



STEVE WHITMEE

PROJECT		LOCATION	
WELDING CODE:	AS 1554.1 2004 - STRUCTURAL	SURFACE FINISH:	As welded
WELD CATEGORY / CLASS:	SP	WELDING PROCESS:	GMAW - Pulse - (Pulse MIG)
JOINT TYPE:	Double Bevel Butt Weld	JOINT POSITION:	1G - (Flat)
MATERIAL TYPE:	Carbon Steel	PLATE POSITION QUALIFIED:	1G
MATERIAL HEAT NUMBER:	6797049	THICKNESS QUALIFIED:	12mm
MATERIAL GRADE:	350	INTER RUN CLEANING METHOD:	Grind / Wire Brush
MATERIAL GROUP N° / P N°:	AS 1554.1 Gr 5 CE=4 / ASME IX P1 Gr 1	BACK GOUGING METHOD:	Arc Air Gouge and Penetrant Inspect
MATERIAL THICKNESS:	Reference Drawing	COOL RATE:	Natural

JOINT PREPARATION	PASS SEQUENCE	JOINT DETAILS																														
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WELD PASS DETAILS				ELECTRODE CLASSIFICATION		WELDING PARAMETERS			TRAVEL SPEED	INTER PASS	HEAT INPUT	STRINGER / WEAVE
RUN	SIDE	POS.	DIR.	SIZE mm	CLASSIFICATION	AMPS	VOLTS	POL.	mm/min	TEMP(°C)	KJ/mm	Max Width
	1	1G	N/A	1.6	ES6-GM/GC-W503H	320	25	DCEP	350	10 - 350	1.4	Stringer
	1	1G	N/A	1.6	ES6-GM/GC-W503H	320	25	DCEP	350	10 - 350	1.4	Stringer
3	1	1G	N/A	1.6	ES6-GM/GC-W503H	320	25	DCEP	350	10 - 350	1.4	Stringer
4	2	1G	N/A	1.6	ES6-GM/GC-W503H	320	25	DCEP	350	10 - 350	1.4	Stringer
5	2	1G	N/A	1.6	ES6-GM/GC-W503H	320	25	DCEP	350	10 - 350	1.4	Stringer

CONSUMABLE DETAILS				ELECTRODE FILLER METALS DETAIL			
FLUX:	Not Applicable	TUNGSTEN TYPE:	Not Applicable	STICK OUT:	20-25mm	AUSTRALIAN CLASSIFICATION:	AS 2717.1 : ES6-GM/GC-W503H
DIAMETER:	Not Applicable	OTHER:	Not Applicable	NOZZLE SIZE:		AWS/ASME-SFA CLASSIFICATION:	SFA-5.18 : ER70S-6
SHIELD GAS TYPE:	CORGON 18	FLOW RATE:	25 L/min	FILLER / A N°:	ASME A 1	FILLER GROUP / FN°:	ASME GMAW - F6 AS 3992 GMAW - F6
PURGE GAS TYPE	None	FLOW RATE:	Not Applicable	Wire Feed Speed:	6.1 M/min AT 320 AMPS	ELECTRODE TREATMENT:	Manufacturers Recommendations

This QA document has been prepared in accordance with the referenced Codes and Standards

DOCUMENTED BY:	<i>M. DRENNAN</i>	NDT & MECHANICAL TEST REPORT N°(s):	<i>QRM05-0473-06</i>
SIGNED:	<i>M. Drennan</i>	DATE:	<i>30-9-05</i>

Report No: QRM05-0473-06
Job Number: 74000003
Interim Report: Yes, faxed on 30-09-2005
Date of Issue: 30-09-2005
Page: 1 of 3
Client: **GAY CONSTRUCTIONS**
Attention: **Mr R Janse**
Address: **360 Lytton Rod, Morningside**
QLD 4170
Order Number: G 17311
Job Description: The machining and macro examination of (1) only butt-welded plate procedure and welder qualification coupon.
Test Piece Identification: **WP No: PQR No: BW001 Rev 0**
Welder: Steve Whitmee
Welding Position: 1G Flat
Welding Process: PGMAW
Nominated Material Specification: AS/NZS 3678-1996 Grade 350
Thickness: 12mm to 12mm
Manufacturing Specification: AS/NZS 1554.1 – 2004 Category SP
Test Specification: AS 2205.5.1 – 2003
Date of Examination: 30-09-2005

Refer to the following page(s) for test results.

MACRO CROSS SECTION TEST

AS 2205.5.1 – 2003

Identification
Location of Test Piece
Surface Preparation
Etchant
Visual Examination

Macro No.1
Through centre of coupon
Wet Polishing to P1200 grit
10% Nital
No defects evident

RESULT

COMPLIES

NOTE: REFER ATTACHED MACRO PHOTOGRAPH



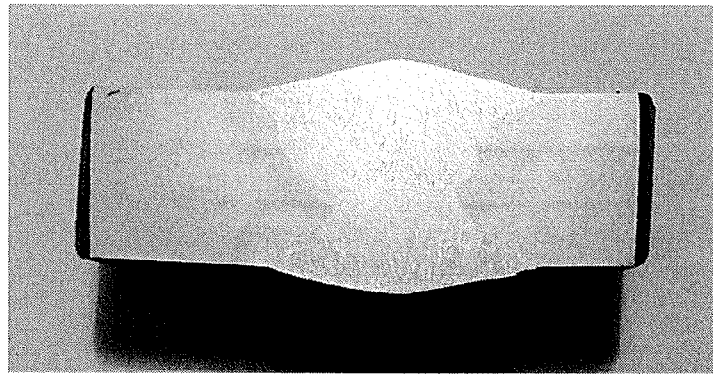
Colin Green
Team Leader – Mechanical Testing



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Accreditation # **218**
Site # **852**

Note: Test plates and specimens will be disposed of 14 days from issue date of this report unless other arrangements have been made.



Macro 1