STYRENE PARK OFFSITE

Document Title:

Welder Qualification Test Certificate

R0	05-Oct-2024	IFA	A.Parsafar	A.Shadmand	M.Heidarzadeh
Rev.	**Issued Date**	**DESCRIPTION**	**PREPARED**	**CHECKED**	**APPROVED**

REVISION RECORD SHEET

Page	Revisions								Page	Revisions						
	R0	R1	R2	R3	R4	R5	R6			R0	R1	R2	R3	R4	R5	R6
1	X								41							
2	X								42							
3	X								43							
4	X								44							
5	X								45							
6	X								46							
7	X								47							
8	X								48							
9	X								49							
10	X								50							
11	X								51							
12	X								52							
13	X								53							
14	X								54							
15	X								55							
16	X								56							
17	X								57							
18	X								58							
19	X								59							
20	X								60							
21	X								61							
22	X								62							
23	X								63							
24	X								64							
25	X								65							
26	X								66							
27	X								67							
28	X								68							
29	X								69							
30	X								70							
31	X								71							
32	X								72							
33	X								73							
34	X								74							
35	X								75							
36	X								76							
37	X								77							
38	X								78							
39	X								79							
40									80							

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

DAMAFIN
thermal technology

ASME IX

Operator's name : **Amir Askari** Stamp : **E**

Base material (s) welded : **SA 105 SA106 GR.B** Welder code: **W12 / 03** Thickness : **20**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITHOUT BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PIPE6"	PLATE & PIPE 1 in. OD AND OVER
Filler metal specification (SFA)	5.1	5.1
Classification	E7018	acc. To F No.
Filler metal F No.	4	1 TO 4
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	20 mm	UP TO 40 mm
Welding position (1G , 2G ….)	**1G**	**F&G**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-109	13.JUL.2022	AZMOON RAD CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

*Start Date	*Expire Date	*Receritification Date
13.JUL.2022	13.JUL.2024	13.JUL.2024

The history of last 5 years have been recorded

We certified 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.

W.E. Department

M.HEIDARZADEH

Date: 13.Jul.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **Amir Askari** Stamp : **E**

Base material (s) welded : **SA 105 SA106 GR.B** Welder code: **W12 / 03** Thickness : **20**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITHOUT BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PIPE6"	PLATE & PIPE 1 in. OD AND OVER
Filler metal specification (SFA)	5.1	5.1
Classification	E7018	acc. To F No.
Filler metal F No.	4	1 TO 4
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	20 mm	UP TO 40 mm
Welding position (1G , 2G ….)	**1G**	**F&G**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-109	13.JUL.2022	AZMOON RAD CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

*Start Date	*Expire Date	*Receritification Date
13.JUL.2022	13.JUL.2023	13.JUL.2024

The history of last 5 years have been recorded

We certified 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.

W.E. Department

M.HEIDARZADEH

Date:13.Jul.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

DAMAFIN
thermal technology

ASME IX

Operator's name : **MAHDI RAEISI** Stamp : **B**

Base material (s) welded : **SA 516 GR.70** Welder code: **133/01** Thickness : **20**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.1	5.1
Classification	E7018	acc. To F No.
Filler metal F No.	4	1 TO4
Consumable insert for GTAW or PAW	NA	NO
Weld deposit thickness for each process	25	UP TO 50mm
Welding position (1G , 2G ….)	**1G**	**F**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (SMAW)		
Automatic joint tracking		
Welding position (1G)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-110	21.Aug.2021	PEYDAYESH FEKER CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

* START DATE	* EXPIRE DATE	* Recertificate Date
21.Aug.2021	21.Aug.2024	21.Aug.2024

The History of last 5 year have been recorded

We certified that the statements in this record are correct and that the test coupons were prepared , welded and tested in tested in accordance with the requirements of section IX of the ASME code.

W.E. Department
M.HEIDARZADEH
Date: 21.Aug.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **HOSSEIN GHOREISHI** Stamp : **J**

Base material (s) welded : **SA 516 GR.70** Welder code: **W 54** Thickness : **20**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.1	5.1 / 5.5 / 5.4 (For SFA-S.4 only EXXX(X)-26 and other than austenitic and duplex)
Classification	E7018	acc. To F No.
Filler metal F No.	4	1 TO4
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	20 mm	UP TO 40 mm
Welding position (1G , 2G ….)	**1G**	**F**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-96.19/07	22.Jul.2021	PEYDAYESH FEKR CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

START DATE :1 22.Jul.2021 EXPIRE DATE : 22.Jul.2024

We certified 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.

DTT'S
W.E. Department
MEHDI HEIDARZADEH
Date: 22.Jul.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **GHOLAM REZA OMIDI** Stamp : **I**

Base material (s) welded : **SA516 Gr.70** Welder code: **W43** Thickness : **4**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	GTAW	GTAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	…..	WITH & WITHOUT BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.18	5.18
Classification	ER70S-3	All Classification
Filler metal F No.	6	6
Consumable insert for GTAW or PAW	NO	NO
Weld deposit thickness for each process	4 mm	UP TO 8 mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NO	NO
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	DCEN	DCEN
Filler metal for GTAW or PAW	SOLID WIRE	SOLID WIRE

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-DAM-89.06/17	12.Nov.2012	PEYDAYESH FEKR CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

START DATE	EXPIRE DATE	RECERTIFICATION DATE
12.Nov.2012	12.Nov.2023	12.Nov.2023

We certified 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.

