

Date: Jun/25/2018

Prepared for:	Serge Vienn	eau Branch	: Monc	ton	
Sample Descripti	on: We	eld Coupons - 5052	_	Welder ID Number:	5302
Standard/Specif	ication:	ASMF IX: OW	/-160 Guided I	Bend Test	

#### **Test Results**

	Visual			
	Examination of			
Sample ID	Weld	Location	Bend Test	Comments
1G	Pass	Face	Pass	
2G	Pass		Pass	
3G	Pass		Pass	
4G	Pass		Pass	
1G	Pass	Root	Pass	
2G	Pass		Pass	
3G	Pass		Pass	
4G	Pass		Pass	

#### **Test Findings**

Coupons passed bend test for all positions.

#### Recommendations

No recommendations needed.

Test Preformed By:

Scott Gira

Test Date: Jun/25/2018

## PATIONAL ENERGY EQUIPMENT INC.

### Welding Performance Qualification (WPQ)

The state of the s		troining i orionianos adamination (**)		
Form Number:NEE-FRM-019	Page 1 of 1	Revision: 0		
Welders Name: Serge WPS Used: H-MBF- Base Metal: 5052	Vienzeau 1432	Identification Number: 5302  Test Coupon: /G  Thickness: /// "		
Welding process Type of Welder Plate or Pipe Base Metal Filler Metal Spec	Actual Values  GMAW  Semi Auto  Plate  5052-H32	Range Values  GMAW  Seni Auto  Plate  5052-H32		
Filler Metal Class Filler Metal Consumable Insert Filler Type	AWS 510 ER 5356 Aluminum	AWS 510 ER 5356 Aluminum		
Position/Progression Inert Gas Used Voltage Amperage	Flat (19) /1 99,99 % A 22.5 Anto			
Transfer Mode Welder Polarity Cleaning Type	Spray Arc DCRP Wire Bruch	Spray Arc DCRP Wire Brush		
Welder and Welding Supervisor are accordance with requirements of Sec Welding Supervisor:  Location:  Welding Supervisor:  Derek	etion IX of the ASME Code.			
Visual Examina Type of Test: Code: ASIM	Results of Bendation of Complete Weld: Bendation	Root or Face  Result: FC. 55		
Visual Examination of Complete Weld:  Type of Test: Bend Roof or Face  Code: ASME IX Result: Pass				
Mechanical Test Preformed by: _S Location: : NEE Winniper	Scott Gica	Signature:		
requirements of Section IX of ASMI		e test coupons were tested in accordance with the		
Date: Jun/25/1018 Organization: National Energy Equipment Name: Muslow/k Signature:				

# PATIONAL ENERGY EQUIPMENT INC.

# Welding Performance Qualification (WPQ)

Form Number:NEE-FRM-019	Page 1 of 1	Revision:	0
Welders Name: Serge WPS Used: H-WBH-Base Metal: 5052	ienseau - H32		ication Number: 53 02 oupon: 2 a less: 44"
	Actual Values		Range Values
Welding process	amaw	_	S M A W
Type of Welder	Semi Auto		Semi Auto
Plate or Pipe	Plate	<b></b>	Plato
Base Metal	5052 - H 32	<del>-</del>	5052 - H33
Filler Metal Spec	AWS -510		AWS- 510
Filler Metal Class	ER 5356		ER-5356
Filler Metal	Aluminum	-	Aluminum
Consumable Insert			
Filler Type	Wire	_	W:se
Position /Progression	Horizontal 129	V UH	Hosizental (2G)/UH
Inert Gas Used	99,99 % Ar		99.99 % AC
Voltage	24	_	21-24
Amperage	Anto	_	205-220
Transfer Mode	Spray Arc		Sprau Arc
Welder Polarity	DCRP	<del>.</del> -	DCRP
Cleaning Type	Wire Brush	<u>.</u> .	Wire Brush
Welder and Welding Supervisor are accordance with requirements of Se			prepared and welded in
$\sim$ (			MAL
Welding Supervisor: Derek	Lites	Signature:	Witte
Location: DEET - VA	encha (UB		
Visual Examina Type of Test: Code: <u>ASi</u> M	Results of Bendation of Complete Weld:  Bend E TX	Root or Result:	
Visual Examin: Type of Test: Code: <u>ASF</u> V	tion of Complete Weld: Berc EIX	Root or F Result:	S Pace Pacs'S
Mechanical Test Preformed by: S Location: : NEE Winnipe	cott bira	Signature	:: latte
We certify that the statement in the requirements of Section IX of ASM		e test coupe	ons were tested in accordance with the
Date: Jun/25/2018 Name: Chine Coulle	Organiz		tional time gy Equipment



