

PQR-WPS WELDING QUALIFICATIONS

PQR-WPS ASME IX	PQR-WPS EN ISO 15609	Plasma Transferred Arc	Deposit thickness on base material	ASME IX P Number	EN ISO 15609 P Number	Base material	Buttering	Filler material
KIR-AS-01 Rev.0	KIR-EN-01 Rev.0	PTA	25	1 Gr 2	11.1	LF2 (1.0460)		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-02 Rev.0	KIR-EN-02 Rev.0	PTA	25	1 Gr 2	11.1	LF2 (1.0460)		ST12 (SFA-5.21 ERCoCr-B) sp. 2
KIR-AS-03 Rev.0	KIR-EN-03 Rev.0	PTA	25	1 Gr 2	11.1	LF2 (1.0460)		ST21 (SFA-5.21 ERCoCr-E) sp. 2
KIR-AS-04 Rev.0	KIR-EN-04 Rev.0	PTA	25	1 Gr 2	11.1	LF2 (1.0460)	F309 sp. 1,5	F316 sp. 2
KIR-AS-05 Rev.0	KIR-EN-05 Rev.0	PTA	25	1 Gr 2	11.1	LF2 (1.0460)		AISI410 sp. 2
KIR-AS-06 Rev.0	KIR-EN-06 Rev.0	PTA	25	5A Gr1	5.2	F22 / 1.7383		INC600 sp. 2
KIR-AS-07 Rev.0	KIR-EN-07 Rev.0	PTA	25	5A Gr1	5.2	F22 / 1.7383		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-08 Rev.0	KIR-EN-08 Rev.0	PTA	25	5A Gr1	5.2	F22 / 1.7383		ST12 (SFA-5.21 ERCoCr-B) sp. 2
KIR-AS-09 Rev.0	KIR-EN-09 Rev.0	PTA	25	5A Gr1	5.2	F22 / 1.7383		ST21 (SFA-5.21 ERCoCr-E) sp. 2
KIR-AS-10 Rev.0	KIR-EN-10 Rev.0	PTA	25	5A Gr1	5.2	F22 / 1.7383		AISI410 sp. 2
KIR-AS-37 Rev.0	KIR-EN-37 Rev.0	PTA	25	5A Gr1	5.2	F22 / 1.7383		F316 sp. 2
KIR-AS-11 Rev.0	KIR-EN-11 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903		INC600 sp. 2
KIR-AS-12 Rev.0	KIR-EN-12 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903	INC600 sp. 1,5	ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-13 Rev.0	KIR-EN-13 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903	INC600 sp. 1,5	ST12 (SFA-5.21 ERCoCr-B) sp. 2
KIR-AS-14 Rev.0	KIR-EN-14 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903	INC600 sp. 1,5	ST21 (SFA-5.21 ERCoCr-E) sp. 2
KIR-AS-15 Rev.0	KIR-EN-15 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903	INC600 sp. 1,5	AISI410 sp. 2
KIR-AS-35 Rev.0	KIR-EN-35 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-36 Rev.0	KIR-EN-36 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903		AISI410 sp. 2
KIR-AS-16 Rev.0	KIR-EN-16 Rev.0	PTA	25	no PN	4.2	1.6368		INC600 sp. 2
KIR-AS-17 Rev.0	KIR-EN-17 Rev.0	PTA	25	no PN	4.2	1.6368	INC600 sp. 1,5	ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-18 Rev.0	KIR-EN-18 Rev.0	PTA	25	no PN	4.2	1.6368		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-19 Rev.0	KIR-EN-19 Rev.0	PTA	25	no PN	4.2	1.6368		ST12 (SFA-5.21 ERCoCr-B) sp. 2
KIR-AS-20 Rev.0	KIR-EN-20 Rev.0	PTA	25	no PN	4.2	1.6368		ST21 (SFA-5.21 ERCoCr-E) sp. 2
KIR-AS-21 Rev.0	KIR-EN-21 Rev.0	PTA	25	no PN	4.2	1.6368		AISI410 sp. 2
KIR-AS-22 Rev.0	KIR-EN-22 Rev.0	PTA	25	4 Gr1	5.1	F11 F12		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-23 Rev.0	KIR-EN-23 Rev.0	PTA	25	4 Gr1	5.1	F11 F12	F309 sp. 1,5	F316 sp. 2
KIR-AS-24 Rev.0	KIR-EN-24 Rev.0	PTA	25	4 Gr1	5.1	F11 F12		AISI410 sp. 2
KIR-AS-25 Rev.0	KIR-EN-25 Rev.0	PTA	25	8 Gr1	8.1	F316-F304-F309-F347		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-32 Rev.0	KIR-EN-32 Rev.0	PTA	25	8 Gr1	8.1	F316-F304-F309-F347		ST12 (SFA-5.21 ERCoCr-B) sp. 2
KIR-AS-26 Rev.0	KIR-EN-26 Rev.0	PTA	25	8 Gr1	8.1	F316-F304-F309-F347		ST21 (SFA-5.21 ERCoCr-E) sp. 2
KIR-AS-27 Rev.0	KIR-EN-27 Rev.0	PTA	25	6 Gr1	7.2	AISI 410 - 1.4122		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-28 Rev.0	KIR-EN-28 Rev.0	PTA	25	10H Gr1	10.1	F51-F52-F53-F55		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-29 Rev.0	KIR-EN-29 Rev.0	PTA	25	10H Gr1	10.1	F51-F52-F53-F55		ST12 (SFA-5.21 ERCoCr-B) sp. 2
KIR-AS-38 Rev.0	KIR-EN-38 Rev.0	PTA	25	10H Gr1	10.1	F51-F52-F53-F55		ST21 (SFA-5.21 ERCoCr-E) sp. 2
KIR-AS-30 Rev.0	KIR-EN-30 Rev.0	PTA	25					ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-31 Rev.0	KIR-EN-31 Rev.0	PTA	25	8 Gr4	8.2	F44	INC600 sp. 1,5	ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-33 Rev.0	KIR-EN-33 Rev.0	PTA	25	42	42	MONEL 400	INC600 sp. 1,5	ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-34 Rev.0	KIR-EN-34 Rev.0	PTA	25	42	42	MONEL K500	INC600 sp. 1,5	ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-39 Rev.0	KIR-EN-39 Rev.0	PTA	25	43	43	INC625		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-40 Rev.0	KIR-EN-40 Rev.0	PTA	25	45	45	INC825		ST6 (SFA-5.21 ERCoCr-A) sp. 2