W.E. Department

MEHDI HEIDARZADE

Date: 12.Nov.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **GHOLAM REZA OMIDI** Stamp : **I**

Base material (s) welded : **SA516 Gr.70** Welder code: **W43** Thickness : **20**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	GMAW	GMAW
Type	SEMI AUTO	SEMI AUTO
Backing (metal , weld metal , welded from both side , flux)	…..	WITH & WITHOUT BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.18	5.18
Classification	ER70S-3	All Classification
Filler metal F No.	6	6
Consumable insert for GTAW or PAW	NO	NO
Weld deposit thickness for each process	20 mm	UP TO 40 mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NO	NO
GMAW transfer mode	SPRAY	SPRAY
GTAW welding current type / polarity	DCEP	DCEP
Filler metal for GTAW or PAW	SOLID WIRE	SOLID WIRE

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-DAM-89.06/34	12.Nov.2012	PEYDAYESH FEKR CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

START DATE	EXPIRE DATE	RECERTIFICATION DATE
12.Nov.2012	12.Nov.2023	12.Nov.2023

We certified 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.

W.E. Department

MEHDI HEIDARZADEH

Date: 12.Nov.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **GHOLAM REZA BAKHSHALY** Stamp : **C**

Base material (s) welded : **SA106 Gr.B** Welder code: **W29** Thickness : **4**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	GTAW	GTAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	…..	WITH & WITHOUT BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.18	5.18
Classification	ER70S-3	All Classification
Filler metal F No.	6	6
Consumable insert for GTAW or PAW	NO	NO
Weld deposit thickness for each process	4 mm	UP TO 8 mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NO	NO
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	DCEN	DCEN
Filler metal for GTAW or PAW	SOLID WIRE	SOLID WIRE

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-DAM-89.06/14	12.Nov.2012	PEYDAYESH FEKR CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADHE**

START DATE	EXPIRE DATE	RECERTIFICATION DATE
12.Nov.2012	12.Nov.2023	12.Nov.2023

We certified 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.

W.E. Department
MEHDI HEIDARZADEH
Date: 12.Nov.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **GHOLAM REZA BAKHSHALY** Stamp : **C**

Base material (s) welded : **SA516 Gr.70** Welder code: **W29** Thickness : **25**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.1	5.1
Classification	E7018	acc. To F No.
Filler metal F No.	4	1 To 4
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	25 mm	UP 50 mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-480	24.APR.2006	AZMOON RAD CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADE**

START DATE	EXPIRE DATE	RECERTIFICATION DATE
24.APR.2006	24.APR.2024	24.APR.2024

We certified 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.

DTT'S
W.E. Department
MEHDI HEIDARZADEH
Date: 24.APR.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **GHOLAM REZA BAKHSHALY** Stamp : **C**

Base material (s) welded : **SA312 TP 316L** Welder code: **W29** Thickness : **13.5**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH BACKING
ASME P No.	8	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PIPE 4"	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.4	5.1 / 5.5 / 5.4 (For SFA-S.4 only austenitic and duplex and EXXX(X)-26) (For SFA-5.5 only EXX20-X and EXX27-X)
Classification	E316L-17	acc. To F No.
Filler metal F No.	5	1&5
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	13.5 mm	UP TO 27 mm
Welding position (1G , 2G ….)	**1G**	**F**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-17/N10	13.Nov.2007	AZMOON RAD CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . NAVID HASHEMABADI**

START DATE : 13.Nov.2007 EXPIRE DATE : 13.Nov.2023

We certified 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.

DTT'S
W.E. Department
MEHDI HEIDARZADEH
Date: 13.Nov.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **GHOLAM REZA BAKHSHALY** Stamp : **C**

Base material (s) welded : **SA516 GR.60** Welder code: **W29** Thickness : **4**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	GMAW	GMAW
Type	SEMI AUTO	SEMI AUTO
Backing (metal , weld metal , welded from both side , flux)	…..	WITH & WITHOUT BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.18	5.2/5.9/5.17/5.18/5.20/5.22/5.23/5.26/5.28/5.29
Classification	ER70S-3	acc. To F No.
Filler metal F No.	6	6 (Except SFA-5.30)
Consumable insert for GTAW or PAW	NO	NO
Weld deposit thickness for each process	20 mm	UP TO 40 mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NO	NO
GMAW transfer mode	SPRAY	SPRAY
GTAW welding current type / polarity	DCEP	DCEP
Filler metal for GTAW or PAW	SOLID WIRE	SOLID WIRE

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-DAM-89.06/32	12.Nov.2012	PEYDAYESH FEKR CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . NAVID HASHEMABADI**

START DATE : 12.Nov.2012 EXPIRE DATE : 12.Nov.2023

We certified 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.

