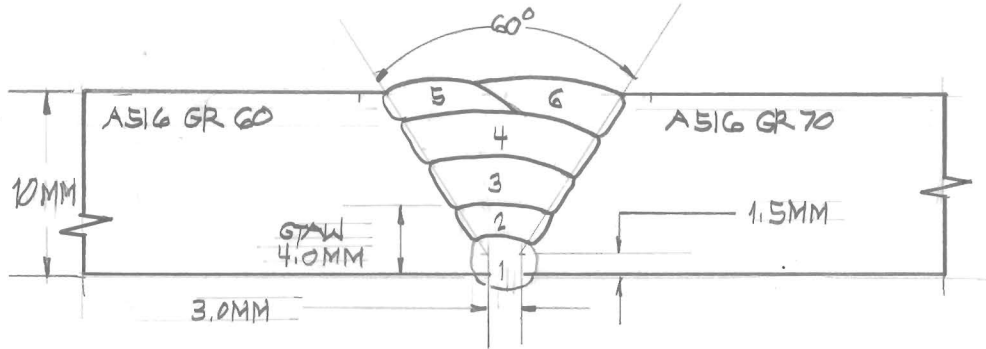


ACTUAL PARAMETERS OF PROCEDURE QUALIFICATION TEST

Test Location: _____	DAEWOO WELDING SCHOOL	Date: <u>18 JAN 2008</u>
PQR No.: <u>GBU-PQT-04</u>	WPS _____	<u>GBU-IAI-GTSM-35</u>
Welding Process: <u>GTAW + SMAW</u>	Position/Progression: _____	<u>3G UPHILL</u>
Base Metal: <u>A516 GR 60 & A516 GR 70</u>	Heat No1.: _____	<u>86656</u>
Thickness: <u>10.0 MM</u>	Heat No2.: _____	<u>88088</u>
Weld Thickness: <u>GTAW 4.0MM SMAW 6.0MM</u>	Gas Flow Rate l/h: Shielding _____	<u>15 L/MIN.</u>
Surface Temperature: <u>26 °C</u>	Interpass Temperature: _____	<u>120 °C</u>



CONSUMABLE	BRAND / TYPE	CLASS	Dia	HEAT No. / LOT No.
FILLER WIRE	1 HYUNDAI / ST-50G	SA5.1BER705-G	2.4	7620305
FILLER WIRE	2 HYUNDAI / ST-50G	SA5.1BER705-G	3.2	6620301
ELECTRODES	3 HYUNDAI / S-7016 LS	SA5.5E7016-G	2.6	75605
ELECTRODES	4 HYUNDAI / S-7016 LS	SA5.5E7016-G	3.2	75603
ELECTRODES	5			
SHIELDING GAS	ARGON			

WELDER NAME: (1): <u>S. H. SONG</u>	STAMP No.: <u>GBU-W-33</u>
WELDER NAME: (2): _____	STAMP No.: _____

WELD LAYER	PROCESS	FILLER METAL		CURRENT			TRAVEL SPEED (mm/min)	HEAT INPUT (J/mm)	TEMP. °C
		CLASS	Dia	POL	AMP	VOLTAGE			
1	GTAW	ERT05-G	2.4	DC/SP	88	10	75	704	26
2	GTAW	ERT05-G	3.2	DC/SP	117	11	93	830	78.9
3	SMAW	E7016-G	2.6	DC/RP	100	24	60	2400	79
4	SMAW	E7016-G	3.2	DC/RP	117	24	47	3548	90
5	SMAW	E7016-G	2.6	DC/RP	100	24	74	1945	120
6	SMAW	E7016-G	2.6	DC/RP	99	25	73	2034	

VISUAL RESULT: ACCEPTED

PREPARED BY: CHARLIE SENO

WITNESSED BY: ANASONYE, I. Sam
18/03/2008