

BRAZER'S APPROVAL CERTIFICATE
 ACCORDING TO UNI EN 13133:2002



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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BRAZER'S APPROVAL CERTIFICATE
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No. 11VE00146PP92

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.: 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

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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**BRAZER'S APPROVAL CERTIFICATE
ACCORDING TO UNI EN 13133:2002**



No. 11VE00146PP93

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.: **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

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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**BRAZER'S APPROVAL CERTIFICATE
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No. **11VE00146PP94**

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.: **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

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. **11VE00146PP95**

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.: **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

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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BRAZER'S APPROVAL CERTIFICATE
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No. **11VE00146PP96**

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.: **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

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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**BRAZER'S APPROVAL CERTIFICATE
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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 NAVIGLIO (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

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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BRAZER'S APPROVAL CERTIFICATE
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No. **11VE00146PP98**

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.: **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							
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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**BRAZER'S APPROVAL CERTIFICATE
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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 (MI)		

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

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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**BRAZER'S APPROVAL CERTIFICATE
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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							
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. **11VE00146PP101**

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.: **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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BRAZER'S APPROVAL CERTIFICATE
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No. **11VE00146PP102**

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.: **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							
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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**BRAZER'S APPROVAL CERTIFICATE
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No. **11VE00146PP103**

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.: **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

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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**BRAZER'S APPROVAL CERTIFICATE
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No. **11VE00146PP104**

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.: **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

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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