DTT'S
W.E. Department
N.HASHEMABADI
Date: 12.Nov.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **GHOLAM REZA BAKHSHALY** Stamp : **C**

Base material (s) welded : **SA106 Gr.B** Welder code: **W29** Thickness : **4**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	GMAW	GMAW
Type	SEMI AUTO	SEMI AUTO
Backing (metal , weld metal , welded from both side , flux)	…..	WITH & WITHOUT BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.18	5.18
Classification	ER70S-3	All Classification
Filler metal F No.	6	6
Consumable insert for GTAW or PAW	NO	NO
Weld deposit thickness for each process	20 mm	UP TO40 mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NO	NO
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	DCEP	DCEP
Filler metal for GTAW or PAW	SOLID WIRE	SOLID WIRE

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-DAM-89/.06/32	12.Nov.2012	PEYDAYESH FEKR CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADHE**

START DATE	EXPIRE DATE	RECERTIFICATION DATE
12.Nov.2012	12.Nov.2023	12.Nov.2023

We certified 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.

W.E. Department

MEHDI HEIDARZADEH

Date: 12.Nov.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **GHOLAM REZA BAKHSHALY** Stamp : **C**

Base material (s) welded : **SA312 TP 316L** Welder code: **W29** Thickness : **20**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH BACKING
ASME P No.	8	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or
Plate or pipe (enter diameter if pipe)	PLATE:20	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.4	5.1 / 5.5 / 5.4 (For SFA-S.4 only austenitic and duplex and
Classification	E316L-17	acc. To F No.
Filler metal F No.	4	1&5
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	20 mm	UP TO 40 mm
Welding position (1G , 2G ….)	**1G**	**F**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-17/N10	19.SEP.2023	PEYDAYESH FEKR

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . 'MEHDI HEIDARZADEH**

START DATE : '19.SEP.2022 EXPIRE DATE :19.Sep.2023

We certified 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.

DTT'S
W.E. Department
MEHDI HEIDARZADEH
Date: 19.Sep.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **DAVOOD SEPARDAR** Stamp : **S**

Base material (s) welded : **SA312^TP 316L** Welder code: **W32 / 01** Thickness : **25**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.1	5.1
Classification	E7018	acc. To F No.
Filler metal F No.	4	1 TO4
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	11 mm	UP TO 22 mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-DAM-90.09/24	03.Aug.2011	PEYDAYESH FEKR

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

START DATE	EXPIRE DATE	RECERTIFICATION DATE
03.Aug.2011	03.Aug.2024	03.Aug.2024

The history of last 5 years have been recorded

We certified 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.

DTT'S

W.E. Department
MEHDI HEIDARZADE
Date: 03.Aug.2025

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **DAVOOD SEPARDAR** Stamp : **S**

Base material (s) welded : **SA312-TP 316L** Welder code: **W32 / 02** Thickness : **12.7**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH BACKING
ASME P No.	8	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PIPE 8"	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.9	5.2/5.9/5.17/5.18/5.20/5.22/5.23/5.26/5.28/5.29
Classification	E316L-17	acc. To F No.
Filler metal F No.	5	1 & 5
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	12.7 mm	UP TO 25.4 mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-DAM-90.07/11	21.Jul.2011	PEYDAYESH FEKR

START DATE	EXPIRE DATE	RECERTIFICATION DATE
21.Jul.2011	21.Jul.2024	21.Jul.2024

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

The certified 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.

DTT'S
W.E. Department
M.HEIDARZADEH
Date: 21.Jul.2025

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

ASME IX

Operator's name : **DAVOOD SEPARDAR** Stamp : **S**

Base material (s) welded : **SA182- F 304L TO SA 312- TP 4L** Welder code: **W32 / 02** Thickness : **10.97**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	GTAW	GTAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH BACKING
ASME P No.	8	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PIPE 6"	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.9	5.2/5.9/5.17/5.18/5.20/5.22/5.23/5.26/5.28/5.29
Classification	ER308L	acc. To F No.
Filler metal F No.	6	1 & 6
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	10.97	UP TO 25.4 mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	HS-1/RT-DAM-00.20/01	14.Oct.2020	PEYDAYESH FEKR

START DATE	EXPIRE DATE	RECERTIFICATION DATE
14.Oct.2020	14.Oct.2023	14.Oct.2023

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

The certified 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.

DTT'S
W.E. Department
M.HEIDARZADEH
Date: 14.Oct.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **MOHAMAD ASHRAFI** Stamp : **W**

Base material (s) welded : **SA516 Gr.70** Welder code: **W37 / 01** Thickness : **25**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.1	5.1
Classification	E7018	acc. To F No.
Filler metal F No.	4	1 TO4
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	25 mm	UP TO 50 mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-480	24.APR.2004	PARSIAN SHARGH CO

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

START DATE	EXPIRE DATE	RECERTIFICATION DATE
24.APR.2004	24.APR.2024	24.APR.2024

The history of last 5 years have been recorded

We certified 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.

W.E. Department

P.KHOJASTHE

Date: 24.Apr.2024

EWF Mehdi Heidarzadeh IR EWF 0047 European Welding Engineer

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **MOHAMAD ASHRAFI** Stamp : **W**

Base material (s) welded : **SA312-TP 316L** Welder code: **W37 / 02** Thickness : **12.7**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH BACKING
ASME P No.	8	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PIPE 8"	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.9	5.2/5.9/5.17/5.18/5.20/5.22/5.23/5.26/5.28/5.29
Classification	E316L-17	acc. To F No.
Filler metal F No.	5	1 & 5
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	12.7 mm	UP TO 25.4 mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-DAM-90.07/17	21.Jul.2011	PEYDAYESH FEKR

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . NAVID HASHEMABADI**

START DATE : 21.Jul.2024 EXPIRE DATE : 21.Jul.2025

We certified 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.

