

#### No. 11VE00146PP91

Brazer's name	BERETTA GUALTIERO	Stamp	No. BG		
Born in	MILANO (MI)	on	20/04/1968		
Employed by BERETTA GUALTIERO-TREZZANO SUL NAVIGLIO (MI)					

Manufacturer's brazing procedure reference No.: 01/11 Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31	ISO 15608: Group 31
Filler metal type/designation	UNI EN 1044:CP 104	UNI EN 1044:CP 104
Flux type/designation	N.A.	N.A.
Test pieces thickness (mm)	1	0.5 to 2
Pipe outside diameter (mm)	6	6 to 12
Brazing position(s)	Horizontal-Flow	Horizontal-Flow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	10	Max. 12.5
Clearance (mm)	According to relevant BPS	According to relevant BPS

				Type of test			
Visual	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable
Shear	Not Tested	Peel	Not Tested	Bend	Not Tested	Tensile	Not Tested

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Cript Code: 9P97167VELmNP161748235569616145M



#### No. 11VE00146PP92

Brazer's name	BERETTA GUALTIERO	Stamp N	No. BG
Born in	MILANO (MI)	on	20/04/1968
Employed by	BERETTA GUALTIERO-TREZZANO SUL NAVIGLIO (MI	)	

Manufacturer's brazing procedure reference No.:

02/11

Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31	ISO 15608: Group 31
Filler metal type/designation	UNI EN 1044:CP 104	UNI EN 1044:CP 104
Flux type/designation	N.A.	N.A.
Test pieces thickness (mm)	1	0.5 to 2
Pipe outside diameter (mm)	12	12 to 24
Brazing position(s)	Horizontal-Flow	Horizontal-Flow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	10	Max. 12.5
Clearance (mm)	According to relevant BPS	According to relevant BPS

		None		Type of test		(7	-	
Visual	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable	
Shear	Not Tested	Peel	Not Tested	Bend	Not Tested	Tensile	Not Tested	

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Cript Code: 6P11717261V984ER5125zA6329PG9186



#### No. 11VE00146PP93

Brazer's name	BERETTA GUALTIERO	Stamp N	No. <b>BG</b>	
Born in	MILANO (MI)	on	20/04/1968	
Employed by BERETTA GUALTIERO-TREZZANO SUL NAVIGLIO (MI)				

Manufacturer's brazing procedure reference No.: 03/11 Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31	ISO 15608: Group 31
Filler metal type/designation	UNI EN 1044:CP 104	UNI EN 1044:CP 104
Flux type/designation	N.A.	N.A.
Test pieces thickness (mm)	1	0.5 to 2
Pipe outside diameter (mm)	28	25 and over
Brazing position(s)	Horizontal-Flow	Horizontal-Flow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	10	Max. 12.5
Clearance (mm)	According to relevant BPS	According to relevant BPS

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Visual	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable
Shear	Not Tested	Peel	Not Tested	Bend	Not Tested	Tensile	Not Tested

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Cript Code: 16E94F7V9693136435941291dP5G84P33



#### No. 11VE00146PP94

Brazer's name	BERETTA GUALTIERO	Stamp N		
Born in	MILANO (MI)	on	20/04/1968	
Employed by	BERETTA GUALTIERO-TREZZANO SUL NAVIGLIO (MI			

Manufacturer's brazing procedure reference No.:

04/11

Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31	ISO 15608: Group 31
Filler metal type/designation	UNI EN 1044:CP 104	UNI EN 1044:CP 104
Flux type/designation	N.A.	N.A.
Test pieces thickness (mm)	1	0.5 to 2
Pipe outside diameter (mm)	6	6 to 12
Brazing position(s)	Vertical-Upflow	Vertical-Upflow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	10	Max. 12.5
Clearance (mm)	According to relevant BPS	According to relevant BPS

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Visuai	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable
Shear	Not Tested	Peel	Not Tested	Bend	Not Tested	Tensile	Not Tested

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#### No. 11VE00146PP95

Brazer's name	BERETTA GUALTIERO	Stamp No	. BG	
Born in	MILANO (MI)		20/04/1968	
Employed by BERETTA GUALTIERO-TREZZANO SUL NAVIGLIO (MI)				

Manufacturer's brazing procedure reference No.:

05/11

Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31	ISO 15608: Group 31
Filler metal type/designation	UNI EN 1044:CP 104	UNI EN 1044:CP 104
Flux type/designation	N.A.	N.A.
Test pieces thickness (mm)	1	0.5 to 2
Pipe outside diameter (mm)	12	12 to 24
Brazing position(s)	Vertical-Upflow	Vertical-Upflow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	10	Max. 12.5
Clearance (mm)	According to relevant BPS	According to relevant BPS

	en e	en. B	- 1	Type of test		<u>.</u>		
Visual	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable	
Shear	Not Tested	Peel	Not Tested	Bend	Not Tested	Tensile	Not Tested	

