

Date: Aug/20/2018

Prepared for: _	Stephen Hillier	Branch: _	Mount Pearl, NF		
Sample Descrip	otion: Weld Co	oupons - 6061	Welder ID	Number:	E2955
			110.0.0.12	-	

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 positions passed bend test.

Recommendations

No Recommendations needed.

Test Preformed By:

Scott Gira

Test Date: Aug/20/2018



n Number:NEE-FRM-019 Page 1 of 1			Revision: 0		
Welders Name	Stephen Hillier	Idantii	ication numb	ar E2955	
WPS used	A-MBF-2 6061 T6	Test Co	=	<u>1G</u>	
Base Metal	000110	Thickn	ess	1/4"	
		<b>Actual Values</b>	Ra	nge Values	
Welding proces	SS	GMAW	GN	1AW	
Type of Welder	r	SEMI AUTO	SEI	MI AUTO	
Plate or Pipe		PLATE	 PL/	ATE	
Base metal		6061 T6		D5/6061/6063/6111/6351	
Filler Metal spe	ecs	AWS 5.10		<u>/S 5.10</u>	
Filler Metal clas		ER5356		5356	
Filler Metal	33	ALUMINUM		JMINUM	
Consumable In:	sert	ALOIVIIIVOIVI			
Filler Type	3010	WIRE	WI	 RF	
Weld position/	nrogression	1G FLAT/Uphill		FLAT/Uphill	
Inert gas Used	progression	99.99% ARGON	· · · · · · · · · · · · · · · · · · ·	99% ARGON	
Voltage		22 Volts	<del></del>	– 25 Volts	
=					
Amp		711105.		<u>0 – 260 Amps.</u>	
Transfer mode		SPRAY ARC		RAY ARC	
Welder polarity	y	DCRP	<u>DC</u>	<u></u>	
Cleaning type		STEEL WIRE BRI	<u>JSH</u> <u>STI</u>	EEL WIRE BRUSH	
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	tion IX of the AS			repared and welded in accordance <u>Jeremy Newhook</u>	
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Form Number:NEE-FRM-019 Page 1			1 Revision: 0		
Maldona Nome	Stephen Hillier	l d o n t i	isation number	· E2955	
Welders Name			fication number		
WPS used <u>A-MBH-2</u> Rase Metal 6061 T6		Test Co	-		
Base Metal	000110	Thickn	ess	1/4"	
		Actual Values		ge Values	
Welding proces		GMAW	<u>GM</u> /		
Type of Welder	•	SEMI AUTO		I AUTO	
Plate or Pipe		PLATE	<u>PLA</u> 1		
Base metal		6061 T6		<u>5/6061/6063/6111/</u> 6351	
Filler Metal spe		AWS 5.10	<u>AWS</u>	5.10	
Filler Metal clas	SS	ER5356	ER53	<u>856</u>	
Filler Metal		ALUMINUM	ALU	MINUM	
Consumable Ins	sert				
Filler Type		WIRE	<u>WIR</u>	<u>E</u>	
Weld position/	progression	2G Horizintal/U	phill 2G F	<u>lorizintal/Uph</u> ill	
Inert gas Used		99.99% ARGON	<u>99.9</u>	9% ARGON_	
Voltage		22 Volts	22 –	25 Volts	
Amp		Auto Amps.	215	– 230 Amps.	