DTT'S
W.E. Department
N.HASHEMABADI
Date: 21.Jul.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN

thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **MOKHTAR NASIRI** Stamp : **T**

Base material (s) welded : **SA312-TP 316L** Welder code: **W41 / 01** Thickness : **12.7**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH BACKING
ASME P No.	8	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PIPE 8"	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.9	5.2/5.9/5.17/5.18/5.20/5.22/5.23/5.26/5.28/5.29
Classification	E316L-17	acc. To F No.
Filler metal F No.	5	1 & 5
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	12.7 mm	UP TO 25.4 mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-DAM-90.07/12	21.Jul.2011	PEYDAYESH FEKR

START DATE	EXPIRE DATE	RECERTIFICATION DATE
Nov.14.2022	Nov.14.2023	Nov.14.2023
Nov.14.2023	Nov.14.2024	Nov.14.2024

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

The certified 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.

DTT'S
W.E. Department
M.HEIDARZADEH
Date: 14.Nov.2024

EWF
Mehdi Heidarzadeh
IR EWF 0047
EUROPEAN WELDING ENGINEER

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Operator's name : **MOKHTAR NASIRI** Stamp : **T**

Base material (s) welded : **SA516 GR70** Welder code: **W41 / 01** Thickness : **25**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.1	5.1
Classification	E7018	acc. To F No.
Filler metal F No.	4	1 TO4
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	25 mm	UP TO 50 mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-026	FEB.10.2008	AZMOON RAD CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

START DATE	EXPIRE DATE	RECERTIFICATION DATE
10.Feb.2020	10.Feb.2021	10.Feb.2021
10.Feb.2021	10.Feb.2022	10.Feb.2022
10.Feb.2022	10.Feb.2023	10.Feb.2023
10.Feb.2023	10.Feb.2024	10.Feb.2024
10.Feb.2024	10.Feb.2025	

The history of last 5 years have been recorded

We certified 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.

W.E. Department

M.HEIDARZADEH

Date: Feb.10.2024

EWF
Mehdi Heidarzadeh
IR EWF 0047
EUROPEAN WELDING ENGINEER

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

DAMAFIN
thermal technology

ASME IX

Operator's name : **SAEED ASADOLAHI** Stamp : **D**

Base material (s) welded : **SA105 TO SA106 Gr.B** Welder code: **W12 / 01** Thickness : **4**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	GTAW	GTAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	…..	WITH & WITHOUT BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PIPE 4"	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.18	5.18
Classification	ER70S-3	All Classifiction
Filler metal F No.	6	6
Consumable insert for GTAW or PAW	NO	NO
Weld deposit thickness for each process	4 mm	UP TO 8 mm
Welding position (1G , 2G ….)	**6G**	**ALL**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NO	NO
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	DCEN	DCEN
Filler metal for GTAW or PAW	SOLID WIRE	SOLID WIRE

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-108	Jul.13.2008	AZMOON RAD CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

*Start Date	*Expire Date	*Receritification Date
14.Nov.2018	14.Nov.2023	14.Nov.2023

The history of last 5 years have been recorded

We certified 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.

W.E. Department
P.KHOJASTHE
Date Nov.14.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

DAMAFIN
thermal technology

ASME IX

Operator's name : **SAEED ASADOLAHI** Stamp : **D**

SA 105 SA106

Base material (s) welded : **GR.B** Welder code: **W12 / 03** Thickness : **11**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITHOUT BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PIPE6"	PLATE & PIPE 1 in. OD AND OVER
Filler metal specification (SFA)	5.1	5.1
Classification	E7018	acc. To F No.
Filler metal F No.	4	1 TO 4
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	11 mm	UP TO 22 mm
Welding position (1G , 2G ….)	**6G**	**ALL**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-109	JUL/13/2008	AZMOON RAD CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

*Start Date	*Expire Date	*Receritification Date
13.JUL.2023	13.JUL.2023	13.JUL.2023
13.JUL.2023	13.JUL.2024	13.JUL.2024

The history of last 5 years have been recorded

We certified 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.

W.E. Department
P.KHOJASTHE
Date: 13.Jul.2024

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

DAMAFIN
thermal technology

ASME IX

Operator's name : **SAEED ASADOLAHI** Stamp : **D**

Base material (s) welded : **SA516 GR.70** Welder code: **W12 / 04** Thickness : **25**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SAW	SAW
Type	MACHINING	MACHINING
Backing (metal , weld metal , welded from both side , flux)	METAL AND WELD METAL	WITH BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.17	5.17
Classification	EH14	All Classification
Filler metal F No.	6	6
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	25 mm	UP TO 50 mm
Welding position (1G , 2G ….)	**1G**	**F**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote	DIRECT	DIRECT
Automatic voltage control (GTAW)	NA	NA
Automatic joint tracking	NO	YES OR NO
Welding position (1G , 2G ….)	1G	FLAT
Consumable insert	NO	YES OR NO
Backing (metal , weld metal , welded from both side , flux)	WELD FROM BOTH SIDE	WITH BACKING
Single or multipass per side	MULTI	MULTI OR SINGLE

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-516	APR.24.2006	PARSIAN SHARG CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

*Start Date	*Expire Date	*Receritification Date
24.APR.2006	24.APR.2023	24.APR.2023
24.APR.2023	24.APR.2024	24.APR.2024

The history of last 5 years have been recorded .

