NATIONAL ENERGY EQUIPMENT INC.

Date: Aug/20/2018

Prepared for: Stephen Hillier Branch: Mount Pearl, NF

Sample Description: Weld Coupons - 6061 Welder ID Number: E2955

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 Preformed By: Scott Gira

Test Date: Aug/20/2018

NATIONAL ENERGY EQUIPMENT INC.

Welding Performance Qualification (WPQ)

Form Number:NEE-FRM-019	Page 1 of 1	Revision: 0

Welders Name	Stephen Hillier	**Identification number**	E2955
WPS used	A-MBF-2	**Test Coupon**	1G
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	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	1G FLAT/Uphill	1G FLAT/Uphill
Inert gas Used	99.99% ARGON	99.99% ARGON
Voltage	22 Volts	22 – 25 Volts
Amp	Auto Amps.	230 – 260 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 accordance with requirements of Section IX of the ASME Code.

Welding Supervisor: Jeremy Newhook **Signature:** *Jeremy Newhook*

Location: Mount Pearl Shop

Results of Bend Test

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

Visual Examination of Complete Weld: Pass
Type of Test: Bend **Root Result:** Pass
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 requirements of Section IX of ASME Code.

Date: August 20, 2018 **Organization:** National Energy Equipment Inc.
Name: Zanyar Farhadi **Signature:**

NATIONAL ENERGY EQUIPMENT INC.

Welding Performance Qualification (WPQ)

Form Number:NEE-FRM-019	Page 1 of 1	Revision: 0

Welders Name	Stephen Hillier	**Identification number**	E2955
WPS used	A-MBH-2	**Test Coupon**	2G
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	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	2G Horizintal/Uphill	2G Horizintal/Uphill
Inert gas Used	99.99% ARGON	99.99% ARGON
Voltage	22 Volts	22 – 25 Volts
Amp	Auto Amps.	215 – 230 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 accordance with requirements of Section IX of the ASME Code.

Welding Supervisor: Jeremy Newhook **Signature:** *Jeremy Newhook*

Location: Mount Pearl Shop

Results of Bend Test

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

Visual Examination of Complete Weld: Pass
Type of Test: Bend **Root Result:** Pass
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 requirements of Section IX of ASME Code.

Date: August 20, 2018 **Organization:** National Energy Equipment Inc.
Name: Zanyar Farhadi **Signature:**

NATIONAL ENERGY EQUIPMENT INC.

Welding Performance Qualification (WPQ)

Form Number:NEE-FRM-019	Page 1 of 1	Revision: 0

Welders Name	Stephen Hillier	**Identification number**	E2955
WPS used	A-MBV-2	**Test Coupon**	3G
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	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	3G Vertical/Uphill	3G Vertical/Uphill
Inert gas Used	99.99% ARGON	99.99% ARGON
Voltage	22 Volts	22 – 25 Volts
Amp	Auto Amps.	190 – 210 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 accordance with requirements of Section IX of the ASME Code.

Welding Supervisor: Jeremy Newhook **Signature:** Jeremy Newhook

Location: Mount Pearl Shop

Results of Bend Test

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

Visual Examination of Complete Weld: Pass
Type of Test: Bend **Root Result:** Pass
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 requirements of Section IX of ASME Code.

Date: August 20, 2018 **Organization:** National Energy Equipment Inc.

Name: Zanyar Farhadi **Signature:**

NATIONAL ENERGY EQUIPMENT INC.

Welding Performance Qualification (WPQ)

Form Number:NEE-FRM-019	Page 1 of 1	Revision: 0

Welders Name	Stephen Hillier	**Identification number**	E2955
WPS used	A-MBO-2	**Test Coupon**	4G
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	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
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 accordance with requirements of Section IX of the ASME Code.

Welding Supervisor: Jeremy Newhook **Signature:** Jeremy Newhook

Location: Mount Pearl Shop

Results of Bend Test

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

Visual Examination of Complete Weld: Pass
Type of Test: Bend **Root Result:** Pass
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 requirements of Section IX of ASME Code.

Date: August 20, 2018 **Organization:** National Energy Equipment Inc.

Name: Zanyar Farhadi **Signature:**