Total: PQR-WPS ASME IX + PED n°40
PQR-WPS EN ISO 15609 n°40

Date: 16/01/2025 Rev.0

Issued by: A.Pagani

ELENCO QUALIFICHE DI SALDATURA PQR-WPS

PQR-WPS ASME IX	PQR-WPS EN ISO 15609	Plasma Arco Trasferito	Spessore materiale base	P Number ASME IX	P Number EN ISO 15609	materiale base	materiale di imballatura	materiale d'apporto
KIR-AS-01 Rev.0	KIR-EN-01 Rev.0	PTA	25	1 Gr 2	11.1	LF2 (1.0460)		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-02 Rev.0	KIR-EN-02 Rev.0	PTA	25	1 Gr 2	11.1	LF2 (1.0460)		ST12 (SFA-5.21 ERCoCr-B) sp. 2
KIR-AS-03 Rev.0	KIR-EN-03 Rev.0	PTA	25	1 Gr 2	11.1	LF2 (1.0460)		ST21 (SFA-5.21 ERCoCr-E) sp. 2
KIR-AS-04 Rev.0	KIR-EN-04 Rev.0	PTA	25	1 Gr 2	11.1	LF2 (1.0460)	F309 sp. 1,5	F316 sp. 2
KIR-AS-05 Rev.0	KIR-EN-05 Rev.0	PTA	25	1 Gr 2	11.1	LF2 (1.0460)		AISI410 sp. 2
KIR-AS-06 Rev.0	KIR-EN-06 Rev.0	PTA	25	5A Gr1	5.2	F22 / 1.7383		INC600 sp. 2
KIR-AS-07 Rev.0	KIR-EN-07 Rev.0	PTA	25	5A Gr1	5.2	F22 / 1.7383		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-08 Rev.0	KIR-EN-08 Rev.0	PTA	25	5A Gr1	5.2	F22 / 1.7383		ST12 (SFA-5.21 ERCoCr-B) sp. 2
KIR-AS-09 Rev.0	KIR-EN-09 Rev.0	PTA	25	5A Gr1	5.2	F22 / 1.7383		ST21 (SFA-5.21 ERCoCr-E) sp. 2
KIR-AS-10 Rev.0	KIR-EN-10 Rev.0	PTA	25	5A Gr1	5.2	F22 / 1.7383		AISI410 sp. 2
KIR-AS-37 Rev.0	KIR-EN-37 Rev.0	PTA	25	5A Gr1	5.2	F22 / 1.7383		F316 sp. 2
KIR-AS-11 Rev.0	KIR-EN-11 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903		INC600 sp. 2
KIR-AS-12 Rev.0	KIR-EN-12 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903	INC600 sp. 1,5	ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-13 Rev.0	KIR-EN-13 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903	INC600 sp. 1,5	ST12 (SFA-5.21 ERCoCr-B) sp. 2
KIR-AS-14 Rev.0	KIR-EN-14 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903	INC600 sp. 1,5	ST21 (SFA-5.21 ERCoCr-E) sp. 2
KIR-AS-15 Rev.0	KIR-EN-15 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903	INC600 sp. 1,5	AISI410 sp. 2
KIR-AS-35 Rev.0	KIR-EN-35 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-36 Rev.0	KIR-EN-36 Rev.0	PTA	25	15E Gr1	6.4	F91 F92 / 1.4903		AISI410 sp. 2
KIR-AS-16 Rev.0	KIR-EN-16 Rev.0	PTA	25	no PN	4.2	1.6368		INC600 sp. 2