We certified 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.

W.E. Department
P.KHOJASTEH
Date:24.APR.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

dtt ermal technology

Operator's name : **SAEED ASADOLAHI** Stamp : **D**

Base material (s) welded : **SA516 Gr.70** Welder code: **W12 / 01** Thickness : **25**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SAW	SAW
Type	MACHINING	MACHINING
Backing (metal , weld metal , welded from both side , flux)	METAL AND WELD METAL	WITH BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.17	5.2/5.9/5.17/5.18/5.20/5.22/ 5.23/5.26/5.28/5.29
Classification	EH14	acc. To F No.
Filler metal F No.	6	6 (Except SFA-5.30)
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	25 mm	UP TO 50 mm
Welding position (1G , 2G ….)	**1G**	**F**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote	DIRECT	DIRECT
Automatic voltage control (GTAW)	NA	NA
Automatic joint tracking	NO	YES OR NO
Welding position (1G , 2G ….)	1G	FLAT
Consumable insert	NO	YES OR NO
Backing (metal , weld metal , welded from both side , flux)	WELD FROM BOTH SIDE	WITH BACKING
Single or multipass per side	MULTI	MULTI OR SINGLE

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-516	APR.24.2006	PARSIAN SHARGH CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . HEIDARZADEH**

*Start Date	*Expire Date	*Receritification Date
24.APR.2006	24.APR.2023	24.APR.2023
24.APR.2023	24.APR.2024	24.APR.2024

We certified 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.

DTT'S
W.E. Department
M.HEIDARZADEH
Date:24.APR.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

dtt ıermal technology

Operator's name : **SAEED ASADOLAHI** Stamp : **D**

Base material (s) welded : **SA240-TP 316L** Welder code: **W12 / 05** Thickness : **25**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SAW	SAW
Type	MACHINING	MACHINING
Backing (metal , weld metal , welded from both side , flux)	METAL AND WELD METAL	WITH BACKING
ASME P No.	8	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
	5.9	5.2/5.9/5.17/5.18/5.20/5.22/ 5.23/5.26/5.28/5.29
Classification	ER316L	acc. To F No.
Filler metal F No.	6	6 (Except SFA-5.30)
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	25 mm	
Welding position (1G , 2G ….)	**1G**	**F**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote	DIRECT	DIRECT
Automatic voltage control (GTAW)	NA	NA
Automatic joint tracking	NO	YES OR NO
Welding position (1G , 2G ….)	1G	FLAT
Consumable insert	NO	YES OR NO
Backing (metal , weld metal , welded from both side , flux)	WELD FROM BOTH SIDE	WITH BACKING
Single or multipass per side	MULTI	MULTI OR SINGLE

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RESULTE	REPORT NO	DATE	BY
Satisfactory	DQC-31	11.Nov.2007	JAHAD LABORATORY

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . NAVID HASHEMABADI**

START DATE :Nov.11.2024 EXPIRE DATE : Nov.11.2025

We certified 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.

20.JUN.2020 DTT'S

W.E. Department

M.HEIDARZADEH

Date:Nov.11.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

thermal technology

Operator's name : **SAEED ASADOLAHI** Stamp : **D**

Base material (s) welded : **SB-163 UNS** Welder code: **W12 / 07** Thickness : **1.65**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	GTAW	GTAW
Type	AUTOMATIC	AUTOMATIC
Backing (metal , weld metal , welded from both side , flux)	…..	WITH & WITHOUT BACKING
ASME P No.	45	P-01 S-No. 41 through P or S-No.
Plate or pipe (enter diameter if pipe)	PIPE 1"	PLATE & PIPE 1 in. OD AND OVER
Filler metal specification (SFA)	5.14	5.11/5.30/5.14
Classification	ER NiCrMo-3	acc. To F No.
Filler metal F No.	43	41~46
Consumable insert for GTAW or PAW	NO	NO
Weld deposit thickness for each process	1.65 mm	UP TO 3.3 mm
Welding position (1G , 2G ….)	**5F**	**5F**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	YES	with backing gas
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	DCEN	DCEN
Filler metal for GTAW or PAW	SOLID WIRE	SOLID WIRE

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RESULTE	REPORT NO	DATE	BY
Satisfactory	DS11-P44	08.Feb.2014	JAHAD LAB.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . NAVID HASHEMABADI**

START DATE :08.FEB.2023 EXPIRE DATE : 08.FEB.2025

We certified 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.

DTT'S
W.E. Department
M.HEIDARZADEH
Date: 08.FEB.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

DAMAFIN
thermal technology

ASME IX

Operator's name : **HADI LAK** Stamp : **F**

Base material (s) welded : **SA 516 Gr.70 N** Welder code: **W105 / 01** Thickness : **25**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH & WITHOUT BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.1	5.2/5.9/5.17/5.18/5.20/5.22/5.23/5.26/5.28/5.29
Classification	E7018-1	acc. To F No.
Filler metal F No.	4	1 To 4
Consumable insert for GTAW or PAW	N/A	N/A
Weld deposit thickness for each process	25	UP TO 50 mm
Welding position (1G , 2G ….)	**1G**	**F**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULT	REPORT NO	DATE	BY
Satisfactory	DAM / RT-105	03.Feb.2022	PEYDAYESH FEKR CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . PEYMANN KHOJASTEH**

* START DATE	* EXPIRE DATE	* Recertificate Date
03.Feb.2022	03.Feb.2023	03.Feb.2023
03.Feb.2023	03.Feb.2024	03.Feb.2024

The History of last 5 year have been recorded

We certified 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.