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#### No. 11VE00146PP96

		COMPANY OF THE STATE OF THE STA	
Brazer's name	BERETTA GUALTIERO	Stamp N	
Born in	MILANO (MI)	on	20/04/1968
Employed by	BERETTA GUALTIERO-TREZZANO SUL NAVIGLIO (MI		

Manufacturer's brazing procedure reference No.:

06/11

Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31	ISO 15608: Group 31
Filler metal type/designation	UNI EN 1044:CP 104	UNI EN 1044:CP 104
Flux type/designation	N.A.	N.A.
Test pieces thickness (mm)	1	0.5 to 2
Pipe outside diameter (mm)	28	25 and over
Brazing position(s)	Vertical-Upflow	Vertical-Upflow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	10	Max. 12.5
Clearance (mm)	According to relevant BPS	According to relevant BPS

	:	and the second of the second o		Type of test			
Visual	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable
Shear	Not Tested	Peel	Not Tested	Bend	Not Tested	Tensile	Not Tested

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#### No. 11VE00146PP97

Brazer's name	BERETTA GUALTIERO	Stamp	No. BG
Born in	MILANO (MI)	on	20/04/1968
Employed by	BERETTA GUALTIERO-TREZZANO SUL NAVIGL	IO (MI)	

Manufacturer's brazing procedure reference No.: 07/11 Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31	ISO 15608: Group 31
Filler metal type/designation	UNI EN AG 306	UNI EN AG 306
Flux type/designation	N.A.	N.A.
Test pieces thickness (mm)	6	1.6 to 12
Pipe outside diameter (mm)	6	6 to 12
Brazing position(s)	Horizontal-Flow	Horizontal-Flow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	7	Max. 8.75
Clearance (mm)	According to relevant BPS	According to relevant BPS

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Visual	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable
Shear	Not Tested	Peei	Not Tested	Bend	Not Tested	Tensile	Not Tested

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#### No. 11VE00146PP98

Brazer's name	BERETTA GUALTIERO	Stamp N	No. BG
Born in	MILANO (MI)	on	20/04/1968
Employed by	BERETTA GUALTIERO-TREZZANO SUL NAVIGLIO (MI	)	

Manufacturer's brazing procedure reference No.:

08/11

Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31	ISO 15608: Group 31
Filler metal type/designation	UNI EN AG 306	UNI EN AG 306
Flux type/designation	N.A.	N.A.
Test pieces thickness (mm)	6	1.6 to 12
Pipe outside diameter (mm)	12	12 to 24
Brazing position(s)	Horizontal-Flow	Horizontal-Flow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	7	Max. 8.75
Clearance (mm)	According to relevant BPS	According to relevant BPS

				Type of test	14		
Visual	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable
Shear	Not Tested	Peel	Not Tested	Bend	Not Tested	Tensile	Not Tested

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#### No. 11VE00146PP99

Brazer's name	BERETTA GUALTIERO	Stamp	No. BG
Born in	MILANO (MI)	on	20/04/1968
Employed by	BERETTA GUALTIERO-TREZZANO SUL NAVIGLIO (M		

Manufacturer's brazing procedure reference No.:

09/11

Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31	ISO 15608: Group 31
Filler metal type/designation	UNI EN AG 306	UNI EN AG 306
Flux type/designation	N.A.	N.A.
Test pieces thickness (mm)	6	1.6 to 12
Pipe outside diameter (mm)	28	25 and over
Brazing position(s)	Horizontal-Flow	Horizontal-Flow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	7	Max. 8.75
Clearance (mm)	According to relevant BPS	According to relevant BPS

	- "		213, 1	Type of test			
Visual	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable
Shear	Not Tested	Peel	Not Tested	Bend	Not Tested	Tensile	Not Tested

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Cript Code: 329816P99668595R99E91V19331G1P4M6



#### No. 11VE00146PP100

Brazer's name	BERETTA GUALTIERO	Stamp	No. BG	
Born in	MILANO (MI)	on	20/04/1968	
Employed by BERETTA GUALTIERO-TREZZANO SUL NAVIGLIO (MI)				

Manufacturer's brazing procedure reference No.:

10/11

Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31 to 32	ISO 15608: Group 31 to Group 32
Filler metal type/designation	UNI EN AG 306	UNI EN AG 306
Flux type/designation	N.A.	N.A.
Test pieces thickness (mm)	6	1.6 to 12
Pipe outside diameter (mm)	6	6 to 12
Brazing position(s)	Vertical-Upflow	Vertical-Upflow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	7	Max. 8.75
Clearance (mm)	According to relevant BPS	According to relevant BPS

