

Cinnabar California
 1040 N. Las Palmas
 Los Angeles, CA 90038

P.O. #113652

9/8/94

AWS D-1.2

Name Mike Borsch Clock No. _____ Stamp No. _____ Retest _____
 Welding Process _____ Type Miller Power Supply
 In accordance with welding procedure specification WPS No. _____ and PQR No. _____
 Material Group 6061-T6 Aluminum To Group _____ Alloy _____ To _____
 Thickness of Test Material 1" x 2" x .125
 Filler Metal F No. 5356 AWS Class _____ Diameter _____
 Other _____
 Position 2F Backing Material _____
(Fig. 20, 69)
 Electrical Characteristics: Current _____ Polarity _____
 Shielding Gas _____ Flow _____

For Information Only

Power Source _____
(Make, model, type)
 Wire Feeder _____
 Welding Torch _____

VISUAL INSPECTION (9.8.1)

Appearance Satisfactory Undercut _____ Piping Porosity _____

GUIDED BEND TEST RESULTS

Type of bend	Specimen thick., in.	Bend jig Fig. no.	Bend diam., in.	Result	Type of bend	Specimen thick., in.	Bend jig Fig. no.	Bend diam., in.	Result

Radiographic results: Alternative qualification of groove welds by radiography in accordance with Subs. 5.7.3 _____

Test conducted by _____ Laboratory: Test No. _____
 per _____

FILLET WELD TEST RESULTS

Fracture test: Satisfactory
(Describe the location, nature, and size of any crack or tearing of specimen.)
 Length and percent of defects _____ Inches _____ %
 Appearance: Fillet Size _____ in. X _____ in. Convexity or Concavity _____ in.
 Test conducted by Durkee Testing Laboratories Laboratory: Test No. Lab #25055
 per Kenneth R. John Log #4712M
KENNETH R. JOHN
MECH. LAB SUPERVISOR

We certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of ANSI/AWS D1.2, Structural Welding Code-Aluminum.

Signed _____ By _____
(Organization)
 Date _____ Title _____



FILE NO: 18601

WELDER AND WELDING OPERATOR QUALIFICATION TEST RECORD

Welder or welding operator's name MIKE BORSCH Identification no. SSN#550-63-3811
 Welding process GMAW Manual Semiautomatic X Machine
 Position 6G UPHILL

(Flat, horizontal, overhead or vertical - if vertical, state whether upward or downward)

In accordance with procedure specification no.

Material specification ASTM A53 GRADE B

Diameter and wall thickness (if pipe) - otherwise, joint thickness 8" SCHEDULE 80 PIPE

Thickness range this qualifies 0.187 TO UNLIMITED

FILLER METAL

Specification no. AWS A5.18 Classification AWSER70S-6 F no. 8

Describe filler metal (if not covered by AWS specification)

Is backing strip used? YES

Filler metal diameter and trade name 0.035 DI. TIGER BRAND Flux for submerged arc or gas for gas metal arc or flux 602-85% / ARGON-15%

VISUAL INSPECTION (9.25.1)

Appearance GOOD Undercut NONE Piping porosity NONE

Guided Bend Test Results

Type	Result	Type	Result
SIDE BEND	PASSED	SIDE BEND	PASSED
SIDE BEND	PASSED	SIDE BEND	PASSED

Test conducted by SMITH EMERY COMPANY Laboratory test no. 88546M
 per R.W. PATTERSON Test date 12/21/88

N/A

Fillet Test Results

Appearance Fillet size
 Fracture test root penetration Macroetch

(Describe the location, nature, and size of any crack or tearing of the specimen.)

Test conducted by Laboratory test no.
 per Test date

N/A

RADIOGRAPHIC TEST RESULTS

Film identification	Results	Remarks	Film identification	Results	Remarks

Test witnessed by Test no.
 per

We, the undersigned, certify that the statements in this record are correct and that the welds were prepared and tested in accordance with the requirements of 5C or D of AWS D1.1, (88) Structural Welding Code.