DTT'S
W.E. Department
M.HEIDARZADEH
Date: 03.Feb.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **ALI BAGHERI** Stamp : **P**

Base material (s) welded : **SA516 Gr.70** Welder code: **W103/02** Thickness : **25**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	GMAW	SAW
Type	MACHINING	MACHINING
Backing (metal , weld metal , welded from both side , flux)	METAL AND WELD METAL	WITH BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.17	5.17
Classification	EH-12K	All clasification
Filler metal F No.	6	6
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	25 mm	UP TO 50 mm
Welding position (1G , 2G ….)	**1G**	**F**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote	DIRECT	DIRECT
Automatic voltage control (GTAW)	NA	NA
Automatic joint tracking	NO	YES OR NO
Welding position (1G , 2G ….)	1G	FLAT
Consumable insert	NO	YES OR NO
Backing (metal , weld metal , welded from both side , flux)	WELD FROM BOTH SIDE	WITH BACKING
Single or multipass per side	MULTI	MULTI OR SINGLE

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-112	24.May.2021	PARSIAN SHARGH CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

START DATE	EXPIRE DATE	Recertification Date
24.May.2021	24.May.2022	24.May.2022
24.May.2022	24.May.2023	24.May.2023
24.May.2023	24.May.2024	24.May.2024

We certified 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.

DTT'S
W.E. Department
ENG . MEHDI HEIDARZADEH
Date: 24.MAY.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

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DAMAFIN

thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **ALI BAGHERI** Stamp : **P**

Base material (s) welded : **SA240-TP 316L** Welder code: **W103 / 03** Thickness : **25**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SAW	SAW
Type	MACHINING	MACHINING
Backing (metal , weld metal , welded from both side , flux)	METAL AND WELD METAL	WITH BACKING
ASME P No.	8	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.9	5.2/5.9/5.17/5.18/5.20/5.22/ 5.23/5.26/5.28/5.29
Classification	ER316L	acc. To F No.
Filler metal F No.	6	6 (Except SFA-5.30)
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	25 mm	
Welding position (1G , 2G ….)	**1G**	**F**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote	DIRECT	DIRECT
Automatic voltage control (GTAW)	NA	NA
Automatic joint tracking	NO	YES OR NO
Welding position (1G , 2G ….)	1G	FLAT
Consumable insert	NO	YES OR NO
Backing (metal , weld metal , welded from both side , flux)	WELD FROM BOTH SIDE	WITH BACKING
Single or multipass per side	MULTI	MULTI OR SINGLE

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-113	24.May.2021	PARSIAN SHARGH CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

START DATE :MAY.24.2021 EXPIRE DATE : MAY.24.2022

START DATE	EXPIRE DATE	Recertification Date
24.May.2021	24.May.2022	24.May.2022
24.May.2022	24.May.2023	24.May.2023
24.May.2023	24.May.2024	24.May.2024

We certified 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.

DTT'S

W.E. Department

ENG . MEHDI HEIDARZADEH

Date: 24.MAY.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

DAMAFIN
thermal technology

ASME IX

Operator's name : **ALI BAGHERI** Stamp : **P**

Base material (s) welded : **SA-516 Gr.70** Welder code: **W103 / 04** Thickness : **25**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SAW	SAW
Type	MACHINING	MACHINING
Backing (metal , weld metal , welded from both side , flux)	METAL AND WELD METAL	WITH BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.17	5.2/5.9/5.17/5.18/5.20/5.22/ 5.23/5.26/5.28/5.29
Classification	ER316L	acc. To F No.
Filler metal F No.	6	6 (Except SFA-5.30)
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	25 mm	Up to 50 mm
Welding position (1G , 2G ….)	**1G**	**F**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote	DIRECT	DIRECT
Automatic voltage control (GTAW)	NA	NA
Automatic joint tracking	NO	YES OR NO
Welding position (1G , 2G ….)	1G	FLAT
Consumable insert	NO	YES OR NO
Backing (metal , weld metal , welded from both side , flux)	WELD FROM BOTH SIDE	WITH BACKING
Single or multipass per side	MULTI	MULTI OR SINGLE

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-113	24.May.2021	PARSIAN SHARGH CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

START DATE :MAY.24.2021 EXPIRE DATE : MAY.24.2022

START DATE	EXPIRE DATE	Recertification Date
24.May.2021	24.May.2022	24.May.2022
24.May.2022	24.May.2023	24.May.2023
24.May.2023	24.May.2024	24.May.2024

We certified 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.

