

Date: May/11/2018

Prepared for:	Jeremy Newhook	Branch:	Mount Pearl, NF	

Sample Description: Weld Test Coupons - 6061 Welder ID Number: E2228

Standard/Specification: ASME IX: QW-160 Guided 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

All position passed.

Recommendations

No recommendations needed.

Test Preformed By:

Scott Gira

Test Date: May/11/2018



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Welders Name	Jeremy Newhook	Identif	ication numbe	e r E2228	
WPS used	A-MBF-2	Test Co	nogue	1G	
Base Metal	6061 T6	Thickne	-	1/4"	
		Actual Values	Rai	nge Values	
Welding proces	SS	GMAW		AW	
Type of Welder		SEMI AUTO		//I AUTO	
Plate or Pipe		PLATE			
Base metal		6061 T6		05/6061/6063/6111/6351	
Filler Metal spe	ecs	AWS 5.10		S 5.10	
Filler Metal cla		ER5356		356	
Filler Metal		ALUMINUM		JMINUM	
Consumable In	sert	ALCIVIIIVOIVI		NAME OF THE PROPERTY OF THE PR	
Filler Type	3010	WIRE	— WII	RF	
Weld position/	nrogression	1G FLAT/Uphill	_	FLAT/Uphill	
Inert gas Used	progression	99.99% ARGON		99% ARGON	
_		•			
Voltage				- 25 Volts	
Amp		Amps.		0 – 260 Amps.	
Transfer mode		SPRAY ARC		AY ARC	
Welder polarity	У	DCRP	<u>DC</u> I	<u> </u>	
Cleaning type		STEEL WIRE BRU	<u>ish</u> <u>ste</u>	EL WIRE BRUSH	
der and Welding Sup requirements of Sec	_		upons being pi	epared and welded in accordance	
requirements of Sec	tion IX of the ASI				
requirements of Sec	tion IX of the ASI			epared and welded in accordance Michael Cross	
requirements of Sec	tion IX of the AS		Signature: <u>.</u> Bend Test	Michael Cross	
requirements of Sec	tion IX of the AS	ME Code.	Signature: <u>e</u> Bend Test Pa	Michael Cross	
requirements of Sec ding Supervisor: Mic ation: Mount F Visual Examina Type of Test:	tion IX of the ASI hael Cross Pearl Shop ation of Complete Bend	ME Code.	Signature: 2 Bend Test Pa Face	<u>Michael Cross</u>	
requirements of Sec	tion IX of the ASI hael Cross Pearl Shop ation of Complete Bend	ME Code.	Signature: <u>e</u> Bend Test Pa	<u>Michael Cross</u>	
requirements of Sec ding Supervisor: Mic ation: Mount F Visual Examin Type of Test: _ Code: ASME 1	tion IX of the ASI chael Cross Pearl Shop action of Complete Bend IX	ME Code. Results of Weld:	Signature: 2 Bend Test Pa Face Result: Pa	Michael Cross SS SS	
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n Number:NEE-FRM-019			Page 1 of 1	age 1 of 1 Revision: 0			
Weld	lers Name	Jeremy Newhook		fication num	ber <u>E2228</u>		
WPS	used	A-MBH-2	Test Co	oupon	<u>2G</u>		
Base	Metal	6061 T6	Thickn	ess	1/4"		
			A street Malices		anna Maluas		
			Actual Values		ange Values		
	ling proces	S	GMAW		MAW		
	of Welder		SEMI AUTO		EMI AUTO		
	or Pipe		PLATE		LATE		
	metal		6061 T6		<u>005/6061/6063/6111/</u> 6351		
	Metal spe		AWS 5.10		WS 5.10		
	Metal clas	S	ER5356	<u>E</u>	R5356		
Filler	Metal		<u>ALUMINUM</u>	<u>A</u>	<u>LUMINUM</u>		
Cons	umable Ins	ert					
Filler	Туре		WIRE	<u></u>	WIRE		
Weld	l position/	progression	2G Horizintal/U	phill 2	<u>G Horizintal/Uph</u> ill		
Inert	gas Used		99.99% ARGON	<u>9</u>	9.99% ARGON		
Volta	age		22 Volts		2 – 25 Volts		
Amp			Auto Amps.		15 – 230 Amps.		
Trans	sfer mode		SPRAY ARC		PRAY ARC		
Weld	ler polarity		DCRP		CRP		
	ning type		STEEL WIRE BRI		TEEL WIRE BRUSH		
		ervisor are respon			prepared and welded in accordance		
ith requirem	ents of Sect	ion IX of the ASN		oupons being			
ith requireme Velding Super	ents of Sect	ion IX of the ASN		oupons being	prepared and welded in accordance		
th requirements	ents of Sect	ion IX of the ASM	AE Code.	oupons being Signature:	prepared and welded in accordance		
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vith requirements Velding Superfocation: Visual Type	ents of Sect rvisor: Mich Mount Pe	ion IX of the ASM nael Cross earl Shop tion of Complete Y	AE Code.	Signature: Bend Test	prepared and welded in accordance <u>Michael Cross</u>		
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velding Super ocation: Visua Type Code Visua Type Code	al Examinate of Test: Ee: ASME IX al Examinate of Test: Ee: Asme IX est Preform	tion of Complete Send Complete	ME Code. Results of Weld: Weld:	Signature: Bend Test P Face Result: P Root Result:	michael Cross ass ass 2ass		
Velding Super ocation: Visual Type Code Visual Type Code Mechanical To Location: N	al Examinate of Test: _Fe: _ASME IX al Examinate of Test: _Fe: _ASME IX al Examinate of Test: _Fe: _Asme IX est Preform	tion IX of the ASM nael Cross earl Shop tion of Complete Send tion of Complete Send complete Send complete Send complete Send	ME Code. Results of Weld: Weld:	Signature: Bend Test P Face Result: P Root Result: I Signature:	Michael Cross ass ass ass		
vith requirement Velding Super Location: Visually Type Code Visually Type Code Mechanical Telescotion: _N	al Examinate of Test: _Fe: _ASME IX est Preform [EEI Winnight the statem	tion IX of the ASM again and Cross tion of Complete Send Complete Send again and Complete Se	Results of Weld: Weld: a is correct and that the	Signature: Bend Test P Face Result: P Root Result: I Signature:	michael Cross ass ass 2ass		
Velding Super Location: Visual Type Code Visual Type Code Mechanical Tele Location: N	al Examinate of Test: _Fe: _ASME IX est Preform [EEI Winnight the statem	tion IX of the ASM nael Cross earl Shop tion of Complete Send tion of Complete Send complete Send complete Send complete Send	Results of Weld: Weld: a is correct and that the	Signature: Bend Test P Face Result: P Root Result: I Signature:	Michael Cross ass ass ass		