# Welding Performance Qualification (WPQ)

Form Number:NEE-FRM-019 Page 1 of 1		Revision: 0		
Welders Name: Serge WPS Used: A-MBI Base Metal: 5052 - A	Vienneau 1-1 132	Identification Number: 5302 Test Coupon: 36 Thickness: 44"		
Welding process Type of Welder Plate or Pipe Base Metal Filler Metal Spec Filler Metal Class Filler Metal Consumable Insert Filler Type Position /Progressi Inert Gas Used	Wire	Range Values  GMAW  Semi Anto  Plate  5052-H32  AWS 510  ER 5356  Alminym  Wire  JUH  Verticle (3G)/UH  GGGG 9/0Ar		
Voltage Amperage Transfer Mode Welder Polarity Cleaning Type	22.5  Auto Spray Arc DCRP Wire Brush  are responsible for the test cou Section IX of the ASME Code.	21-24  185-205  Stray Arc  DCRP  Wire Brush  pons being prepared and welded in		
	Results of Bengination of Complete Weld:	Root or Cace  Result: (4.3.5		
Visual Examination of Complete Weld:  Type of Test:  Bey Roof or Face  Roof or Face  Result:  Result:  Roof or Face  Result:  Result:  Result:  Roof or Face  Result:  Result:  Roof or Face  Result:  Re				
We certify that the statement in the record is correct and that the test coupons were tested in accordance with the requirements of Section IX of ASME Code.  Date: Jun/25/2018 Organization: National Energy Egylpment Signature: Signature:				

## FZ NATIONAL ENERGY EQUIPMENT INC.

PE EQUIPMENT INC.		Welding Performance Qualification (WPQ)		
Form Number:NEE-FRM-019	Page 1 of 1	Revision: 0		
Welders Name: Serge WPS Used: A-MBO-Base Metal: 5052-H	Jienzeau 1 32	Identification Number: 5302 Test Coupon: 49 Thickness: 14"		
Welding process  Type of Welder  Plate or Pipe  Base Metal  Filler Metal Spec  Filler Metal Class  Filler Metal  Consumable Insert  Filler Type  Position /Progression  Inert Gas Used  Voltage  Amperage  Transfer Mode  Welder Polarity  Cleaning Type	Aq. Aq o/o Ar 24 Ay. +00 Spray Arc DCRP Wire Brush	AWS-510  ER 5356  Aluminum  Wire  Overhead (4G) UH  99.99 % AC  21-24  200-200  Spray Acc  DCRP  Wice Brush		
Welder and Welding Supervisor are raccordance with requirements of Sective Welding Supervisor:  Decek  Location:  NEET-Mo-	ion IX of the ASME Code.	Signature:		
	Results of Bend on of Complete Weld:	Root or Cace)  Result:   Cass		
Visual Examinati Type of Test: _ Code:ASINE	on of Complete Weld:	Roof or Face Result: Pass		
Mechanical Test Preformed by: So Location: NEE Winniper	of Gira	Signature:		
We certify that the statement in the re requirements of Section IX of ASME		e test coupons were tested in accordance with the		
Date: Jun/25/2018 Name: Cher level	Organiz Signatur	ation: National Gregy Equipment		