

Royal Metal Industries, LLC

Home Builder Division

April 5, 2024

Permit# PRRES20232699

Address: 1201 SW Corinthian
Lees Summit, MO 64081

Welded connections for: Walker Custom Homes

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

Weld Certification attached.

Best Regards,

Ashley Kessler
Homebuilding Office Supervisor
Royal Metal Industries
913-583-4028

ROYAL METAL INDUSTRIES, INC.

WELDER, WELDING OPERATOR, OR TACK WELDER QUALIFICATION TEST RECORD

WQTR No. 6090 Welder Name ARTURO VEGA Welder Id 6090
 WPS No. RMI-SMAW-01-15 Revision 0 Date 10/2/2018

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)) VERTICAL UP 3G
 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) OVER 24"
 Diameter(Pipe): Groove () _____
 Fillet (X) OVER 24"
 Notes N/A
 Filler Metal (Table 10, Item (2))
 Spec. A5.1/A5.1M:2004
 Class. E7018H4R
 F-No. F4
 Gas/Flux Type (Table 4. 1 0, Item (3)) IRON POWDER
 Other N/A

Qualification Range

SMAW
 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 *
 * ANY FILLET OR PJP WELD SIZE ON ANY THICKNESS OF PLATE, PIPE OR TUBING.
A5.1/A5.1M:2004
ALL ELECTRODES GROUP F1,F2,F3 & F4
1F,2F,3F,1G,2G,3G FLAT & PLUG & SLOT WELDS SAME POSITION

VISUAL INSPECTION (4.8.1) Acceptable YES

GUIDED BEND TEST RESULTS (4,30.5)

| Type | Result | Type | Result |
|-----------|------------|-----------|------------|
| ROOT BEND | ACCEPTABLE | FACE BEND | ACCEPTABLE |

 Dennis A Wright
 CWI 96090251
 QC1 EXP. 9/1/2023

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 _____

RADIOGRAPHIC TEST RESULTS (4.30.3.1)

| Film Identification No. | Result | Remark | Interpreted By |
|-------------------------|--------|--------|-------------------------|
| N/A | N/A | N/A | N/A |
| | | | Organization <u>N/A</u> |
| | | | Test No. <u>N/A</u> |
| | | | Date <u>N/A</u> |

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.

Manufacturer ROYAL METAL INDUSTRIES, INC Authorized By RICHARD JACOBSON Date 10/2/2018

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GUIDED BEND TEST RESULTS (4.30.5)

| Type | Result | Type | Result |
|-----------|------------|-----------|------------|
| ROOT BEND | ACCEPTABLE | FACE BEND | ACCEPTABLE |

AWIS
 Dennis A Wright
 CWI 98090 51
 QC1 E-11-2023

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 _____

RADIOGRAPHIC TEST RESULTS (4.30.3.1)

| Film Identification No. | Result | Remark | Interpreted By |
|-------------------------|--------|--------|-------------------------|
| N/A | N/A | N/A | N/A |
| | | | Organization <u>N/A</u> |
| | | | Test No. <u>N/A</u> |
| | | | Date <u>N/A</u> |

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