



AMERICAN BUREAU OF SHIPPING

Two World Trade Center, 106th Floor
New York, New York 10048

Page 1 of 1

Report No.: SG108213-C

Date: 23 NOVEMBER 2000

Port: SINGAPORE

WELDING PROCEDURE QUALIFICATION TEST

THIS IS TO CERTIFY THAT THE UNDERSIGNED SURVEYOR TO THIS BUREAU DID , AT THE REQUEST OF GOLTENS SINGAPORE PTE LTD , ATTEND THE PLANT AT NO.6A BENOI ROAD , SINGAPORE 629881 ON 11 OCTOBER 2000 AND SUBSEQUENT DATES IN ORDER TO WITNESS AND REPORT ON PROCEDURE QUALIFICATION TEST :-

1. WELDING PROCEDURE WAS CARRIED OUT IN ACCORDANCE WITH GOLTENS SINGAPORE PTE LTD PROCEDURE SPECIFICATION NO. GS005.9.2.2000 ON PISTON CROWN AND CYLINDER COVER REPAIRS, MATERIAL 16CrMo4.4 AS PER ASME SECTION IX(1995) .
2. WELDING WAS CARRIED OUT BY WELDER : MR. TAN KEE YONG , I/C NO.1555448/G AND MR.KOH AH KENG , I/C NO. 7081856/F ON SMAW PROCESS IN THE 1G POSITION AND UTILIZING 3.2 & 4 MM DIAMETER FILLER METAL , MANUFACTURED BY ESSAB OK (76.18) TO AWS E8018-B2 SPECIFICATION .
3. UPON COMPLETION OF WELDING , THE TEST COUPON WAS CUT AND SUBJECTED TO MECHANICAL TESTS AND RESULTS FOUND AS FOLLOWS :-
 - a. FOUR (4) SIDE BEND-- SATISFACTORY
 - b. TWO (2) REDUCED TENSILE STRENGTH :-
 - i. SPECIMEN T1 - 682 N/MM2
 - ii. SPECIMEN T2 - 683 N/MM2
 - iii. SPECIMEN T3 - 678 N/MM2
 - iv. SPECIMEN T4 - 663 N/MM2
 - c. MACRO-ETCH - SATISFACTORY
4. WELDER MR.TAN KEE YONG , I/C NO .1555448/G AND MR. KOH AH KENG , IC NO. 7081856/F TO BE CONSIDERED SATISFACTORY PASSED THE WELDING QUALIFICATION FOR THIS MATERIAL AND IN 1G POSITION .

SURVEYOR-L.C.THON

Note: This Report evidences compliance with one or more of the Rules, guides, standards or other criteria of American Bureau of Shipping and is issued solely for the use of the Bureau, its committees, its clients or other authorized entities. This Report is a representation only that the structure, item of material, equipment, machinery or any other item covered by this Report has met one or more of the Rules, guides, standards or other criteria of American Bureau of Shipping as of the date of issue. Parties are advised to review the Rules for the scope and conditions of classification and to review the survey records for a fuller description of any restrictions or limitation on the vessel's service or surveys. The validity, applicability and interpretation of this Report is governed by the Rules and standards of American Bureau of Shipping who shall remain the sole judge thereof. Nothing contained in this Report or in any notation made in contemplation of this Report shall be deemed to relieve any designer, builder, owner, manufacturer, seller, supplier, repairer, operator or other entity of any warranty express or implied.