



Customer Name **ACORN INDUSTRIES CO. LLC**
Attending Office **Dubai**
First Visit Date **24-Jan-2018**

Purchase Order No.
Report Number **DU3443768**
Last Visit Date **28-Feb-2018**

Welding Procedure Survey

Survey Location : Emirates Industrial City

This is to Certify that the undersigned surveyor(s) to this Bureau did, at the request of the customer, carry out the following survey and report as follows:

The following details of the welding procedure were verified as deemed necessary and presented as contained in this report:

Applicable Rules, Codes, Specifications are referenced

Welding Process Description is available

Base Metal(s) is/are identified

Welding positions are indicated

Filler metal is specified

Shielding gas and flux is indicated

Current is specified

Thermal data is indicated (preheat/ post heat/ inter-pass temperatures)

Joint design is described

Weld backing is specified as applicable

Parameter ranges are described

Test weldment procedure is described

Test specimen locations are indicated

Inspection methods are described

Results of Welding Procedure Test Data are included in facility/ shipyard/ Plant Procedure Qualification Report (PQR)

This procedure is acceptable for this application and test results are satisfactory.

Following welding procedure qualifications was witnessed in accordance with ASME Sec IX ED 2017 and report as follows:

I.WPS No : WPS-010 Rev.0

PQR No: ACORN/PQR/006

Material: Pipe SA 106 Gr.B- 2 Sch 160 (8.74mm)

Process: GTAW+SMAW

Filler Metal: ER 70 S6 ,2.4 mm+E7018,2.5 mm

Position: 6G

Preheat: 32 Deg C

Interpass: 180 Deg C Maximum

Post Weld Heat Treatment : N/A

II.WPS No : WPS-008 Rev.0

PQR No: ACORN/PQR/004

Material: Plate SA 36- 20 mm

Process: SMAW

Filler Metal:E7018,2.5/3.2 mm

NOTE: This report evidences that the survey reported herein was carried out in compliance with one or more of the Rules, guides, standards or other criteria of the 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 vessel, structure, item or material equipment, machinery or any other item covered by this Report has been examined for compliance with, or has met one or more of the Rules, guides, standards or other criteria of American Bureau of Shipping. 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 the 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.

Customer Name **ACORN INDUSTRIES CO. LLC**
Attending Office **Dubai**
First Visit Date **24-Jan-2018**

Purchase Order No.
Report Number **DU3443768**
Last Visit Date **28-Feb-2018**

Position: 3G
Preheat: 32 Deg C
Interpass: 220 Deg C Maximum
Post Weld Heat Treatment : N/A

III.WPS No : WPS-009 Rev.0
PQR No: ACORN/PQR/005
Material: Plate SA 516 Gr.70 -12 mm + SA 240 TP304L -12 mm
Process: SMAW
Filler Metal:E 309L-16 2.5/3.2 mm
Position: 1G
Preheat: 32 Deg C
Interpass: 150 Deg C Maximum
Post Weld Heat Treatment : N/A

Qualification parameters were recorded as indicated in the Welding Procedure Qualification Record (PQR)
Test coupons were visually examined, Non Destructive Tested using Radiography and found satisfactory.
Testing as per the specifications were carried out as recorded in the Welding Procedure Qualification Test Reports from International Inspection Services Ltd and attached to the Procedure Qualification Records PQR.
The completed Procedure Qualification Records (PQR) and Welders Qualification Certificates of the welders qualified with PQR were endorsed by the undersigned.

**Surveyor(s) to The American Bureau of Shipping
Attending Surveyors**

Gopal Rajesh

Electronically Signed on 28-Feb-2018

Reviewed By

Schilg, Alexander Thomas

Electronically Signed on 01-Mar-2018, Dubai Port

NOTE: This report evidences that the survey reported herein was carried out in compliance with one or more of the Rules, guides, standards or other criteria of the 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 vessel, structure, item or material equipment, machinery or any other item covered by this Report has been examined for compliance with, or has met one or more of the Rules, guides, standards or other criteria of American Bureau of Shipping. 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 the 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.