				Type of test		, v. 1	· ·
Visual	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable
Shear	Not Tested	Peel	Not Tested	Bend	Not Tested	Tensile	Not Tested

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Cript Code: a3c919549E91oP1RPV334Ab1PE27642M16



#### No. 11VE00146PP101

Brazer's name	BERETTA GUALTIERO	Stamp N	
Born in	MILANO (MI)	on	20/04/1968
Employed by	BERETTA GUALTIERO-TREZZANO SUL NAVIGLIO (MI)		

Manufacturer's brazing procedure reference No.:

11/11

Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31 to 32	ISO 15608: Group 31 to Group 32
Filler metal type/designation	UNI EN AG 306	UNI EN AG 306
Flux type/designation	N.A.	N.A.
Test pieces thickness (mm)	6	1.6 to 12
Pipe outside diameter (mm)	12	12 to 24
Brazing position(s)	Vertical-Upflow	Vertical-Upflow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	7	Max. 8.75
Clearance (mm)	According to relevant BPS	According to relevant BPS

				Type of test			
Visual	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable
Shear	Not Tested	Peel	Not Tested	Bend	Not Tested	Tensile	Not Tested

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Cript Code: 53462494884103q9P16VP81CE8fG91V61



#### No. 11VE00146PP102

Brazer's name	BERETTA GUALTIERO	Stamp N	
Born in	MILANO (MI)	on	20/04/1968
Employed by	BERETTA GUALTIERO-TREZZANO SUL NAVIGLIO (MI)		

Manufacturer's brazing procedure reference No.:

12/11

Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31 to 32	ISO 15608: Group 31 to Group 32
Filler metal type/designation	UNI EN AG 306	UNI EN AG 306
Flux type/designation	N.A.	N.A.
Test pieces thickness (mm)	6	1.6 to 12
Pipe outside diameter (mm)	28	25 and over
Brazing position(s)	Vertical-Upflow	Vertical-Upflow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	7	Max. 8.75
Clearance (mm)	According to relevant BPS	According to relevant BPS

	. "			Type of test	in the second	_ "	
Visual	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable
Shear	Not Tested	Peel	Not Tested	Bend	Not Tested	Tensile	Not Tested

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Cript Code: 532P9F1HV16486P413E42616d87G122590



#### No. 11VE00146PP103

Brazer's name	BERETTA GUALTIERO	Stamp N	No.	BG	
Born in	MILANO (MI)	on		4/1968	
Employed by BERETTA GUALTIERO-TREZZANO SUL NAVIGLIO (MI)					

Manufacturer's brazing procedure reference No.:

13/11

Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31 to 32	ISO 15608: Group 31 to Group 32
Filler metal type/designation	UNI EN AG 106	UNI EN AG 106
Flux type/designation	CASTOLIN FLUX 1020 FH10	CASTOLIN FLUX 1020 FH10
Test pieces thickness (mm)	1.5	0.75 to 3
Pipe outside diameter (mm)	12	12 to 24
Brazing position(s)	Horizontal-Flow	Horizontal-Flow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	10	Max. 12.5
Clearance (mm)	According to relevant BPS	According to relevant BPS

	- "	1		Type of test			
Visual	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable
Shear	Not Tested	Peel	Not Tested	Bend	Not Tested	Tensile	Not Tested

This certificate is valid until October 2014						
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Cript Code: 71cD43E1i5819498V15V4A1P1458h366P



#### No. 11VE00146PP104

Brazer's name BERETTA GUALTIERO Stamp No. BG					
Born in	MILANO (MI)	on -	20/04/1968		
			**************************************		
Employed by	BERETTA GUALTIERO-TREZZANO SUL NAVIGL	• •			

Manufacturer's brazing procedure reference No.:

14/11

Job knowledge: not tested

Brazing variables	Test details	Range of approval
Brazing process	Hand torch	Hand torch
Joint type	Lap joint	Lap joint
Parent material(s)	31 to 32	ISO 15608: Group 31 to Group 32
Filler metal type/designation	UNI EN AG 106	UNI EN AG 106
Flux type/designation	CASTOLIN FLUX 1020 FH10	CASTOLIN FLUX 1020 FH10
Test pieces thickness (mm)	1.5	0.75 to 3
Pipe outside diameter (mm)	28	25 and over
Brazing position(s)	Horizontal-Flow	Horizontal-Flow; Vertical-Downflow
Type of heating gas	C2H2+O2	C2H2+O2
Torch type/gas flow	315 lt/h	315 lt/h
Overlap (mm)	10	Max. 12.5
Clearance (mm)	According to relevant BPS	According to relevant BPS

	e :		·	Type of test		1	
Visual	Acceptable	Radiographic	Not Tested	Penetrant	Not Tested	Metallographic	Acceptable
Shear	Not Tested	Peel	Not Tested	Bend	Not Tested	Tensile	Not Tested

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