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Orm Number:NEE-FRM-019		Page 1 of 1	Page 1 of 1 Revision: 0		
Welders Name	Jeremy Newhook	Identif	ication number E2228		
WPS used	A-MBV-2	Test Co	oupon <u>3G</u>		
Base Metal	6061 T6	Thickn	ess <u>1/4"</u>		
		Actual Values	Range Values		
Welding proces	ec	GMAW	GMAW		
Type of Welder		SEMI AUTO	SEMI AUTO		
Plate or Pipe		PLATE	PLATE		
Base metal		6061 T6			
			6005/6061/6063/6111/6351		
Filler Metal spe		AWS 5.10	AWS 5.10		
Filler Metal clas	SS	ER5356	<u>ER5356</u>		
Filler Metal	_	ALUMINUM	<u>ALUMINUM</u>		
Consumable In	sert				
Filler Type	_	WIRE	<u>WIRE</u>		
Weld position/	progression	3G Vertical/Uph			
Inert gas Used		<u>99.99% ARGON</u>	99.99% ARGON		
Voltage		22 Volts	<u>22 – 25 Volts</u>		
Amp		Auto Amps.	<u> 190 – 210 Amps.</u>		
Transfer mode		SPRAY ARC	SPRAY ARC		
Welder polarity	у	DCRP	<u>DCRP</u>		
Cleaning type		STEEL WIRE BRU	JSH STEEL WIRE BRUSH		
	_		oupons being prepared and welded in accordance		
with requirements of Sec	tion IX of the AS		W. 4. 4.0		
with requirements of Section Welding Supervisor: Mic	tion IX of the AS		oupons being prepared and welded in accordance Signature: Michael Cross		
with requirements of Section Welding Supervisor: Mic	tion IX of the AS		W. 4. 4.0		
with requirements of Section Welding Supervisor: Mic	tion IX of the AS		Signature: Michael Cross		
with requirements of Section: Welding Supervisor: Micro Mount P	tion IX of the AS	ME Code. Results of I	Signature: Michael Cross		
with requirements of Sections Welding Supervisor: Mount P Visual Examina Type of Test: I	tion IX of the AS chael Cross Pearl Shop tion of Complete Bend	ME Code. Results of I	Signature: Michael Cross Bend Test Pass		
with requirements of Section: Welding Supervisor: Micro Mount P Visual Examina	tion IX of the AS chael Cross Pearl Shop tion of Complete Bend	ME Code. Results of I	Signature: Michael Cross Bend Test Pass		
Welding Supervisor: Mic Location: Mount P Visual Examina Type of Test: H Code: ASME D	tion IX of the AS chael Cross Pearl Shop tion of Complete Bend	ME Code. Results of I	Signature: Michael Cross Bend Test Pass		
Welding Supervisor: Mic Location: Mount P Visual Examina Type of Test: H Code: ASME D	tion IX of the AS chael Cross Pearl Shop tion of Complete Bend X tion of Complete	ME Code. Results of I	Signature: Michael Cross Bend Test Pass Face Result: Pass Pass Pass		
with requirements of Sections Welding Supervisor: Mic Location: Mount P Visual Examina Type of Test: I Code: ASME IX Visual Examina	tion IX of the AS chael Cross Pearl Shop tion of Complete Bend X tion of Complete Bend	ME Code. Results of I	Signature: Michael Cross Bend Test Pass Face Result: Pass		
Welding Supervisor: Mic Location: Mount P Visual Examina Type of Test: I Code: ASME IX Visual Examina Type of Test: I Code: Asme IX	tion IX of the AS chael Cross Pearl Shop tion of Complete Bend X tion of Complete Bend X	ME Code. Results of I Weld: Weld:	Signature: Michael Cross Bend Test Pass Face Result: Pass Pass Root Result: Pass		
with requirements of Sections Welding Supervisor: Mic Location: Mount P Visual Examina Type of Test: H Code: ASME D Visual Examina Type of Test: H	tion IX of the AS chael Cross Pearl Shop tion of Complete Bend X tion of Complete Bend X	ME Code. Results of I Weld: Weld:	Signature: Michael Cross Bend Test Pass Face Result: Pass Pass Pass		
Welding Supervisor: Mic Location: Mount P Visual Examina Type of Test: L Code: ASME IX Visual Examina Type of Test: L Code: Asme IX	tion IX of the AS chael Cross Pearl Shop tion of Complete Bend X	ME Code. Results of I Weld: Weld:	Signature: Michael Cross Bend Test Pass Face Result: Pass Pass Root Result: Pass		
Welding Supervisor: Mic Location: Mount P Visual Examina Type of Test: I Code: ASME IX Visual Examina Type of Test: I Code: Asme IX Mechanical Test Preform Location: NEEI Winnig	tion IX of the AS chael Cross Pearl Shop tion of Complete Bend X med by: Scott Gir peg	ME Code. Results of H Weld: Weld: a is correct and that the	Signature: Michael Cross Bend Test Pass Face Result: Pass Pass Root Result: Pass		
Welding Supervisor: Mic Location: Mount P Visual Examina Type of Test: I Code: ASME IX Visual Examina Type of Test: I Code: Asme IX Mechanical Test Preform Location: NEEI Winnig We certify that the statem requirements of Section I	tion IX of the AS chael Cross Pearl Shop tion of Complete Bend X tion of Complete Bend X teled by: Scott Gir peg ment in the record X of ASME Code	ME Code. Results of I Weld: Weld: a is correct and that the	Signature: Michael Cross Bend Test Pass Face Result: Pass Pass Root Result: Pass Signature:		
Welding Supervisor: Mic Location: Mount P Visual Examina Type of Test: I Code: ASME IX Visual Examina Type of Test: I Code: Asme IX Mechanical Test Preform Location: NEEI Winnig We certify that the statem requirements of Section I	tion IX of the AS chael Cross Pearl Shop tion of Complete Bend X tion of Complete Bend X tion of Complete Bend X ted by: Scott Gir peg nent in the record X of ASME Code	ME Code. Results of I Weld: a is correct and that the	Signature: Michael Cross Bend Test Pass Face Result: Pass Pass Root Result: Pass Signature:		



