

# REPAIRER'S DATA REPORT

**JOB NUMBER: 29044**



**Client:** Minespec Parts Pty Ltd (Qld)

**Description:** Hitachi EX5600-6 Stick / Arm MSP-0005217

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## Technical Document Report Index

	Section	Records Provided	
		Yes	No
<b>Certificate of Conformance</b>	<b>1</b>	✓	
<b>QC Check Sheet</b>	<b>2</b>	✓	
<b>NDT Records</b>	<b>3</b>	✓	
<b>Welding Records / Heat sheets</b>	<b>4</b>	✓	
<b>Delivery Docket</b>	<b>5</b>	✓	

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*Section 1*

# CERTIFICATE OF CONFORMANCE

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## CERTIFICATE OF CONFORMANCE

<b>Company Name:</b>	CQ Field Mining Services			
<b>Street Address:</b>	40 Production Dr			
<b>City / Suburb:</b>	Paget	<b>State:</b>	QLD	<b>Postcode:</b> 4740
<b>Purchase Order:</b>		<b>CQFMS Part No:</b>	N/A	
<b>CQFMS Job No.:</b>	29044			
<b>Drawing No.:</b>	N/A	<b>Revision No:</b>	NA	
<b>Date of Overhaul:</b>	April / May 2024	<b>Qty Shipped:</b>	1	
<b>Date Shipped:</b>	21 <sup>st</sup> May 2024	<b>Serial No.</b>	N/A	
<b>Description:</b>	EX 5500 Stick Refurbishment			
<b>Specification/Special Processes:</b>	N/A			

This is to certify that the products and/or services contracted by the Purchase Order have been manufactured, processes, inspected and tested in accordance with all requirements of the purchase order and specified on referenced documents.

Inspection and test results signify that the items delivered are fully acceptable and in complete conformance to all purchase order requirements.

Data and records, not enclosed with this shipment, are maintained on file and are available upon request.

<b>Signature:</b>		<b>Date:</b>	13/06/2024
<b>Position:</b>	Workshop Manager		

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*Section 2*

# QC CHECKLIST

Document Name	Document ID	Version	Issue Date	Page
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**INSPECTION & TEST PLAN**

ITP Number:	29044		
ITP Title:	EX5600 Stick		
Prepared by:	Estimator		
Reviewed by:	Supervisor		
Approved by:	Workshop Manager		

CLIENT:	Minespec	PROJECT LOCATION:	Workshop		
CONTRACTOR:	CQFMS Workshop	CONTRACT/PO #:			
CHECKED BY: PE = Engineer; SUP = Supervisor; NATA = Testing Authority; PM = Project Manager; QA = Quality Manager; QC = Inspector		INSPECTION TYPE:	H = Hold Point M = Monitor	R = Review V = Verify	W = Witness
WITNESSED/VERIFICATION BY (Signed and dated)					