Transfer mode		SPRAY ARC	· · · · · · · · · · · · · · · · · · ·	AY ARC	
Welder polarity	<i>i</i>	DCRP	DCR		
Cleaning type		STEEL WIRE BRI	_	L WIRE BRUSH	
Welder and Welding Sup with requirements of Sect		nsible for the test co		pared and welded in accordance	
with requirements of Sect	tion IX of the AS	nsible for the test co	oupons being pre	pared and welded in accordance	
with requirements of Sect Welding Supervisor:	tion IX of the AS	nsible for the test co	oupons being pre	<del>-</del>	
with requirements of Sect Welding Supervisor:	emy Newhook	nsible for the test co	Signature:	pared and welded in accordance	
with requirements of Sect  Welding Supervisor:	emy Newhook	nsible for the test come.  ME Code.  Results of	Signature:	pared and welded in accordance Jeremy Newhook	
with requirements of Sect  Welding Supervisor: Jer  Location: Mount P	emy Newhook earl Shop	nsible for the test come.  ME Code.  Results of	Signature:	pared and welded in accordance Jeremy Newhook	
with requirements of Sect  Welding Supervisor:	emy Newhook earl Shop  tion of Complete Bend	nsible for the test come.  ME Code.  Results of	Signature:	pared and welded in accordance  Severy Newhook	
with requirements of Sect  Welding Supervisor:	emy Newhook earl Shop  tion of Complete Bend	nsible for the test come.  ME Code.  Results of	Signature:	pared and welded in accordance  Seremy Newhook	
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Welding Supervisor: Jen Location: Mount P  Visual Examina Type of Test: J Code: ASME D  Visual Examina Type of Test: J Code: Asme IX	emy Newhook earl Shop  attion of Complete Bend X  attion of Complete Bend X	Results of Weld:	Signature:    Pass	pared and welded in accordance  Severny Newhook	
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Welding Supervisor: Jen Location: Mount P  Visual Examina Type of Test: J Code: ASME D  Visual Examina Type of Test: J Code: Asme IX	emy Newhook  tearl Shop  tion of Complete Bend X  tion of Complete Bend C  tearl Shop	Results of Weld:	Signature:    Pass	pared and welded in accordance  Severny Newhook	
Welding Supervisor: Jer Location: Mount P  Visual Examina Type of Test: J Code: ASME D  Visual Examina Type of Test: J Code: Asme IX  Mechanical Test Preform Location: NEEI Winnig	emy Newhook  earl Shop  ation of Complete Bend X  ation of Complete Bend X  ation of Complete Bend C  and by: Scott Gin peg  ment in the record	Results of  Weld:  Weld:	Signature:  Signature:  Pass Face Result:  Pass Root Result:  Pass Signature:	pared and welded in accordance  Severny Newhook	
Welding Supervisor: Jen Location: Mount P  Visual Examina Type of Test: J Code: ASME II  Visual Examina Type of Test: J Code: Asme IX  Mechanical Test Preform Location: NEEI Winnig  We certify that the statem requirements of Section I	tion IX of the AS  emy Newhook  earl Shop  tion of Complete Bend X  tion of Complete Bend X  tion of Complete Bend X  and by: Scott Gin peg  ment in the record X of ASME Code	Results of Weld:  "a  lis correct and that to	Signature:    Pass	pared and welded in accordance  Severny Newhook  Severny Severnook	
