5A Gr 1 TO 1 Gr. 1	GTAW + SMAW + SAW	BW	UP TO 30,18	FILLETT WELD SOCHET WELD BRANCH WELD	YES	0°C	x
LF2+A333GR6°	M.T.I. di LAITA A & C.	02/2007 PWHT	ASME SECT. IX°	VINCOTTE	02/2007 PWHT 12X5,54	1.1 TO 1,2	GTAW + SMAW	BW	UP TO 11,08	FILLETT WELD SOCHET WELD BRANCH WELD	YES	-46°C	x
SA 516 70+ 60	M.T.I. di LAITA A & C.	01.2008	ASME SECT. IX°	Lloyd Register Milano	01.08 60/70	1,1 TO 1,2	GTAW SMAW SAW	BW	200	FILLETT WELD SOCHET WELD BRANCH WELD	NO	-46°C	x
SA 516 70+ 60	M.T.I. di LAITA A & C.	01.2008 PWHT	ASME SECT. IX°	Lloyd Register Milano	01.08 60/70 PWHT	1,1 TO 1,2	GTAW SMAW SAW	BW	200	FILLETT WELD SOCHET WELD BRANCH WELD	YES	-46°C	x

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urea grade	M.T.I. di LAITA A & C.	MIL-09-BI-120	EN 15614-1 /2005	BOUREAU VERITAS	15/06 UG	8,1	141+111	BUTTWELD GROOVE	12.06 mm	FILLETT WELD SOCHET WELD BRANCH WELD	NA		X
API 5L X80 + AISI 8630	M.T.I. di LAITA A & C.	01.012 X80+8630	ASME IX + DNV OS-C401	DNV MILAN	01.012 REV.02	1,4 TO AISI 8630	GTAW SMAW SAW	BUTTWELD GROOVE	50 mm	FILLETT WELD SOCHET WELD BRANCH WELD	YES	-20°C	X
AISI 4130	M.T.I. di LAITA A & C.	01.014-4130	ASME IX	TUV Rheinland	01.014 rev. 02	AISI 4130	SMAW	GROOVE WITH BACKING	UP TO 100	FILLETT WELD SOCHET WELD BRANCH WELD	YES	-46°C	X
API 5L X70M PSL2	M.T.I. di LAITA A & C.	02.014-X70	ASME IX	Lloyd Register Emea Milano	01.014 / SU14-0124	1.3	GTAW SMAW SAW	BUTTWELD GROOVE	UP TO 57,2	FILLETT WELD SOCHET WELD BRANCH WELD	NO	- 50° C	X
API 5L X52 + AISI 4130	M.T.I. di LAITA A & C.	01,015 4130+X52	ASME IX	Lloyd Register Emea Milano	01,015 4130+X52 REV. 01	1,1 TO AISI 4130	GTAW SMAW SAW	BUTTWELD GROOVE	UP TO 69,86	FILLETT WELD SOCHET WELD BRANCH WELD	YES	-46°C	X
ASTM A333 GR. 6°	M.T.I. di LAITA A & C.	001/017	ASME IX	Lloyd Register Emea Milano	001/017/333	1,1	GTAW SMAW	BUTTWELD GROOVE	UP TO 34,96	FILLETT WELD SOCHET WELD BRANCH WELD	NO	-46°C	X
RIPARAZIONI													
ASTM A350 LF2	M.T.I. di LAITA A & C.	01-04 RIP 50%	ASME SECT. IX°	DNV MILANO	01-04 RP 50%	PN°1 Gr 2	SMAW		UP TO 36 mm		NO	- 46 °C	X
ASTM A350 LF2	M.T.I. di LAITA A & C.	02-04 RP 75%	ASME SECT. IX°	DNV MILANO	02-04 RP 75%	PN°1 Gr 2	SMAW		UP TO 52 mm		NO	- 46 °C	X
OVERLAY:													
AISI 8630 + INC. 625	M.T.I. di LAITA A & C.	01/013/8630-625	ASME IX + DNV OS-C401 / OS-F101	DNV MILAN	01/013/625	AISI 8630-80K + INC.6235	GMAW	OVERLAY	>=25 mm		NO		X