Item No.	Activity Description	Person Responsible	Reference Documents	Acceptance Criteria	Verifying Record	Sub-contractor	CQFMS Workshop Rep	Client	Comments - Yes Or No?
1.00	Bucket Repairs								
1	Scope Review	-EST	-SOW Docs	- Complies to CQFMS Business Model - Workshop Manager to approve	-Signed ITP				
2	Initial N.D.T. Inspection and testing of Items	-NATA	-AS/NZS 1554.1:2014 -AS/NZS 1554.4:2014 Structural steel welding Welding of steel structures	-Complies to Australian Standards	-Welding QA Docs -NATA Report	Verify & Sign			
3	Drawing Verification	-EST	-SOW Docs -Site Inspections -Drawings supplied by site	-Complies to Australian Standard Drawings and Specifications as received from client.	-As per SOW Docs -QC Sheet				
4	Materials receipt, identification, and correlation with certification.	-SUP	Scope Of Work	-Complies to Australian Standards -Complies to Purchase Order	-Material Certification -QC Sheet				
5	Submit welding procedures, welder qualifications and welding consumables.	-SUP	-AS/NZS 1554.1:2014 -AS/NZS 1554.4:2014 Structural steel welding Welding of steel structures	-Complies to Australian Standards	-Welder Certificates -Weld Procedures & Qualifications				
6	Receipt of Materials	-SUP	-Purchase Order -Delivery Dockets	-Complies to Australian Standards -Complies to Purchase Order - SOW	-Delivery Dockets -QC Sheet				
7	Assembly Of Structural & Wear Components	-SUP	-SOW Docs -Site Inspections -Drawings supplied by client	-Complies to Australian Standard Drawings and Specifications as received from client.	-As per SOW Docs -QC Sheet				
8	Welding	-QA -SUP	-AS/NZS 1554.1:2014 -AS/NZS 1554.4:2014 Structural steel welding Welding of steel structures	-Complies to Australian Standards - SOW	-Welding QA Docs -NATA Report				
10	In house Visual Inspection of items on completion of welding & Dimensional check	-SUP	-SOW Docs -Site Inspections -Drawings supplied by site	-Complies to Australian Standard Drawings and Specifications as received from client.	-As per SOW Docs -QC Sheet -Drawings				
11	Final N.D.T. Inspection and testing of Items	-NATA	-AS/NZS 1554.1:2014 -AS/NZS 1554.4:2014 Structural steel welding Welding of steel structures	-Complies to Australian Standards	-Welding QA Docs -NATA Report	Verify & Sign		ATS	
12	Machining - Measure & Record Final Machining Of Bores & Faces	-L/SUP	Drawings	Specified Tolerance	-QC Sheet	Verify & Sign			
12	Weighing	-SUP	Suppliers Procedures	-Complies to Australian Standards	-NATA Report	Verify & Sign			
13	Surface Treatment	-SUP	Scope Of Work	Manufacturers Specs & Recommendation	-QC Sheet			Review & Sign	Hold Point
14	Final inspection & document check	EST/CLIENT	-Signed ITP & Visual Inspection	Client Specification, SOW & Drawing Provided	-QC Sheet -Drawings -NATA Report			Review & Sign	Hold Point

ADDITIONAL COMMENTS & NOTES						
WORK COMPLETED IN ACCORDANCE TO ITP ACCEPTENCE - The acceptance of this ITP does not relieve the Contractor, Subcontractor or Supplier of their Statutory or Contractual obligations						
CQ FIELD SIGN OFF	Name:	L. VILLON	Comments:	CLIENT SIGN OFF	Name:	
	Sign:				Sign:	
	Position:	W. S. Supervisor			Position:	
	Date:	20/5/24			Date:	

*Section 4*

# NDT RECORDS

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## N.D.T. TEST REPORT

ZT:sk  
21MAR24

**REPORT No.:**

R24-0947

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**CLIENT:**

CQ Field Mining Services  
40 Production Drive  
Paget, Qld 4740

**CLIENT CONTACT:**

Mr. B. Sedcole

**ORDER No.:**

56901

**JOB No.:**

29044

**DRAWING No.:**

Not Specified

**ITEM:**

5500 Stick

**DESCRIPTION:**

*Initial* NDT & Inspection of 5500 Stick  
at CQ Field Mining Services Workshop, Mackay.

**TECHNICIAN/S:**

Mr. Z. Tass / Mr. J. Friese / Mr. B. Bell

**DATE OF TEST:**

29FEB24

**WORKSHEET REF. No.:**

MPI 24 - 45363



**INSPECTION DATA:**

PROCEDURE No.: TP-301

TEST STANDARD: AS 1171-1998

ASSOCIATED STANDARD: Not Applicable

SURFACE FINISH: As Welded

SURFACE PREPARATION: Mechanical Cleaned (Needle Gunned)

