



AMERICAN BUREAU OF SHIPPING

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Page 1 of 1

Report No.: SG108213-D

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. GS004.9.2.2000 ON CYLINDER COVER REPAIRS, MATERIAL C35E/CK35 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 (48.04) TO AWS E 7018 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 - 587 N/MM2
 - ii. SPECIMEN T2 - 578 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

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