

# *Royal Metal Industries, Inc.*

Home Builder Division

September 22, 2023

**Address:**

2611 Barley Field Drive

Hook Farms #175

Lee's Summit, Mo. 64082

Welded connections for: Walker Custom Homes

Welding rod 7018 per industry standards was used by our certified welder, Kyle Bauer, a contracted employee through Royal Metal Industries.

Weld Certification attached.

Best Regards,

Tatiana Cheffen,

Inside Sales Representative

Royal Metal Industries

(816-924-1649)

WQTR No. 901636 Welder Name KYLE BAUER Welder Id 901636  
 WPS No. RMI-SMAW-02-21 Revision 0 Date 3/9//2023

**Variables Record Actual Values Used In Qualification**  
 Process (Table 4. 1 0, Item (1)) SMAW  
 Transfer Mode (GMAW): Short-Cir.  Globular  Spray   
 Type Manual  Machine  Semi-Auto  Auto   
 Number of Electrodes Single  Multiple   
 Current/Polarity AC  DCEP  DCEN  Pulsed   
 Position (Table 4. 1 0, Item (4)) OVERHEAD  
 Weld Progression: (Table 4.10, Item (6)) Up  Down   
 Backing [Table 4. 1 0, Item (7)] Use Backing   
 Consumable Insert (GTAW) Use Insert   
 Material/Spec. ASTM-A36 to ASTM-A36  
 Thickness (Plate): Groove ( X ) 3/8"  
 Fillet ( X ) \_\_\_\_\_  
 Thickness (Pipe/tube): Groove ( ) \_\_\_\_\_  
 Fillet ( X ) \_\_\_\_\_  
 Diameter(Pipe): Groove ( ) N/A  
 Fillet ( X ) OVER 24"  
 Notes N/A  
 Filler Metal (Table 1 0, Item (2))  
 Spec. A5.5/A5.5M:2006 A5.1/A5.1:2004  
 Class. E7018-1 & E7018  
 F-No. 4  
 Gas/Flux Type (Table 4. 1 0, Item (3)) IRON POWDER  
 Other N/A

**Qualification Range**  
ALL ELECTRODES F1,F2,F3, & F4 IF 2F, 3F, 1G, 2G, 3G FLAT, PLUG & SLOT WELDS SAME POSITION  
 Short-Circuiting  Globular  Spray   
 Manual  Machine  Semi-Auto  Auto   
 Single  Multiple   
 AC  DCEP  DCEN  Pulsed   
 Up  Down   
 With Backing  Without Backing   
 With Insert  Without Insert   
ALL MATERIALS GROUP #1  
1/8" - 3/4"  
SEE BELOW - SEE BELOW  
SEE BELOW - SEE BELOW  
SEE BELOW - SEE BELOW  
SEE BELOW - SEE BELOW  
SEE BELOW - SEE BELOW  
ANY FILLET OR PJP WELD SIZE ON ANY THICKNESS OF PLATE, PIPE OR TUBING A5.5/A5.5M:2006 A5.1/A5.1M:2004  
ALL ELETRODES F1,F2,F3, & F4 IF,2F,3F,1G,2G,3G FLAT, PLUG & SLOT WELDS SAME POSITION

**VISUAL INSPECTION (4.8.1) Acceptable X**  
 GUIDED BEND TEST RESULTS (4.30.5)

Type	Result	Type	Result
ROOT BEND	ACCEPTABLE	FACE BEND	ACCEPTABLE

Dennis A. Wright  
 CWI 96090251  
 OCT EXP. 8/1/2026

Fillet Test Results (4.30.2.3 and 4.30.4.1)  
 Appearance N/A Fillet Size N/A Macroetch N/A  
 Fracture Test Root Penetration N/A Description N/A  
 Inspected By N/A Test No. N/A Organization N/A Date N/A

**RADIOGRAPHIC TEST RESULTS (4.30.3.1)**

Film Identification No.	Result	Remark	Interpreted By
N/A	N/A	N/A	N/A

Organization N/A  
 Test No. N/A  
 Date N/A

We, the undersigned, 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 section 4 of ANSI/AWS D1. 1, (2020 ) Structural Welding Code-Steel.

Manufacturer ROYAL METAL INDUSTRIES, INC Authorized By RICHARD JACOBSON Date 3/9/2023