KIR-AS-17 Rev.0	KIR-EN-17 Rev.0	PTA	25	no PN	4.2	1.6368	INC600 sp. 1,5	ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-18 Rev.0	KIR-EN-18 Rev.0	PTA	25	no PN	4.2	1.6368		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-19 Rev.0	KIR-EN-19 Rev.0	PTA	25	no PN	4.2	1.6368		ST12 (SFA-5.21 ERCoCr-B) sp. 2
KIR-AS-20 Rev.0	KIR-EN-20 Rev.0	PTA	25	no PN	4.2	1.6368		ST21 (SFA-5.21 ERCoCr-E) sp. 2
KIR-AS-21 Rev.0	KIR-EN-21 Rev.0	PTA	25	no PN	4.2	1.6368		AISI410 sp. 2
KIR-AS-22 Rev.0	KIR-EN-22 Rev.0	PTA	25	4 Gr1	5.1	F11 F12		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-23 Rev.0	KIR-EN-23 Rev.0	PTA	25	4 Gr1	5.1	F11 F12	F309 sp. 1,5	F316 sp. 2
KIR-AS-24 Rev.0	KIR-EN-24 Rev.0	PTA	25	4 Gr1	5.1	F11 F12		AISI410 sp. 2
KIR-AS-25 Rev.0	KIR-EN-25 Rev.0	PTA	25	8 Gr1	8.1	F316-F304-F309-F347		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-32 Rev.0	KIR-EN-32 Rev.0	PTA	25	8 Gr1	8.1	F316-F304-F309-F347		ST12 (SFA-5.21 ERCoCr-B) sp. 2
KIR-AS-26 Rev.0	KIR-EN-26 Rev.0	PTA	25	8 Gr1	8.1	F316-F304-F309-F347		ST21 (SFA-5.21 ERCoCr-E) sp. 2
KIR-AS-27 Rev.0	KIR-EN-27 Rev.0	PTA	25	6 Gr1	7.2	AISI 410 - 1.4122		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-28 Rev.0	KIR-EN-28 Rev.0	PTA	25	10H Gr1	10.1	F51-F52-F53-F55		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-29 Rev.0	KIR-EN-29 Rev.0	PTA	25	10H Gr1	10.1	F51-F52-F53-F55		ST12 (SFA-5.21 ERCoCr-B) sp. 2
KIR-AS-38 Rev.0	KIR-EN-38 Rev.0	PTA	25	10H Gr1	10.1	F51-F52-F53-F55		ST21 (SFA-5.21 ERCoCr-E) sp. 2
KIR-AS-30 Rev.0	KIR-EN-30 Rev.0	PTA	25					ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-31 Rev.0	KIR-EN-31 Rev.0	PTA	25	8 Gr4	8.2	F44	INC600 sp. 1,5	ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-33 Rev.0	KIR-EN-33 Rev.0	PTA	25	42	42	MONEL 400	INC600 sp. 1,5	ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-34 Rev.0	KIR-EN-34 Rev.0	PTA	25	42	42	MONEL K500	INC600 sp. 1,5	ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-39 Rev.0	KIR-EN-39 Rev.0	PTA	25	43	43	INC625		ST6 (SFA-5.21 ERCoCr-A) sp. 2
KIR-AS-40 Rev.0	KIR-EN-40 Rev.0	PTA	25	45	45	INC825		ST6 (SFA-5.21 ERCoCr-A) sp. 2

Totale: PQR-WPS ASME IX + PED n°40
PQR-WPS EN ISO 15609 n°40

Data: 16/01/2025 Rev.0

Emesso da: A.Pagani