WELD TEST WITNESSED BY R. W. Patterson

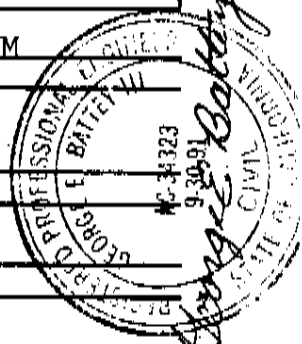
SMITH EMERY COMPANY

Manufacturer or contractor SHOW MOTION DESIGN

Authorized by

Date 12/28/88

Form E-4 DATE: 12/16/88





FILE NO: 18601

WELDER AND WELDING OPERATOR QUALIFICATION TEST RECORD

Welder or welding operator's name MIKE BORSCH Identification no. SSN# 550-63-3118
 Welding process GMAW Manual _____ Semiautomatic X Machine _____
 Position 6G UPHILL
 (Flat, horizontal, overhead or vertical - if vertical, state whether upward or downward)
 In accordance with procedure specification no. _____
 Material specification ASTM A53 GRADE B
 Diameter and wall thickness (if pipe) - otherwise, joint thickness 8" SCHEDULE 80 PIPE
 Thickness range this qualifies 0.187 TO UNLIMITED

FILLER METAL

Specification no. AWS A5.18 Classification AWSER70S-6 F no. 8
 Describe filler metal (if not covered by AWS specification) _____
 Is backing strip used? YES
 Filler metal diameter and trade name _____ Flux for submerged arc or gas for gas metal arc or flux
0.035 DIAMETER ESAB cored arc welding CO2-25%/ARGON-75%

VISUAL INSPECTION (9.25.1)

Appearance GOOD Undercut NONE Piping porosity NONE

Guided Bend Test Results

Type	Result	Type	Result
SIDE BEND	PASSED	SIDE BEND	PASSED
SIDE BEND	PASSED	SIDE BEND	PASSED

Test conducted by SMITH EMERY COMPANY Laboratory test no. 88546M
 per R. W. PATTERSON Test date 12/21/88
 N/A R. W. Patterson Fillet Test Results

Appearance _____ Fillet size _____
 Fracture test root penetration _____ Macroetch _____
 (Describe the location, nature, and size of any crack or tearing of the specimen.)

Test conducted by _____ Laboratory test no. _____
 per _____ Test date _____

RADIOGRAPHIC TEST RESULTS

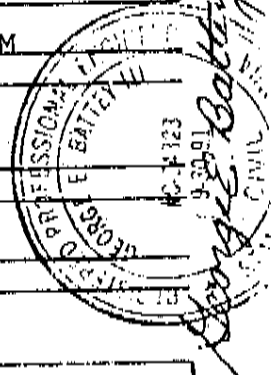
Film identification	Results	Remarks	Film identification	Results	Remarks

Test witnessed by _____ Test no. _____
 per _____

We, the undersigned, certify that the statements in this record are correct and that the welds were prepared and tested in accordance with the requirements of BC or D of AWS D1.1, (88) Structural Welding Code.

ELD TEST WITNESSED BY [Signature]
 DATE 12/28/88
 SMITH EMERY COMPANY

Manufacturer or contractor SHOW MOTION DESIG
 Authorized by _____
 Date 12/28/88





FILE NO: 18601

WELDER AND WELDING OPERATOR QUALIFICATION TEST RECORD

Welder or welding operator's name MIKE BORSCH Identification no. SSN 4550-63-3118
 Welding process GMAW Manual Machine
 Position 6G UPHILL
 (Flat, horizontal, overhead or vertical - if vertical, state whether down or up)
 In accordance with procedure specification no. _____
 Material specification ASTM A53 GRADE B
 Diameter and wall thickness (if pipe) or otherwise, joint thickness SCHEDULE 80 PIPE
 Thickness range this qualifies 0.187 TO UNLIMITED

FILLER METAL

Specification no. AWS A5.18 Classification AWSER70S-6 F no. 8
 Describe filler metal (if not covered by AWS specification) _____

Is backing strip used? YES
 Filler metal diameter and trade name 0.35 DIAMETER ER70S-6 Flux ER70S-6 or gas for gas metal arc or flux ER70S-6/ARGON-757

VISUAL INSPECTION

Appearance GOOD Undercut NONE Cracking NONE Spalling NONE

Guided Bend Test Results

Type	Result	Type	Result
SIDE BEND	PASSED	SIDE BEND	PASSED
SIDE BEND	PASSED	SIDE BEND	PASSED

Test conducted by SMITH-EMERY COMPANY Laboratory test no. 88546M
 per R. W. PATTERSON Test date 12/21/88

N/A

Appearance _____
 Fracture test foot penetration _____ Microetch _____
 (Describe the location, nature, and size of any crack or tearing of the specimen)

Test conducted by _____ Laboratory test no. _____
 per _____ Test date _____

N/A

RADIOGRAPHIC TEST RESULTS

Film Identification	Results	Remarks	Remarks

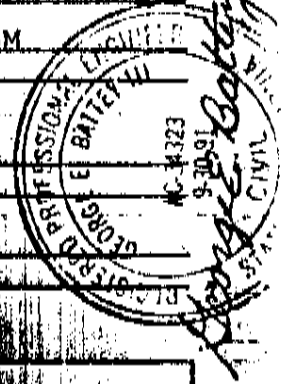
Test witnessed by _____
 per _____

We, the undersigned, certify that the test was conducted in accordance with the requirements of the American Welding Society in accordance with the requirements of the American Welding Society.

