

Prepared for: Patrick Dow Branch: Thunder Bay

Sample Description: Weld Test Coupons Welder ID Number: 14401

Standard/Specification: ASME IX: QW-160 Guided Bend Test

**Test Results**

Sample ID	Visual Examination of Welds	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 Performed By:   
 \_\_\_\_\_  
 Scott Gira

Test Date: Sep/25/2017





Welder Performance Qualification (WPQ)

Welders Name Patrick Dow Identification number 14401  
 WPS used A-MBF-1 Test Coupon 1G  
 Base Metal S052/H32 Thickness .25

	Actual Values	Range Values
Welding process	<u>GMAW</u>	<u>-</u>
Type of Welder	<u>SEMI AUTO</u>	<u>-</u>
Plate or Pipe	<u>PLATE</u>	<u>-</u>
Base metal	<u>S052/H32</u>	<u>-</u>
Filler Metal specs	<u>AWS 5.10</u>	<u>-</u>
Filler Metal class	<u>ER 5356</u>	<u>-</u>
Filler Metal	<u>ALUMINIUM</u>	<u>-</u>
Consumable Insert	<u>-</u>	<u>-</u>
Filler Type	<u>WIRE</u>	<u>-</u>
Position Qualified	<u>1G</u>	<u>-</u>
Inert gas Used	<u>99.9% Ar</u>	<u>-</u>
Voltage	<u>23.</u>	<u>22-25</u>
Amp	<u>215</u>	<u>215-225</u>
Transfer mode	<u>SPRAY</u>	<u>-</u>
Welder polarity	<u>DCEP</u>	<u>-</u>
Cleaning type	<u>SS WIRE BRUSH</u>	<u>-</u>

Visual Examination of Complete Weld Result Pass  
 Type of Test Bend Root or Face Face  
 Code ASME IX Result Pass

Visual Examination of Complete Weld Result Pass  
 Type of Test Bend Root or Face  
 Code ASME IX Result Pass

Mechanical test done by NEE Welding Supervised TONY ZELWIEGER  
 Laboratory test location Winnipeg, MB

We certify that the statement in the record is correct and that the test coupons were prepared welded, and tested in accordance with the requirements of Section IX of ASME Code.

Date Sep/25/2017 Organization National Energy Equipment

Signature



Welder Performance Qualification (WPQ)

Welders Name Patrick Dow Identification number 14401  
 WPS used A-MBH-1 Test Coupon 26  
 Base Metal S052/H32 Thickness .25

	Actual Values	Range Values
Welding process	<u>GMAW</u>	-
Type of Welder	<u>SEMI AUTO</u>	-
Plate or Pipe	<u>PLATE</u>	-
Base metal	<u>S052/H32</u>	-
Filler Metal specs	<u>AWS 5.10</u>	-
Filler Metal class	<u>ER 5356</u>	-
Filler Metal	<u>ALUMINUM</u>	-
Consumable Insert	-	-
Filler Type	<u>WIRE</u>	-
Position Qualified	<u>2G</u>	-
Inert gas Used	<u>99.9% Ar</u>	-
Voltage	<u>23</u>	<u>22-25</u>
Amp	<u>215</u>	<u>215-225</u>
Transfer mode	<u>SPRAY</u>	-
Welder polarity	<u>DCEP</u>	-
Cleaning type	<u>SS WIRE BRUSH</u>	-

Visual Examination of Complete Weld Pass Result  
 Type of Test Bend Root or Face  
 Code ASME IX Result Pass

Visual Examination of Complete Weld Pass  
 Type of Test Bend Root or Face  
 Code ASME IX Result Pass

Mechanical test done by NEE Welding Supervised TONY ZELWEGER  
 Laboratory test location Hinnipeg, MB

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Welder Performance Qualification (WPQ)

Welders Name Patrick Dow Identification number 14401  
 WPS used A-MBV-1 Test Coupon 3G  
 Base Metal S052/H32 Thickness .25

	Actual Values	Range Values
Welding process	<u>GMAW</u>	-
Type of Welder	<u>SEMI AUTO</u>	-
Plate or Pipe	<u>PLATE</u>	-
Base metal	<u>S052/H32</u>	-
Filler Metal specs	<u>AWS 5.10</u>	-
Filler Metal class	<u>ER 5356</u>	-
Filler Metal	<u>ALUMINUM</u>	-
Consumable Insert	-	-
Filler Type	<u>WIRE</u>	-
Position Qualified	<u>3G</u>	-
Inert gas Used	<u>99.9% Ar</u>	-
Voltage	<u>23</u>	<u>22-25</u>
Amp	<u>215</u>	<u>215-225</u>
Transfer mode	<u>SPRAY</u>	-
Welder polarity	<u>DCRP</u>	-
Cleaning type	<u>SS WIRE BRUSH</u>	-

Visual Examination of Complete Weld Result PASS  
 Type of Test Bend Root or Face Face  
 Code ASME IX Result PASS

Visual Examination of Complete Weld Result PASS  
 Type of Test Bend Root or Face Face  
 Code ASME IX Result PASS

Mechanical test done by NEE Welding Supervised TONY ZELWEGER  
 Laboratory test location Winnipeg, MB

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# NATIONAL ENERGY EQUIPMENT INC.

## Welder Performance Qualification (WPQ)

Welders Name Patrick Dow Identification number 14401  
 WPS used A-MBO-1 Test Coupon 4G  
 Base Metal S052/H32 Thickness .25

	Actual Values	Range Values
Welding process	<u>GMAW</u>	-
Type of Welder	<u>SEMI AUTO</u>	-
Plate or Pipe	<u>PLATE</u>	-
Base metal	<u>S052/H32</u>	-
Filler Metal specs	<u>AWS 5.10</u>	-
Filler Metal class	<u>ER 5356</u>	-
Filler Metal	<u>ALUMINUM</u>	-
Consumable Insert	-	-
Filler Type	<u>WIRE</u>	-
Position Qualified	<u>4G</u>	-
Inert gas Used	<u>99.9% Ar</u>	-
Voltage	<u>23.</u>	<u>22-25</u>
Amp	<u>215</u>	<u>215-225</u>
Transfer mode	<u>SPRAY</u>	-
Welder polarity	<u>DCEP</u>	-
Cleaning type	<u>SS WIRE BRUSH</u>	-

Visual Examination of Complete Weld Result Pass  
 Type of Test Bend Root or Face  
 Code ASME IX Result Pass

Visual Examination of Complete Weld Result Pass  
 Type of Test Bend Root or Face  
 Code ASME IX Result Pass

Mechanical test done by NEE Welding Supervised TONY ZEHWEGER  
 Laboratory test location Winnipeg, MB

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Date Sep/25/2017 Organization National Energy Equipment

Signature 