

Royal Metal Industries, Inc.
Home Builder Division

September 29, 2023

Address:

2311 SW Serena Place
Summit View Farms #82
Lees Summit, Mo. 64081

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)

1000 W Ironwood Olafhe, KS • 66061 • Tel (913) 829-3000 • Fax (913) 489-0047

ROYAL METAL INDUSTRIES, INC

WQTR No. 901636

Welder Name KYLE BAUER

Welder Id 901636

WPS No. RMI-SMAW-03-21

Revision 0

Date 2/21/2023

Variables

Record Actual Values Used In Qualification

Process (Table 4, 1, 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, Item (4)) 3G

Weld Progression: (Table 4, 1, Item (6)) Up ☒ Down ☐

Backing (Table 4, 1, Item (7)) Use Backing ☒

Consumable Insert (GTAW) ☐ Use Insert ☐

Material/Spec. ASTM-A36 to ASTM-A36

Thickness (Plate): Groove (X) 3/8"

Thickness (Pipe/tube): Groove ()

Thickness ()

Thickness ()

Thickness ()

Thickness ()

Thickness ()

Notes N/A

Filler Metal (Table 10, Item (2))

Spec. A5/A5.5M:2006 A5 1/A5 1:2004

Class. E7018-1 & E7018

F-No. F4

Gas/Flux Type (Table 4, 1, Item (3)) IRON POWDER

Other N/A

VISUAL INSPECTION (4.8, 1) Acceptable

GUIDED BEND TEST RESULTS (4.30.5)

Type Result

Type Result

ROOT BEND

ACCEPTABLE

Face Bend

ACCEPTABLE

Filler Test Results (4.30.2.3 and 4.30.4, 1)

Macroetch N/A

Fracture Test Root Penetration N/A

Test No. N/A

Organization N/A

Date N/A

Interpreted By N/A

Test No. N/A

Date N/A

Organization N/A

Test No. N/A

Date 2/21/2023

Authorized By RICHARD JACOBSON

ROYAL METAL INDUSTRIES, INC

Manufacturer

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 ANSUAWS D1, 1, (2020) Structural Welding Code-Steel.

Qualification Range

ALL ELECTRODES FLAT & P4

IF 2F, 3F, 1G, 2G, 3G FLAT & 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 ☐

1/8"

SEE BELOW

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