Welding Supervisor: Jen Location: Mount P  Visual Examina Type of Test: J Code: ASME D  Visual Examina Type of Test: J Code: Asme IX  Mechanical Test Preform Location: NEEI Winnig  We certify that the staten requirements of Section I	emy Newhook  learl Shop  ation of Complete Bend X  ation of Complete Bend X  ation of Complete Bend X  ation of Complete Complete And by: Scott Gin Deg  ment in the record X of ASME Code 2018	Results of Weld:  "a  lis correct and that to	Signature:	pared and welded in accordance  Seremy Newhook  Seremy Ser	



Welders Name WPS used Base Metal WPS used A-MBV-2 Test Coupon Thickness Thic	n Number:NEE-FRM-0	19	Page 1 of 1	Revisio	n: 0	
Welding process  Welding process  GMAW Type of Welder  SEMIAUTO Plate or Pipe PLATE PLATE Base metal 6081 T6 6081 T6 6005/6061/6063/6111/6351 Filler Metal class Filler Metal class Filler Metal ALUMINUM Consumable Insert Filler Type Weld position/ progression Inert gas Used 99.99% ARGON Voltage 42 Volts 22 Volts 22 Volts 22 Volts 22 Volts Amp Transfer mode Welder polarity DCRP Cleaning type  Welding Supervisor are responsible for the test coupons being prepared and welded in accordance rith requirements of Section IX of the ASME Code.  Welding Supervisor:  Welding Supervisor:  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of	Welders Name	Stephen Hillier	Identif	fication n	number E2955	
Welding process GMAW GMAW Type of Welder SEMI AUTO Plate or Pipe PLATE Base metal Base Base Base Boolos(563/6111/6351 Base Base Base Base Base Base Base Base	WPS used A-MBV-2		Test Coupon		<u>3G</u>	
Welding process Type of Welder Type of Welder SEMI AUTO SEMI AUTO Plate or Pipe PLATE Base metal  6061 T6 6005/6061/6063/6111/6351  Filler Metal specs Filler Metal class Filler Metal class Filler Metal Consumable Insert Filler Type Wire Weld position/ progression Inert gas Used 99.99% ARGON Voltage 22 Volts Amp Auto Amps Transfer mode SPRAY ARC Welder polarity Cleaning type  Velder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordance ith requirements of Section IX of the ASME Code.  Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination o	Base Metal	6061 T6	Thickn	ess	1/4"	
Type of Welder   SEMI AUTO   SEMI AUTO   Plate or Pipe   PLATE   PLATE   Description   Plate or Pipe   PLATE   Description   Semi Auto   Plate   Plate   Plate   Semi Auto   S			Actual Values		Range Values	
Plate or Pipe Base metal  Dool 176	Welding process	s	GMAW		GMAW	
Base metal Filler Metal specs Filler Metal class Filler Metal class Filler Metal Consumable Insert Filler My Wire Filler My Miss Filler My Mi	Type of Welder		SEMI AUTO		SEMI AUTO	
Filler Metal class	Plate or Pipe		PLATE		<u>PLATE</u>	
Filler Metal class Filler Metal ALUMINUM ALUMINUM Consumable Insert Filler Type Wire Wire Wire Wire Wire Wire Wire Wir	Base metal		6061 T6		<u>6005/6061/6063/6111/</u> 6351	
Filler Metal Consumable Insert  Filler Type Wire Wire Wire Wire Weld position/ progression 3G Vertical/Uphill 3G Vertical/Uphill Inert gas Used 99.99% ARGON 99.99% ARGON Voltage 22 Volts 22 - 25 Volts 190 - 210 Amps. 190 - 210 Amps. 190 - 210 Amps. Transfer mode SPRAY ARC SPRAY ARC SPRAY ARC Welder polarity DCRP DCRP Cleaning type STEEL WIRE BRUSH STEEL WIRE BRUSH  Felder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordance the requirements of Section IX of the ASME Code.  Felding Supervisor: Jeremy Newhook Signature: Jeventy Newhook Signature: Jeventy Newhook  Pass  Visual Examination of Complete Weld: Pass Type of Test: Bend Result: Pass  Visual Examination of Complete Weld: Pass Type of Test: Bend Result: Pass  Visual Examination of Complete Weld: Pass  Face Result: Pas	Filler Metal spec	cs	AWS 5.10		AWS 5.10	
