

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



No. **12VE00042PP16**

Brazer's name	FAVA LUCA	Stamp No.	FL
Born in	MODENA (MO)	on	03/06/1965
Employed by	MARCHI S.R.L. - MODENA (MO)		

Manufacturer's brazing procedure reference No.: **03/2003** 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)	ISO/TR 15608: Group 31	ISO/TR 15608: Group 31
Filler metal type/designation	UNI EN ISO 17672:CuP279	UNI EN ISO 17672:CuP279
Flux type/designation	EN 1045:FH 10	EN 1045:FH 10
Test pieces thickness (mm)	1.2	0.6 to 2.4
Pipe outside diameter (mm)	28	25 and over
Brazing position(s)	Horizontal-flow	Horizontal-flow; Vertical-Downflow
Type of heating gas	ACETYLENE + OXYGEN	ACETYLENE + OXYGEN
Torch type/gas flow	500 lt/h	500 lt/h
Overlap (mm)	20	Max. 25
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

This certificate is valid until	April 2015		
Issued at	GENOVA	on	12 April 2012

This certificate consist of 2 pages

Il contenuto del presente documento costituisce materiale riservato e soggetto a copyright.

Form EN 13133-11

RINA Services S.p.A.
Via Corsica 12 - 16128 Genova



Cript Code:
4B44e97132724577PEV3146E5916hI552