DTT'S
W.E. Department
ENG . MEHDI HEIDARZADEH
Date: 24.MAY.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **ALI BAGHERI** Stamp : **P**

Base material (s) welded : **SA312-TP 316L** Welder code: **W103 / 05** Thickness : **20**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	WITH BACKING
ASME P No.	8	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE 20	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.4	5.1 / 5.5 / 5.4 (For SFA-S.4 only austenitic and duplex and EXXX(X)-26) (For SFA-5.5 only EXX20-X and EXX27-X)
Classification	E316L-17	acc. To F No.
Filler metal F No.	4	1&5
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	20 mm	UP TO 40 mm
Welding position (1G , 2G ….)	**1G**	**F&G**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
Guide bend	**NA**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-17/N10	SEP.19.2023	PEYDAYESH FEKR

Visual examination : SATISFACTORY

Welding test conducted by Mr. :

START DATE : SEP.19.2023

We certified 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.

DTT'S

W.E. Department

M.HEIDARZADEH

EXPIRE DATE : SEP.19.2024

EWF
Mehdi Heidarzadeh
IR EWF 0047
EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **ALIREZA KHERADMANDI** Stamp : **K**

Base material (s) welded : **SA 182-F 304 L** Welder code: **33/02** Thickness : **13.5 / 4"**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	STAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	-	WITH & WITHOUT BACKING
ASME P No.	8	P-or S-No. 8
Plate or pipe (enter diameter if pipe)	PIPE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.4	5.4
Classification	E 308 L-17	acc. To F No.
Filler metal F No.	5	5
Consumable insert for GTAW or PAW	NA	NO
Weld deposit thickness for each process	4"-13.5	UP TO 27mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**N/A**		
Macro	**N/A**		
Guide bend	**N/A**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT- A42	10.April.2023	PEYDAYESH FEKER CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

* START DATE	* EXPIRE DATE	* Recertificate Date
13.April.2024	13.April.2025	

The History of last 5 year have been recorded

We certified that the statements in this record are correct and that the test coupons were prepared , welded and tested in tested in accordance with the requirements of section IX of the ASME code.

W.E. Department

M.HEIDARZADEH

Date: 13.April.2024

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **MEHDI LORZAMANI** Stamp : **L**

Base material (s) welded : **SA 516 GR.70 NACE** Welder code: **133/02** Thickness : **35**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	GTAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	-	WITH & WITHOUT BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.18	5.18
Classification	ER70S-6	acc. To F No.
Filler metal F No.	6	6
Consumable insert for GTAW or PAW	NA	NO
Weld deposit thickness for each process	4	UP TO 8mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**Satisfactory**	***5098-2***	***RASF Co.***
Macro	**N/A**		
Guide bend	**Satisfactory**	***5098-2***	***RASF Co.***

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT-046	10.MAY.2023	PEYDAYESH FEKER CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

* START DATE	* EXPIRE DATE	* Recertificate Date
15.May.2024	15.May.2025	

The History of last 5 year have been recorded

We certified that the statements in this record are correct and that the test coupons were prepared , welded and tested in tested in accordance with the requirements of section IX of the ASME code.

W.E. Department

M.HEIDARZADEH

Date: 15.May.2023

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **MEHDI LORZAMANI** Stamp : **L**

Base material (s) welded : **SA 182-F 304 L** Welder code: **133/03** Thickness : **13.5 / 4"**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	GTAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	-	WITH & WITHOUT BACKING
ASME P No.	8	P-or S-No. 8
Plate or pipe (enter diameter if pipe)	PIPE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.4	5.4
Classification	E 308 L-17	acc. To F No.
Filler metal F No.	5	5
Consumable insert for GTAW or PAW	NA	NO
Weld deposit thickness for each process	4"-13.5	UP TO 27mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**N/A**		
Macro	**N/A**		
Guide bend	**N/A**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT- A42	10.April.2023	PEYDAYESH FEKER CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

* START DATE	* EXPIRE DATE	* Recertificate Date
13.April.2024	13.April.2025	

The History of last 5 year have been recorded

We certified that the statements in this record are correct and that the test coupons were prepared , welded and tested in tested in accordance with the

W.E. Department

M.HEIDARZADEH

Date: 15.May.2024

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **ALI ABDI** Stamp : **H**

Base material (s) welded : **SA 516 GR.70** Welder code: **W151/01** Thickness : **20**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	SMAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	WELD METAL	-
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.1	5.1 / 5.5 / 5.4 (For SFA-S.4 only EXXX(X)-26 and other than austenitic and duplex)
Classification	E7018	acc. To F No.
Filler metal F No.	4	1 TO4
Consumable insert for GTAW or PAW	NA	NA
Weld deposit thickness for each process	20 mm	ALL
Welding position (1G , 2G ….)	**2F**	**H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
PT	**Satisfactory**	**G 400/07**	***DAMAFIN CO***

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	VT-400./08	22.DEC.2020	PEYDAYESH FEKR CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

START DATE :1 27.DEC.2024 EXPIRE DATE : 27.DEC.2025

We certified 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.