Consumable Insert Filler Type Wire Wire Wire Wire Wire Wire Wire Wir	Filler Metal clas	s	ER5356		ER5356	
Consumable Insert Filler Type Weld position/ progression 3G Vertical/Uphill Inert gas Used 99.99% ARGON 99.99% ARGON 99.99% ARGON Voltage 22 Volts 22 - 25 Volts Amp Aulo Amps. 190 - 210 Amps. Transfer mode SPRAY ARC Welder polarity DCRP Cleaning type STEEL WIRE BRUSH  Velding Supervisor are responsible for the test coupons being prepared and welded in accordance ith requirements of Section IX of the ASME Code.  Velding Supervisor:    Jeremy Newhook	Filler Metal			<u></u>	· · · · · · · · · · · · · · · · · · ·	
Weld position/ progression   3G Vertical/Uphill   3G Vertical/Uphill   Inert gas Used   99.99% ARGON   99.99% ARGON   99.99% ARGON   Voltage   22	Consumable Ins	ert				
Weld position/ progression   3G Vertical/Uphill   3G Vertical/Uphill   1nert gas Used   99.99% ARGON   99.99% ARGON   99.99% ARGON   22 - 25 Volts   20 - 20 Nmps   20 - 210	Filler Type		WIRE		WIRE	
Inert gas Used  Voltage  22 Volts  Amp  Auto Amps.  190-210 Amps.  190-210 Amps.  Transfer mode  SPRAY ARC  Welder polarity  Cleaning type  STEEL WIRE BRUSH  Volder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordance with requirements of Section IX of the ASME Code.  Volding Supervisor:  Jeremy Newhook  Signature:  Visual Examination of Complete Weld:  Type of Test:  Bend  Code:  ASME IX  Visual Examination of Complete Weld:  Type of Test:  Bend  Code:  ASME IX  Visual Examination of Complete Weld:  Type of Test:  Bend  Code:  ASME IX  Visual Examination of Complete Weld:  Type of Test:  Bend  Code:  ASME IX  Visual Examination of Complete Weld:  Type of Test:  Bend  Code:  ASME IX  Visual Examination of Complete Weld:  Type of Test:  Bend  Code:  ASME IX  Visual Examination of Complete Weld:  Type of Section IX of ASME Code.  Visual Examination of Complete Weld:  Type of Section IX of ASME Code.  Visual Examination of Complete Weld:  Type of Section IX of ASME Code.  Visual Examination of Complete Weld:  Type of Section IX of ASME Code.  Visual Examination of Complete Weld:  Type of Section IX of ASME Code.  Visual Examination of Complete Weld:  Type of Section IX of ASME Code.  Visual Examination of Complete Weld:  Type of Section IX of ASME Code.  NEEI Winnipeg  Visual Examination of Complete Weld:  Type of Test:  Bend  Code:  Asme IX  Account of Test Preformed by:  South Gira  Signature:  August 20, 2018  Organization:  National Energy Equipment Inc.		progression		nill		
Voltage Auto Amps. 190 - 210 Amps. Transfer mode SPRAY ARC SPRAY ARC Welder polarity DCRP DCRP Cleaning type STEEL WIRE BRUSH STEEL WIRE BRUSH  Volder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordance with requirements of Section IX of the ASME Code.  Velding Supervisor: Jeremy Newhook Signature: Jeremy Newhook ocation: Mount Pearl Shop  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 Result: Pass  Visual Examination of Complete Weld: Pass Type of Test: Bend Result: Pass  Visual Examination of Complete Weld: Signature: Pass  Visual Examination of Complete Weld: Pass Type of Test: Bend Result: Pass  Visual Examination of Complete Weld: Signature: Pass  Visual Examination of Complete Weld: Result: Pass		p. 08. 000.01.				
