

Prepared for: Michael Cross Branch: Dartmouth

Sample Description: Coupons - 6061 Welder ID Number: 6421

Standard/Specification: ASME IX: QW-160 Guided Bend Test

Test Results

Sample ID	Visual Examination of 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

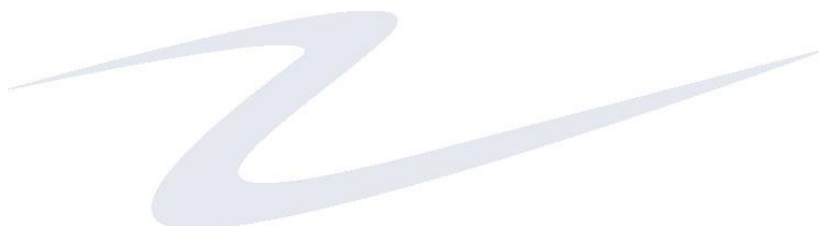
All positions passed bend test.

Recommendations

No recommendations needed.

Test Performed By: 
Scott Gira

Test Date: JUN/25/2018





Welding Performance Qualification (WPQ)

Form Number: NEE-FRM-019

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Revision: 1

Welders Name: Michael Cross
WPS Used: A-MBF-2
Base Metal: 6061

Identification Number: 6421
Test Coupon: 1G
Thickness: 1/4"

Table with 3 columns: Parameter, Actual Values, Range Values. Rows include Welding process (GMAW), Type of Welder (Semi Auto), Plate or Pipe (Plate), Base Metal (6061), Filler Metal Spec (AWS 5.10), Filler Metal Class (ER5356), Filler Metal (Aluminum), Consumable Insert, Filler Type (Wire), Position/ Progression (Flat 1G/ Uphill), Inert Gas Used (99.99% Argon), Voltage (24.2), Amperage (Auto), Transfer Mode (Spray Arc), Welder Polarity (DCRP), Cleaning Type (Wire Brush).

Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordance with requirements of Section IX of the ASME Code.

Welding Supervisor: Robert Ward
Location: Dartmouth Shop

Signature: Robert Ward

Results of Bend Test

Visual Examination of Complete Weld: Pass
Type of Test: Bend
Code: ASME IX
Root or Face: Face
Result: Pass

Visual Examination of Complete Weld: Pass
Type of Test: Bend
Code: ASME IX
Root or Face: Face
Result: Pass

Mechanical Test Performed by: Scott Gira
Location: NEE Winnipeg

Signature: Scott Gira

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/25/18
Name: Zanyar Farhadi

Organization: National Energy Equipment
Signature: Zanyar Farhadi



Welding Performance Qualification (WPQ)

Form Number: NEE-FRM-019

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Revision: 1

Welders Name: Michael Cross
WPS Used: A-MBH-1
Base Metal: 6061

Identification Number: 6421
Test Coupon: 2G
Thickness: 1/4"

Table with 3 columns: Parameter, Actual Values, Range Values. Rows include 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.

Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordance with requirements of Section IX of the ASME Code.

Welding Supervisor: Robert Ward
Location: Dartmouth Shop

Signature: Robert Ward

Results of Bend Test

Visual Examination of Complete Weld: PASS
Type of Test: Bend
Code: ASME IX
Result: PASS

Visual Examination of Complete Weld: PASS
Type of Test: Bend
Code: ASME IX
Result: PASS

Mechanical Test Performed by: Scott Gira
Location: NEE Winnipeg

Signature: Scott Gira

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/25/18
Name: Zanyar Farhadi

Organization: National Energy Equipment
Signature: Zanyar Farhadi

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Revision: 1

Welders Name: Michael Cross
 WPS Used: A-MBV-1
 Base Metal: 6061

Identification Number: 6421
 Test Coupon: 3G
 Thickness: 1/4"

	Actual Values	Range Values
Welding process	GMAW	GMAW
Type of Welder	Semi Auto	Semi Auto
Plate or Pipe	Plate	Plate
Base Metal	6061	6061
Filler Metal Spec	AWS 5.10	AWS 5.10
Filler Metal Class	ER5356	ER5356
Filler Metal	Aluminum	Aluminum
Consumable Insert		
Filler Type	Wire	Wire
Position/ Progression	Vertical 3G/ Uphill	Vertical 3G/ Uphill
Inert Gas Used	99.99% Argon	99.99% Argon
Voltage	<u>24.2</u>	22-25
Amperage	Auto	190-210
Transfer Mode	Spray Arc	Spray Arc
Welder Polarity	DCRP	DCRP
Cleaning Type	Wire Brush	Wire Brush

Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordance with requirements of Section IX of the ASME Code.

Welding Supervisor: Robert Ward
 Location: Dartmouth Shop

Signature: Robert Ward

Results of Bend Test

Visual Examination of Complete Weld: Pass
 Type of Test: Bend
 Code: ASME IX
 Root or Face: Pass
 Result: Pass

Visual Examination of Complete Weld: Pass
 Type of Test: Bend
 Code: ASME IX
 Root or Face: Pass
 Result: Pass

Mechanical Test Performed by: Scott Gira
 Location: NEE Winnipeg

Signature: Scott Gira

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/25/18
 Name: Zangar Farhadi

Organization: National Energy Equipment
 Signature: Zangar Farhadi



Welding Performance Qualification (WPQ)

Form Number: NEE-FRM-019

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Revision: 1

Welders Name: Michael Cross
WPS Used: A-MBO-2
Base Metal: 6061

Identification Number: 6421
Test Coupon: 4G
Thickness: 1/4"

Table with 3 columns: Parameter, Actual Values, Range Values. Rows include Welding process (GMAW), Type of Welder (Semi Auto), Plate or Pipe (Plate), Base Metal (6061), Filler Metal Spec (AWS 5.10), Filler Metal Class (ER5356), Filler Metal (Aluminum), Consumable Insert, Filler Type (Wire), Position/ Progression (Overhead 4G/ Uphill), Inert Gas Used (99.99% Argon), Voltage (21-22), Amperage (Auto), Transfer Mode (Spray Arc), Welder Polarity (DCRP), Cleaning Type (Wire Brush).

Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordance with requirements of Section IX of the ASME Code.

Welding Supervisor: Robert Ward
Location: Dartmouth Shop

Signature: Robert Ward

Results of Bend Test

Visual Examination of Complete Weld: Pass
Type of Test: Bend
Code: ASME IX
Root or Face: Pass
Result: Pass

Visual Examination of Complete Weld: Pass
Type of Test: Bend
Code: ASME IX
Root or Face: Pass
Result: Pass

Mechanical Test Performed by: Scott Gira
Location: NEE Winnipeg

Signature: Scott Gira

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/25/18
Name: Zangar Farhadi

Organization: National Energy Equipment
Signature: Zangar Farhadi