

Date: Sep/25/2017

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					
	Visual				
	Examination of				
Sample ID	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 Preformed By: _	Scott Gira	
Test Date:	Sep/25/2017	



Welders Name WPS used Base Metal	A-MBE SOSA/1	133 -1 -7	Identificatior Test Coupon Thickness	number	14401 1 67 . 25
		Actua	al Values	Range Va	luos
Welding process		-70	hAw	nunge ve	nues
Type of Welder			AL AUTO		
Plate or Pipe		5	ATE		
Base metal		57	DS72/H32		and the second
Filler Metal specs	6	Ac	NS 5.10		- Construction of the second
Filler Metal class		ER	5356		
Filler Metal		ALL	MINUM		
Consumable Inse	rt				
Filler Type		C.	JIRE		Bankin (managa miling managa manag
Position Qualified	k		16		
Inert gas Used	_	99	9 % Ar		
Voltage		Q	3.	22-	25
Amp	-	2	15	215-	225
Transfer mode	-	51	RAY	~	and the second sec
Welder polarity	_	DC	LEP	-	NAME & STREET, STRE
Cleaning type	-	SS	WIRE BRUSH		

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Visual Examination of Complete Type of Test <u>Bend</u> Code <u>ASME TX</u>	Root or Face Result
Visual Examination of Complete	Weld Pass
Type of Test <u>Bend</u>	For Face
Code <u>ASME IX</u>	Result Pass

Mechanical test done by <u>NEE</u> Welding Supervised TONY ZEIIWEGER

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 for all Signature



Welders Name Andreas WPS used A-M Base Metal SOS	<u>BH-1</u> Test Coupor	
	Actual Values	Range Values
Welding process	GMAW	-
Type of Welder	SEMI AUTO	and the second
Plate or Pipe	PLATE	
Base metal	5052/H32	
Filler Metal specs	AWS 5.10	
Filler Metal class	ER 5356	
Filler Metal	AWMINUM	
Consumable Insert		
Filler Type	WIRE	
Position Qualified	26	
Inert gas Used	99.9 % Ar	
Voltage	Q3.	10-05
Amp	215	215-225
Transfer mode	SPRAY	
Welder polarity	DCEP	~

Visual Examination of Complete	Weld Result
Type of Test	Root of Face
Code	Result Result
Visual Examination of Complete Type of Test Code	Weld Pass Result Result

Cleaning type

SS WIRE BRISH

Mechanical test done by <u>NEE</u> Welding Supervised TONY ZEIIWEGER

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



Welders Name WPS used Base Metal	<u>Анекк D.</u> <u>А-MBU-</u> 5052/1	1 - - -	Identification Test Coupon Thickness	n number	14401 35 .25
Welding process			I Values	Range Va	lues
Type of Welder	5		haw		
		SEN	11 AUTO	~	
Plate or Pipe		PLI	376		
Base metal		_50	<u>)52/H32</u>		
Filler Metal spec		_AL	NS 5.10		
Filler Metal class	i	<u> </u>	5356		
Filler Metal		_ALL	IMINOM		and the second design of the second
Consumable Inse	ert		-		
Filler Type		Cr	URE		- NYEMBER Harris and some particular
Position Qualifie	d	-	36		
Inert gas Used		99	9 % Ar		
Voltage	-	Q	3.	22-	25
Amp		2	15	0 :	2.25
Transfer mode			RAY	-	20-2
Welder polarity		DC	Eρ	-	
Cleaning type	-	55	WIRE BRUSH	~	
					and the second second second

Visual Examination of Complete Weld <u>Result</u> Type of Test <u>Bend</u> Root of Face Code <u>ASME IX</u> Result <u>Result</u>	
Visual Examination of Complete Weld Ress Type of Test Benc Root or Face Code ASMETX Result PLSS	

Mechanical test done by		Welding Supervised	TONY	ZELLIFERED
Laboratory test location	Winnipeg, MB			CHOURGER

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Date Sep/25/2017 Organization National Energy Equipment Signature



Welders Name ATRICK WPS used A-MBi Base Metal 50.52	│ Identification	number <u>14401</u> <u>4 6</u> , 25
	Actual Values	Range Values
Welding process	GMAW	
Type of Welder	SEMI AUTO	
Plate or Pipe	PLATE	
Base metal	_5052/H32	
Filler Metal specs	AWS 5.10	
Filler Metal class	E.R 5356	
Filler Metal	ALUMINUM	
Consumable Insert		
Filler Type	WIRE	
Position Qualified	46	
Inert gas Used	99.9 % Ar	
Voltage	<u></u> 23	12-25
Amp	<u></u>	215-225
Transfer mode	_SPRA-1	-
Welder polarity	DCEP	~
Cleaning type	SS WIRE BRISH	-

Result
Visual Examination of Complete Weld
Type of Test Bend Root or Face
Code AGME IX Result Pass
Visual Examination of Complete Weld <u>Pass</u> Type of Test <u>Benc</u> Roof or Face Code ASMETX Result Pass
Mechanical test done by <u>NEE</u> Welding Supervised <u>TONY</u> <u>ZEHWEGER</u> Laboratory test location <u>Winnipeg</u> , <u>MB</u>

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 <u>Sep/25/2017</u>	Organization National	Energy	Equipment
Signature	thi		