Amp   Auto   Amps.   190 - 210 Amps.   SPRAY ARC   SPRAY ARC   DCRP   DCRP   DCRP   DCRP   Cleaning type   STEEL WIRE BRUSH   STEEL WIRE BRUSH    Velder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordance rith requirements of Section IX of the ASME Code.  Velding Supervisor:	•				· · ·	
Transfer mode SPRAY ARC SPRAY ARC Welder polarity DCRP DCRP DCRP DCRP Cleaning type STEEL WIRE BRUSH STEEL WIRE BRUSH  Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordance rith requirements of Section IX of the ASME Code.  Welding Supervisor: Jeremy Newhook Signature: Jeveny Newhook Ocation: Mount Pearl Shop  Results of Bend Test  Visual Examination of Complete Weld: Face Result: Pass  Visual Examination of Complete Weld: Type of Test: Bend Root Result: Pass  Visual Examination of Complete Weld: Signature: Pass  Visual Examination of Complete Weld: Root Result: Pass  Visual Examination of Complete Weld: Necessary Root Result: Pass  Visual Examination of Complete Weld: Result: Pass  Visual Examination of Complete	=				· · ·	
Welder polarity Cleaning type    DCRP	-				· · · · · · · · · · · · · · · · · · ·	
Cleaning type   STEEL WIRE BRUSH   STEEL WIRE BRUSH     Velder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordance with requirements of Section IX of the ASME Code.   Velding Supervisor:					· · ·	
Velder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordance with requirements of Section IX of the ASME Code.  Velding Supervisor:Jeremy Newhook						
Nount Pearl Shop   Results of Bend Test		_		oupons be	ing prepared and welded in accordance	
Visual Examination of Complete Weld: Type of Test: Bend Code: ASME IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Visual Examination of Complete Weld: Type of Test: Bend Code: Asme IX  Mechanical Test Preformed by: Scott Gira Signature:  Vecertify that the statement in the record is correct and that the test coupons were tested in accordance with the equirements of Section IX of ASME Code.  August 20, 2018  Organization: National Energy Equipment Inc.	th requirements of Secti	ion IX of the AS				
Type of Test: Bend	th requirements of Sections of Sections Supervisor:	ion IX of the AS				
Visual Examination of Complete Weld: Type of Test: Bend Root Code: Asme IX  Mechanical Test Preformed 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 equirements of Section IX of ASME Code.  Date: August 20, 2018 Organization: National Energy Equipment Inc.	th requirements of Sections of Sections Supervisor:	ion IX of the AS	ME Code.	Signati	ure: <u>Jeremy Newhook</u>	
Visual Examination of Complete Weld: Type of Test: Bend Root Code: Asme IX  Mechanical Test Preformed 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 equirements of Section IX of ASME Code.  Date: August 20, 2018 Organization: National Energy Equipment Inc.	th requirements of Sectivelding Supervisor:    Jerestation: Mount Pervisor: Mo	ion IX of the AS emy Newhook earl Shop ion of Complete	ME Code.  Results of I	Signati	ure: <u>Jeremy Newhook</u>	
Type of Test: Bend	th requirements of Sective leding Supervisor:    Supervisor:	ion IX of the AS emy Newhook earl Shop ion of Complete end	ME Code.  Results of I	Signate  Bend Test  Face	Pass	
Code: Asme IX  Result: Pass  Mechanical Test Preformed by: Scott Gira  Signature:  Occation: NEEI Winnipeg  We certify that the statement in the record is correct and that the test coupons were tested in accordance with the equirements of Section IX of ASME Code.  Oate: August 20, 2018  Organization: National Energy Equipment Inc.	th requirements of Sective leding Supervisor:    Supervisor:	ion IX of the AS emy Newhook earl Shop ion of Complete end	ME Code.  Results of I	Signate  Bend Test  Face	Pass	
Mechanical Test Preformed 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 equirements of Section IX of ASME Code.  Date: August 20, 2018 Organization: National Energy Equipment Inc.	th requirements of Sective Iding Supervisor:    Sective Iding Supervisor:	emy Newhook earl Shop  ion of Complete end	ME Code.  Results of I  Weld:	Signate  Bend Test  Face	Pass Pass	
