

Date: JUN/25/2018

Prepared for: _	Micha	el Cross	Branch:	Dartmou	ıth	
Sample Descrip	tion:	Coupons	- 5052	V	Velder ID Number:	6421
Standard/Spec	ification:	AS	ME IX: QW-1	60 Guided Be	end 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** 

All positions passed bend test.

Recommendations

No recommendations needed.

Test Preformed By:

Scott Gira

Test Date: JUN/25/2018



## Welding Performance Qualification (WPQ)

Form Number:NEE-FRM-019	Page 1 of 1	Revision: 1		
Welders Name: Michael Cross WPS Used: A-MBF-1 Base Metal: 5052		Identification Number: 6421 Test Coupon: 16 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	5052	5052		
Filler Metal Spec	AWS 5.10	AWS 5.10		
Filler Metal Clas	ER5356	ER5356		
Filler Metal	Aluminum	Aluminum		
Consumable Inse	ert			
Filler Type	Wire	Wire		
Position/ Progress	on Flat 1G/ Uphill	Flat 1G/ Uphill		
Inert Gas Used	99.99% Argon	99.99% Argon		
Voltage	23.0	22-25		
Amperage	Auto	230-260		
Transfer Mode	Spray Arc	Spray Arc		
Welder Polarity	DCRP	DCRP		
Cleaning Type	Wire Brush	Wire Brush		
Welding Supervisor:  Location:  Dartmouth S  Visual Ex	che ASME Code.  Chop  Results of Be amination of Complete Weld:	Signature:  Note: Signature: Root on Race		
Type of T Code:	SMEIX	Result: Result:		
	amination of Complete Weld: est: Be, V KiME IX	Root or Face Result:		
Mechanical Test Preformed t	oy: Scott Gira	Signature:		
Location: : NEE W.O	n:peg			
Location: : NEE W.O	in the record is correct and that ASME Code.	the test coupons were tested in accordance with the  nization: National Energy Equipment  ture:		

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Form Number:NEE-FRM-019	Page 1 of 1	Revision: 1
Welders Name: Michael Cross	,	Identification Number: 6421
WPS Used: A-MBH-1 Base Metal: 5052		Test Coupon: 2G Thickness: 1/4*
Dasc Wetar.		Tinekness:
	Actual Values	Range Values
Welding process	GMAW	GMAW
Type of Welder	Semi Auto	Semi Auto
Plate or Pipe	Plate	Plate
Base Metal	5052	5052
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	Horizontal 2G/ Uphill	Horizontal 2G/ Uphill
Inert Gas Used	99.99% Argon	99.99% Argon
Voltage	23.0	21-24
Amperage	Auto	205-220
Transfer Mode	Spray Arc	Spray Arc
Welder Polarity	DCRP	DCRP
Cleaning Type	Wire Brush	Wire Brush
Welder and Welding Supervisor at requirements of Section IX of the A Welding Supervisor:  Location:  Dartmouth Shop	ASME Code. Luard.	pons being prepared and welded in accordance with  Signature: Roll-Ward.
Type of Test: Code:		Result: Pass
Type of Test: Code:	Bend SINE TX	Roof or Face Result: Pas 5
Mechanical Test Preformed by: _ Location: : NEE Winnipe		Signature:
We certify that the statement in the requirements of Section IX of ASF	ME Code.	he test coupons were tested in accordance with the
Date: <u>Jun /25/18</u> Name: Zanyar Farhadi	Organi Signati	re: Rational Energy Equipment
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## Welding Performance Qualification (WPQ)

Form Number:NEE-FRM-019 Page 1 of 1			Revision: 1		
Welders Na WPS Used: Base Metal			Identification Number: 6421 Test Coupon: 36 Thickness: 1/4"		
		Actual Values	Panga Values		
	Welding process	GMAW	Range Values		
	Type of Welder	Semi Auto	Semi Auto		
	Plate or Pipe	Plate	Plate		
	Base Metal	5052			
	Filler Metal Spec	AWS 5.10			
	Filler Metal Class	ER5356			
	Filler Metal	Aluminum			
	Consumable Insert	Autimati	Aluminum		
	Filler Type	Wire			
	Position/ Progression	Vertical 3G/ Uphill			
	Inert Gas Used	99.99% Argon	Vertical 3G/ Uphill		
	Voltage	**************************************	99.99% Argon 21-24		
	Amperage	ころ、C) Auto			
	Transfer Mode		185-205		
	Welder Polarity	Spray Arc	Spray Arc		
	Cleaning Type	DCRP	DCRP		
	Cleaning Type	Wire Brush	Wire Brush		
	oervisor: Robe A  Dartmouth Shop	Results of Be	Signature: Ross Root of Face		
	Code: ASi	NE IX	Result: 125		
	Visual Examin Type of Test: Code:	nation of Complete Weld:  Bend  SIME IX	Root or Face Result: Pass		
Mechanical	Test Preformed by: _ NEE Winnipe	Sat brian	Signature:		
	that the statement in the ts of Section IX of ASI		the test coupons were tested in accordance with the		
Date: Jun Name: -	/ZS/18 anyar Farhadi	Orgai	ization: National Energy Equipment		



## Welding Performance Qualification (WPQ)

Form Number:NEE-FRM-019 Page 1 of 1			Revision: 1		
Welders Name: Name: WPS Used: A-MBO-Base Metal: 5052			Identification Number: 6421 Test Coupon: 46 Thickness: 114		
		Actual Values	Range Values		
Weld	ling process	GMAW	GMAW		
	e of Welder	Semi Auto	Semi Auto		
• •	or Pipe	Plate	Plate		
	Metal	5052	5052		
	r Metal Spec	AWS 5.10	AWS 5.10		
	r Metal Class	ER5356	ER5356		
	r Metal	Aluminum	Aluminum		
	sumable Insert	7 ttarimani	Administra		
	r Туре	Wire	Wire		
	ion/ Progression	Overhead 4G/ Uphill	Overhead 4G/ Uphill		
	t Gas Used	99.99% Argon	99.99% Argon		
Volt	age	230	21-24		
Amp	erage	Auto	200-220		
	isfer Mode	Spray Arc	Spray Arc		
Weld	ler Polarity	DCRP	DCRP		
Clea	ning Type	Wire Brush	Wire Brush		
requirements of Se Welding Superviso	ction IX of the	ASME Code. Huand.	Signature:		
	Visual Examination Type of Test:	Results of Bernation of Complete Weld: Bena ME IX	Root or Face Result: Pass		
	Visual Exami Type of Test: Code: AS	nation of Complete Weld:	Result:		
Mechanical Test   Location: :	Preformed by: _ SME IX	Scott Gira	Signature:		
We certify that th requirements of S			the test coupons were tested in accordance with the		
3	- 116				
Date: Jin	25/18	Organ	ization: National Energy Equipment		