DTT'S
W.E. Department
MEHDI HEIDARZADEH
Date: 27.DEC.2024

EWF
Mehdi Heidarzadeh
IR EWF 0047
EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **POURYA NEKONAJAFI** Stamp : **N**

Base material (s) welded : **SA 516 GR.70** Welder code: **W148/01** Thickness : **20**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	GMAW	GMAW
Type	SEMI AUTO	SEMI AUTO
Backing (metal , weld metal , welded from both side , flux)	…..	WITH & WITHOUT BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.18	5.2/5.9/5.17/5.18/5.20/5.22/5.23/5.26/5.28/5.29
Classification	ER70S-6	acc. To F No.
Filler metal F No.	6	6 (Except SFA-5.30)
Consumable insert for GTAW or PAW	NO	NO
Weld deposit thickness for each process	20 mm	UP TO 40 mm
Welding position (1G , 2G ….)	**2F**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NO	NO
GMAW transfer mode	SPRAY	SPRAY
GTAW welding current type / polarity	DCEP	DCEP
Filler metal for GTAW or PAW	SOLID WIRE	SOLID WIRE

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
PT	**Satisfactory**	**G 400/07**	***DAMAFIN CO***

VISUAL Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	VT-405./08	02.NOV.2021	PEYDAYESH FEKR CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

START DATE :1 02.NOV.2024 EXPIRE DATE : 02.NOV.2025

We certified 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.

DTT'S
W.E. Department
MEHDI HEIDARZADEH
Date: 05.NOV.2024

EWF
Mehdi Heidarzadeh
IR EWF 0047
EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **SADEGH RABEE** Stamp : **R**

Base material (s) welded : **SA 516 GR.70** Welder code: **W145/01** Thickness : **20**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	GMAW	GMAW
Type	SEMI AUTO	SEMI AUTO
Backing (metal , weld metal , welded from both side , flux)	…..	WITH & WITHOUT BACKING
ASME P No.	1	P-or S-No. 1 through P-or S-No. 11, P-or S-No. 34, and P-or S-No. 41 through P-or S-No. 49
Plate or pipe (enter diameter if pipe)	PLATE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.18	5.2/5.9/5.17/5.18/5.20/5.22/5.23/5.26/5.28/5.29
Classification	ER70S-6	acc. To F No.
Filler metal F No.	6	6 (Except SFA-5.30)
Consumable insert for GTAW or PAW	NO	NO
Weld deposit thickness for each process	20 mm	UP TO 40 mm
Welding position (1G , 2G ….)	**2F**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NO	NO
GMAW transfer mode	SPRAY	SPRAY
GTAW welding current type / polarity	DCEP	DCEP
Filler metal for GTAW or PAW	SOLID WIRE	SOLID WIRE

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**NA**		
Macro	**NA**		
PT	**Satisfactory**	**G 400/010**	***DAMAFIN CO***

VISUAL Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	VT-410./02	02.NOV.2021	PEYDAYESH FEKR CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

START DATE :1 02.NOV.2024 EXPIRE DATE : 02.NOV.2025

We certified 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.

DTT'S
W.E. Department
MEHDI HEIDARZADEH
Date: 05.NOV.2024

EWF
Mehdi Heidarzadeh
IR EWF 0047
EUROPEAN WELDING ENGINEER

DAMAFIN
thermal technology

MANUFACTURER'S RECORD OF WELDER OR WELDING OPERATOR

ASME IX

Operator's name : **ALIREZA KHERADMANDI** Stamp :

Base material (s) welded : **SA 182-F 304 L** Welder code: **33/02** Thickness : **13.5 / 4"**

MANUAL OR SEMIAUTOMATIC VARIABLE FOR EACH PROCESS	ACTUAL VALUES	RANGE QUALIFIED
Welding process used	STAW	SMAW
Type	MANUAL	MANUAL
Backing (metal , weld metal , welded from both side , flux)	-	WITH & WITHOUT BACKING
ASME P No.	8	P-or S-No. 8
Plate or pipe (enter diameter if pipe)	PIPE	PLATE & PIPE 2 7/8 in. OD AND OVER
Filler metal specification (SFA)	5.4	5.4
Classification	E 308 L-17	acc. To F No.
Filler metal F No.	5	5
Consumable insert for GTAW or PAW	NA	NO
Weld deposit thickness for each process	4"-13.5	UP TO 27mm
Welding position (1G , 2G ….)	**2G**	**F&H**
Progression (Uphill or Downhill)	NA	NA
Backing gas for GTAW , PAW or GMAW	NA	NA
GMAW transfer mode	NA	NA
GTAW welding current type / polarity	NA	NA
Filler metal for GTAW or PAW	NA	NA

MACHINE WELDING VARIABLES FOR THE PROCESS USED	ACTUAL VALUES	RANGE QUALIFIED
Direct / Remote		
Automatic voltage control (GTAW)		
Automatic joint tracking		
Welding position (1G , 2G ….)		
Consumable insert		
Backing (metal , weld metal , welded from both side , flux)		
Single or multipass per side		

MECHANICAL Test Results

TYPE OF TEST	RESULTE	REPORT NO	BY
Tensil	**N/A**		
Macro	**N/A**		
Guide bend	**N/A**		

RADIOGRAPHY Test Result

RESULTE	REPORT NO	DATE	BY
Satisfactory	RT- A42	10.April.2023	PEYDAYESH FEKER CO.

Visual examination : SATISFACTORY

Welding test conducted by Mr. : **ENG . MEHDI HEIDARZADEH**

* START DATE	* EXPIRE DATE	* Recertificate Date
13.April.2023	13.April.2024	

The History of last 5 year have been recorded

We certified that the statements in this record are correct and that the test coupons were prepared , welded and tested in tested in accordance with the requirements of section IX of the ASME code.

W.E. Department

M.HEIDARZADEH

Date: 13.April.2023

EWF Mehdi Heidarzadeh IR EWF 0047 EUROPEAN WELDING ENGINEER