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We certify that the statement in the record is correct and that the test coupons were tested in accordance with the equirements of Section IX of ASME Code.  Date: August 20, 2018 Organization: National Energy Equipment Inc.	th requirements of Sective Iding Supervisor:    Jere   Cation:	emy Newhook earl Shop  ion of Complete end ion of Complete end	ME Code.  Results of I  Weld:	Signate  Bend Test  Face  Result:	Pass Pass Pass	
Ve certify that the statement in the record is correct and that the test coupons were tested in accordance with the equirements of Section IX of ASME Code.  Date: August 20, 2018 Organization: National Energy Equipment Inc.	th requirements of Sective Interpretation:  Visual Examination Type of Test: B. Code: ASME IX  Visual Examination Type of Test: B. Code: Asme IX	ion IX of the AS emy Newhook earl Shop  ion of Complete end ion of Complete end	ME Code.  Results of I  Weld:  Weld:	Signate  Bend Test  Face Result:  Root Result:	Pass Pass Pass Pass Pass	
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Name: Zanyar Farhadi Signature: Signature	visual Examinati Type of Test: B Code: ASME IX  Visual Examinati Type of Test: B Code: Asme IX  echanical Test Preforme cation: NEEI Winnip e certify that the statemen	ion IX of the AS  emy Newhook  earl Shop  ion of Complete end  ion of Complete end  ed by: Scott Gir eg  ent in the record  X of ASME Code	ME Code.  Results of I  Weld:  Weld:  a  is correct and that the	Face Result:  Root Result:  Signati	Pass Pass Pass Pass ure:	



Welders Name WPS used A-MBO-2 Test Coupon AG Thickness 1/4"  Welding process GMAW GMAW GMAW Type of Welder Plate or Pipe PLATE PLATE PLATE Filler Metal class ER5356 ER5356 Filler Metal ALUMINUM ALUMINUM ALUMINUM Consumble Insert Filler Type Weld position/ progression AG Overhead/Uphill AG Overhead/Uphill Inert gas Used 99.99% ARGON Voltage 22 Volts 22 – 25 Volts Amp Auto Amps SPRAY ARC Welder polarity DCRP STEEL WIRE BRUSH  Welding Supervisor: Jeremy Newhook Welding Supervisor: Jeremy Newhook Location: Mount Peat Shop	
WPS used Base Metal 6061 T6 Thickness 1/4"  Actual Values Range Values Welding process GMAW GMAW Type of Welder SEMI AUTO SEMI AUTO Plate or Pipe PLATE Base metal 6061 T6 6005/6061/6063/6111/6351 Filler Metal specs AWS 5.10 AWS 5.10 Filler Metal class ER5356 ER5356 Filler Metal ALUMINUM ALUMINUM Consumable Insert Filler Type WIRE WIRE Weld position/ progression 4G Overhead/Uphill 4G Overhead/Uphill 1nert gas Used 99.99% ARGON 99.99% ARGON Voltage 22 Volts 22 - 25 Volts Amp Auto Amps. 215 - 225 Amps. Transfer mode SPRAY ARC SPRAY ARC Welder polarity DCRP DCRP Cleaning type STEEL WIRE BRUSH  Welding Supervisor: Jeremy Newhook Signature: Jevemy Newhook	
Actual Values   Range Values	
Actual Values   Range Values	
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Type of Welder Plate or Pipe PLATE PLATE Base metal 6061 T6 6005/6061/6063/6111/6351 Filler Metal specs AWS 5.10 AWS 5.10 Filler Metal class ER5356 Filler Metal Consumable Insert Filler Type WIRE Weld position/ progression Inert gas Used Voltage 22 Volts Amp Auto Amps. 215 – 225 Amps. Transfer mode Welder polarity DCRP Cleaning type  Welding Supervisor:  SEMI AUTO PLATE	
Plate or Pipe Base metal  6061 T6 6005/6061/6063/6111/6351  Filler Metal specs AWS 5.10 AWS 5.10 Filler Metal class ER5356 Filler Metal Consumable Insert Filler Type WIRE Weld position/ progression Voltage 4G Overhead/Uphill Inert gas Used 99.99% ARGON Voltage 22 Volts 22 - 25 Volts Amp Auto Amps. 215 - 225 Amps.  Transfer mode Welder polarity Cleaning type  Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordar with requirements of Section IX of the ASME Code.  Welding Supervisor:  Jeremy Newhook  PLATE OGOS 6005/6061/6063/6111/6351  AWS 5.10 AWS 5.	
