

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

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 position passed.

Recommendations

No recommendations needed.

Test Performed By: _____


Scott Gira

Test Date: May/11/2018



Welders Name	<u>Jeremy Newhook</u>	Identification number	<u>E2228</u>
WPS used	<u>A-MBV-2</u>	Test Coupon	<u>3G</u>
Base Metal	<u>6061 T6</u>	Thickness	<u>1/4"</u>

	Actual Values	Range Values
Welding process	<u>GMAW</u>	<u>GMAW</u>
Type of Welder	<u>SEMI AUTO</u>	<u>SEMI AUTO</u>
Plate or Pipe	<u>PLATE</u>	<u>PLATE</u>
Base metal	<u>6061 T6</u>	<u>6005/6061/6063/6111/6351</u>
Filler Metal specs	<u>AWS 5.10</u>	<u>AWS 5.10</u>
Filler Metal class	<u>ER5356</u>	<u>ER5356</u>
Filler Metal	<u>ALUMINUM</u>	<u>ALUMINUM</u>
Consumable Insert	<u></u>	<u></u>
Filler Type	<u>WIRE</u>	<u>WIRE</u>
Weld position/ progression	<u>3G Vertical/Uphill</u>	<u>3G Vertical/Uphill</u>
Inert gas Used	<u>99.99% ARGON</u>	<u>99.99% ARGON</u>
Voltage	<u>22 Volts</u>	<u>22 – 25 Volts</u>
Amp	<u>Auto Amps.</u>	<u>190 – 210 Amps.</u>
Transfer mode	<u>SPRAY ARC</u>	<u>SPRAY ARC</u>
Welder polarity	<u>DCRP</u>	<u>DCRP</u>
Cleaning type	<u>STEEL WIRE BRUSH</u>	<u>STEEL WIRE BRUSH</u>

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: Michael Cross

Signature: Michael Cross

Location: Mount Pearl Shop

Results of Bend Test

Visual Examination of Complete Weld:	<u>Pass</u>
Type of Test: <u>Bend</u>	Face
Code: <u>ASME IX</u>	Result: <u>Pass</u>

Visual Examination of Complete Weld:	<u>Pass</u>
Type of Test: <u>Bend</u>	Root
Code: <u>Asme IX</u>	Result: <u>Pass</u>

Mechanical Test Performed by: Scott Gira

Signature: 

Location: NEEI Winnipeg

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: May 11, 2018

Organization: National Energy Equipment Inc.

Name: Zanyar Farhadi

Signature: 