P EQUIPMENT INC.				Welding Performance Qualification (WPQ)		
Form Number:NEE-FRM-019 Page			Revision: 0			
Welders Name	Jeremy Newhook	Identif	fication nu	umber E2228		
WPS used A-MBO-2 Base Metal 6061 T6		Test Coupon		4G		
		Thickn	-	1/4"		
				<u></u>		
AA7 1 P		Actual Values		Range Values		
Welding proces		GMAW		GMAW		
Type of Welder		SEMI AUTO	_	SEMI AUTO		
Plate or Pipe		PLATE 6061 T6	_	PLATE		
	Base metal		_	6005/6061/6063/6111/6351		
Filler Metal spe		AWS 5.10 ER5356		AWS 5.10		
	Filler Metal class			<u>ER5356</u>		
Filler Metal		<u>ALUMINUM</u>		<u>ALUMINUM</u>		
Consumable Ins	sert					
Filler Type		WIRE		WIRE		
Weld position/	progression	4G Overhead/U	phill	4G Overhead/Uphill		
Inert gas Used		99.99% ARGON		99.99% ARGON		
Voltage		22 Volts		<u>22 – 25 Volts</u>		
Amp		Auto Amps.		<u>215 – 225 Amps.</u>		
Transfer mode		SPRAY ARC		SPRAY ARC		
Welder polarity	1	DCRP		DCRP		
Cleaning type		STEEL WIRE BRI	USH	STEEL WIRE BRUSH		
with requirements of Section IX of the ASM Welding Supervisor: Michael Cross			Signatu	re: <u>Michael Cross</u>		
Location: Mount Po	earl Shop					
		Results of	Bend Test			
Visual Examina	Weld:		Pass			
Type of Test: Bend Code: ASME IX Visual Examination of Complete Weld Type of Test: Bend		,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,,	Face			
			Result:	Pass		
		Weld:		Pass		
			Root	Dass		
Code: Asme IX			Result:	<u> </u>		
Mechanical Test Preform		a	Signatu	re:		
Location: <u>NEEI Winni</u>	-					
We certify that the statem requirements of Section I			the test cou	pons were tested in accordance with the		
Date: May	Date: May 11, 2018			National Energy Equipment Inc.		
Name: Zanyar Fa	arhadi	 Signat		Se		
				Can .		