WELD TEST WITNESSED BY _____

SMITH-EMERY COMPANY

Form E-1 DATE: _____





FILE NO: 18601

WELDER AND WELDING OPERATOR QUALIFICATION TEST RECORD

Welder or welding operator's name MIKE BORSCH Identification no. SSN# 550-63-3118
 Welding process GMAW Manual Semiautomatic X Machine
 Position 6G UPHILL
 (Flat, horizontal, overhead or vertical - If vertical, state whether upward or downward)
 In accordance with procedure specification no.
 Material specification ASTM A53 GRADE B
 Diameter and wall thickness (if pipe) - otherwise, joint thickness 8" SCHEDULE 80 PIPE
 Thickness range this qualifies 0.187 TO UNLIMITED

FILLER METAL

Specification no. AWS A5.18 Classification AWSER70S-6 F no. 8
 Describe filler metal (if not covered by AWS specification)
 Is backing strip used? YES
 Filler metal diameter and trade name 0.35 DIAMETER ESAB Flux for submerged arc or gas for gas metal arc or flux
 cored arc welding CO2-25%/ARGON-75%

VISUAL INSPECTION (8.25.1)

Appearance GOOD Undercut NONE Piping porosity NONE

Guided Bend Test Results

Type	Result	Type	Result
SIDE BEND	PASSED	SIDE BEND	PASSED
SIDE BEND	PASSED	SIDE BEND	PASSED

Test conducted by SMITH EMERY COMPANY Laboratory test no. 88546M
 per R. W. PATTERSON Test date 12/21/88

N/A

Fillet Test Results

Appearance Fillet size
 Fracture test root penetration Macroetch
 (Describe the location, nature, and size of any crack or tearing of the specimen.)

Test conducted by Laboratory test no.
 per Test date

N/A

RADIOGRAPHIC TEST RESULTS

Film Identification	Results	Remarks	Film Identification	Results	Remarks

Test witnessed by
 per

We, the undersigned, certify that the statements in this record are true and that the welds were prepared and tested in accordance with the requirements of BC or D of AWS D1.1, () or the American Welding Code.

WELD TEST WITNESSED BY R. W. Patterson

SMITH EMERY COMPANY

Manufacturer/contractor SHOW MOTION DESIGN

Date 12/28/88

Form E-4 DATE: 12/28/88

Cinnabar California
 1040 N. Las Palmas
 Los Angeles, CA 90038

P.O. #113652

9/8/94

AWS D-1.2

Name Mike Borsch Clock No. _____ Stamp No. _____ Retest _____
 Welding Process _____ Type Miller Power Supply
 In accordance with welding procedure specification WPS No. _____ and PQR No. _____
 Material Group 6061-T6 Aluminum To Group _____ Alloy _____ To _____
 Thickness of Test Material 1" x 2" x .125
 Filler Metal F No. 5356 AWS Class _____ Diameter _____
 Other _____
 Position 2F Backing Material _____
(S, ZG, 6G)
 Electrical Characteristics: Current _____ Polarity _____
 Shielding Gas _____ Flow _____

For Information Only

Power Source _____
(Make, model, type)
 Wire Feeder _____
 Welding Torch _____

VISUAL INSPECTION (9.8.1)

Appearance Satisfactory Undercut _____ Piping Porosity _____

GUIDED BEND TEST RESULTS

Type of bend	Specimen thick., in.	Bend jig Fig. no.	Bend diam., in.	Result	Type of bend	Specimen thick., in.	Bend jig Fig. no.	Bend diam., in.	Result

Radiographic results: Alternative qualification of groove welds by radiography in accordance with Subs. 5.7.3 _____

Test conducted by _____ Laboratory: Test No. _____
 per _____

FILLET WELD TEST RESULTS

Fracture test Satisfactory
(Describe the location, nature, and size of any crack or tearing of specimen.)
 Length and percent of defects _____ inches _____ %
 Appearance: Fillet Size _____ in. X _____ in. Convexity or Concavity _____ in.
 Test conducted by Darkee Testing Laboratories Laboratory: Test No. Lab #Z5055
 per Kenneth R. John Log #4712M
KENNETH R. JOHN
MECH. LAB SUPERVISOR

We certify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of ANSI/AWS D1.2, Structural Welding Code - Aluminum.

Signed _____ By _____
(Organization)
 Date _____ Title _____

Form Etc.)