



Date:

Prepared for: Serge Vienneau Branch: Moncton

Sample Description: Weld Test Coupons Welder ID Number: 5302

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

Test Results


| Sample ID | Visual Examination of Weld | Location | Bend Test | Comments |
|-----------|----------------------------|----------|-----------|----------|
| 1G | X | Face | PASS | |
| 2G | X | | PASS | |
| 3G | X | | PASS | |
| 4G | X | | PASS | |
| 1G | X | Root | PASS | |
| 2G | X | | PASS | |
| 3G | X | | PASS | |
| 4G | X | | PASS | |

Test Findings

All positions passed bend test.

Recommendations

No recommendations needed.

Test Performed By: 
Scott Gira

Test Date: APR/02/2018

Welders Name: Serge Vienneau
 WPS Used: A-MBE-2
 Base Metal: 6061 T6

Identification Number: 5302
 Test Coupon: 1G
 Thickness: 1/4"

| | 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>6061 T6</u> |
| Filler Metal Spec | <u>AWS 5.10</u> | <u>AWS 5.10</u> |
| Filler Metal Class | <u>ER 5356</u> | <u>ER 5356</u> |
| Filler Metal | <u>Aluminum</u> | <u>Aluminum</u> |
| Consumable Insert | | |
| Filler Type | <u>Wire</u> | <u>Wire</u> |
| Position / Progression | <u>Flat 1G/VA</u> | <u>Flat 1G/VA</u> |
| Inert Gas Used | <u>99.99 % Ar</u> | <u>99.99 % Ar</u> |
| Voltage | <u>24.5</u> | <u>22-25</u> |
| Amperage | <u>auto</u> | <u>230-260</u> |
| Transfer Mode | <u>Spray Arc</u> | <u>Spray Arc</u> |
| Welder Polarity | <u>DCRP</u> | <u>DCRP</u> |
| Cleaning Type | <u>Wire Brush</u> | <u>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: Derek Lutes
 Location: NEE - Moncton NB

Signature: [Signature]

Results of Bend Test

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

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

Mechanical Test Performed by: Scott Gira
 Location: NEE, Winnipeg

Signature: [Signature]

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: April 2 / 2018
 Name: Chris Gerdl

Organization: National Energy Equipment
 Signature: [Signature]

Welders Name: Serge Vienneau
 WPS Used: A-MBH-2
 Base Metal: 6061 T6

Identification Number: 5302
 Test Coupon: 2G
 Thickness: 1/4"

| | 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>6061 T6</u> |
| Filler Metal Spec | <u>AWS 5.10</u> | <u>AWS 5.10</u> |
| Filler Metal Class | <u>ER 5356</u> | <u>ER 5356</u> |
| Filler Metal | <u>Aluminum</u> | <u>Aluminum</u> |
| Consumable Insert | | |
| Filler Type | <u>Wire</u> | <u>Wire</u> |
| Position / Progression | <u>Horizontal 2G/UT</u> | <u>Horizontal 2G/UT</u> |
| Inert Gas Used | <u>99.99 % Ar</u> | <u>99.99 % Ar</u> |
| Voltage | <u>24.5</u> | <u>22 - 25</u> |
| Amperage | <u>auto</u> | <u>215 - 230</u> |
| Transfer Mode | <u>Spray Arc</u> | <u>Spray Arc</u> |
| Welder Polarity | <u>DCRP</u> | <u>DCRP</u> |
| Cleaning Type | <u>Wire Brush</u> | <u>Wire Brush</u> |

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Welding Supervisor: Derek Lutes
 Location: NEE - Moncton NB

Signature: [Signature]

Results of Bend Test

Visual Examination of Complete Weld: Pass
 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 Performed by: Scott Gira
 Location: NEE, Winnipeg

Signature: [Signature]

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: April 2 / 2018
 Name: Chris Gerullo

Organization: National Energy Equipment
 Signature: [Signature]

Welders Name: Serge Vienneau
 WPS Used: A-MBU-2
 Base Metal: 6061 T6

Identification Number: 5302
 Test Coupon: 3A
 Thickness: 1/4"

| | 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>6061 T6</u> |
| Filler Metal Spec | <u>AWS 5.10</u> | <u>AWS 5.10</u> |
| Filler Metal Class | <u>ER 5356</u> | <u>ER 5356</u> |
| Filler Metal | <u>Aluminum</u> | <u>Aluminum</u> |
| Consumable Insert | | |
| Filler Type | <u>Wire</u> | <u>Wire</u> |
| Position / Progression | <u>Vertical 3G/1H</u> | <u>Vertical 3G/1H</u> |
| Inert Gas Used | <u>99.99 % Ar</u> | <u>99.99 % Ar</u> |
| Voltage | <u>24</u> | <u>22-25</u> |
| Amperage | <u>auto</u> | <u>190-210</u> |
| Transfer Mode | <u>Spray Arc</u> | <u>Spray Arc</u> |
| Welder Polarity | <u>DCRP</u> | <u>DCRP</u> |
| Cleaning Type | <u>Wire Brush</u> | <u>Wire Brush</u> |

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Welding Supervisor: Desrek Lutes
 Location: NEE - Moncton NB

Signature: [Signature]

Results of Bend Test

Visual Examination of Complete Weld: Pass
 Type of Test: Bend Root of 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 Performed by: Scott Giza
 Location: NEE, Winnipeg

Signature: [Signature]

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: April, 2/2018
 Name: Chris Gerully

Organization: National Energy Equipment
 Signature: [Signature]

Welders Name: Serge Vienneau
 WPS Used: A-MBO-2
 Base Metal: 6061

Identification Number: 5302
 Test Coupon: 4A
 Thickness: 1/4"

| | 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</u> | <u>6061</u> |
| Filler Metal Spec | <u>AWS 5.10</u> | <u>AWS 5.10</u> |
| Filler Metal Class | <u>ER 5356</u> | <u>ER 5356</u> |
| Filler Metal | <u>Aluminum</u> | <u>Aluminum</u> |
| Consumable Insert | | |
| Filler Type | <u>Wire</u> | <u>Wire</u> |
| Position / Progression | <u>Overhead 4G/UH</u> | <u>Overhead 4G/UH</u> |
| Inert Gas Used | <u>99.99 % Ar</u> | <u>99.99 % Ar</u> |
| Voltage | <u>24</u> | <u>22-25</u> |
| Amperage | <u>auto</u> | <u>215-225</u> |
| Transfer Mode | <u>Spray Arc</u> | <u>Spray Arc</u> |
| Welder Polarity | <u>DCRP</u> | <u>DCRP</u> |
| Cleaning Type | <u>Wire Brush</u> | <u>Wire Brush</u> |

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Welding Supervisor: Derek Lutes
 Location: NEET - Moncton NB

Signature: [Signature]

Results of Bend Test

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

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

Mechanical Test Performed by: Scott Gira
 Location: NEE, Winnipeg

Signature: [Signature]

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Date: April 2, 2013
 Name: Chris Grallis

Organization: National Energy Equipment
 Signature: [Signature]