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Filler Metal class ER5356 ER5356 Filler Metal ALUMINUM ALUMINUM  Consumable Insert  Filler Type WIRE WIRE  Weld position/ progression 4G Overhead/Uphill 4G Overhead/Uphill Inert gas Used 99.99% ARGON 99.99% ARGON  Voltage 22 Volts 22 - 25 Volts  Amp Auto Amps. 215 - 225 Amps.  Transfer mode SPRAY ARC SPRAY ARC  Welder polarity DCRP DCRP  Cleaning type STEEL WIRE BRUSH STEEL WIRE BRUSH  Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordar with requirements of Section IX of the ASME Code.	
Filler Metal Consumable Insert Filler Type WIRE Weld position/ progression Inert gas Used Voltage Voltage  Auto Amp Auto Amps. Transfer mode Welder polarity Cleaning type  Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordate with requirements of Section IX of the ASME Code.  ALUMINUM AGURE WIRE WIRE  WIRE  SPRAYARO SPRAYARO SPRAY ARC DOCRP Cleaning type STEEL WIRE BRUSH STEEL WIRE BRUSH  Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordate with requirements of Section IX of the ASME Code.	
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Welding Supervisor:  Weld position/ progression Inert gas Used  99.99% ARGON 99.99% ARGON 99.99% ARGON 99.99% ARGON 22 Volts 22-25 Volts Amp Auto Amps. 215-225 Amps.  SPRAY ARC SPRAY ARC Welder polarity DCRP Cleaning type  STEEL WIRE BRUSH  Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordar with requirements of Section IX of the ASME Code.  Welding Supervisor:  Jeremy Newhook  Signature:  Jeremy Newhook	
Inert gas Used  Voltage  22 Volts  Auto Amps. 215 – 225 Amps.  Transfer mode Welder polarity Cleaning type  STEEL WIRE BRUSH  Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordar with requirements of Section IX of the ASME Code.  Welding Supervisor:  Jeremy Newhook  99.99% ARGON 22 Volts 22 – 25 Volts 215 – 225 Amps.  SPRAY ARC SPRAY ARC SPRAY ARC SPRAY BRUSH  STEEL WIRE BRUSH  STEEL WIRE BRUSH  Welding Supervisor are responsible for the test coupons being prepared and welded in accordary with requirements of Section IX of the ASME Code.	
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Transfer mode  SPRAY ARC  Welder polarity  Cleaning type  STEEL WIRE BRUSH  Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordate with requirements of Section IX of the ASME Code.  Welding Supervisor:  Jeremy Newhook  Signature:  Jeremy Newhook	
Welder polarity Cleaning type  STEEL WIRE BRUSH  Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accorda with requirements of Section IX of the ASME Code.  Welding Supervisor:  Jeremy Newhook  Signature:  Jeremy Newhook	
Cleaning type  STEEL WIRE BRUSH  STEEL WIRE BRUSH  Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordar with requirements of Section IX of the ASME Code.  Welding Supervisor:  Jeremy Newhook  Signature:  Jeremy Newhook	
Welder and Welding Supervisor are responsible for the test coupons being prepared and welded in accordary with requirements of Section IX of the ASME Code.  Welding Supervisor:	
with requirements of Section IX of the ASME Code.  Welding Supervisor:   Jeremy Newhook  Signature:   Jeremy Newhook	
Location.	
Results of Bend Test	
Visual Examination of Complete Weld:  Pass  Pass	
Type of Test: Bend Face Code: ASME IX Pass	
Couc. ASME IA Result.	
Visual Examination of Complete Weld:  Pass	
Type of Test: Rend Root	
Code: Asme IX Result: Pass	
	2
Mechanical Test Preformed 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 requirements of Section IX of ASME Code.	the
Date: August 20, 2018 Organization: National Energy Equipment Inc.	
Name: Zanyar Farhadi Signature: National Energy Equipment Inc.	<del></del>
SignatureSignature.	