SURFACE COATINGS: Nil

SURFACE CONDITION:  < 6.3µm Ra,  < 3.2µm Ra

ACC/REJ LIMITS: Record & Report all Cracking

MATERIAL SPECIFICATION: Carbon Steel – No Further Specifications

LIMITATION: Nil

**EQUIPMENT:**

Ultrasonic     Radiographic     Penetrant  
 MPI             Other – Visual

Parker B300S Contour Probe AMP-039  
Castrol Flux Indicator Strip  
Headlamp

MAGNETISATION: Continuous Method

DEMAGNETISATION: No

REF. SENSITIVITY: MPI – 3 Lines Castrol Flux Indicator

CONSUMABLES: Ardrox, Black Magnetic Ink 800/3, Batch # 4980857866  
Ardrox, White Contrast Paint 8901/W, Batch # 4980129572

TEMPERATURE:  10° - 14°     15° - 45°     46° - 50°

RECORD: Photograph

LIGHTING: 1200 Lux

**RESULTS OF EXAMINATION**

**INSPECTION OF 5500 STICK:**

**Initial Magnetic Particle Inspection:**

**Worksheet No. 24 - 45363**

Identification	Result
External Body Job No. 29044 <i>100% Inspection of Prepared Welds</i>	➤ <b>Cracking Evident</b> - <b>Refer to Figures 1 to 4 &amp; Table 1.0 for Results</b>

*Note 1: Lighting Conditions comply with the Requirements of AS 3978 Section 6.1 – 2003*

*Note 2: Bores not Inspected*

*Note 3: 75% of Top of Body not Inspected - Refer to Figure 2*

**SUMMARY OF EXAMINATION**

**INSPECTION OF 5500 STICK:**

**Magnetic Particle Inspection:**

**Worksheet No. 24 - 45363**

Identification	Total No. of Defects	Total Length of Defects	Interpretation
External Body	37	4450mm	New Cracking Evident

*Note 1: Lighting Conditions comply with the Requirements of AS 1171 Section 3.5.2 1998*

**Technicians:**

*Zackary Tass*

*Jayden Friese*

*Brodie Bell*

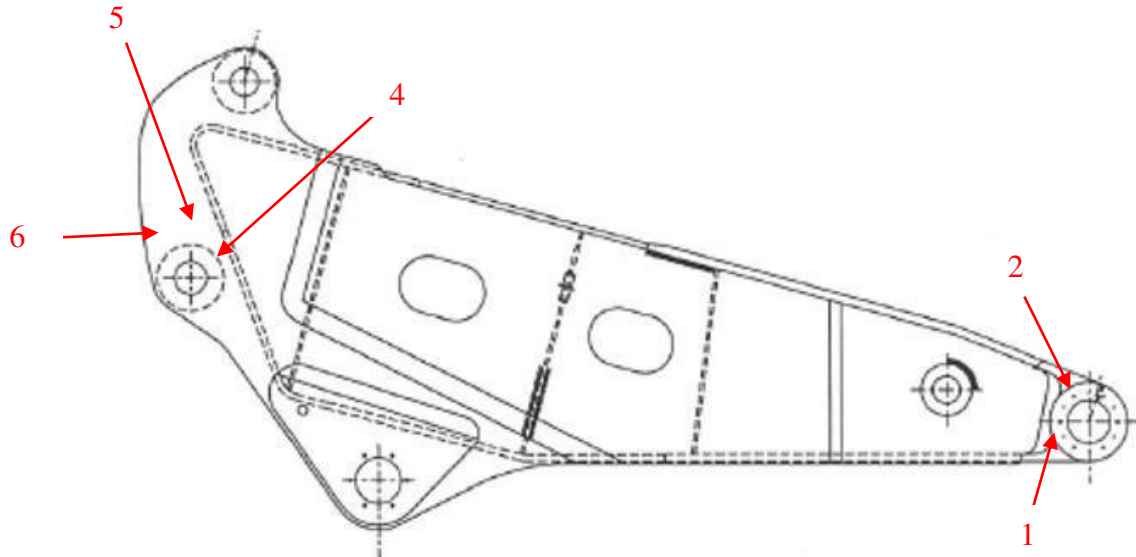


Z. Tass

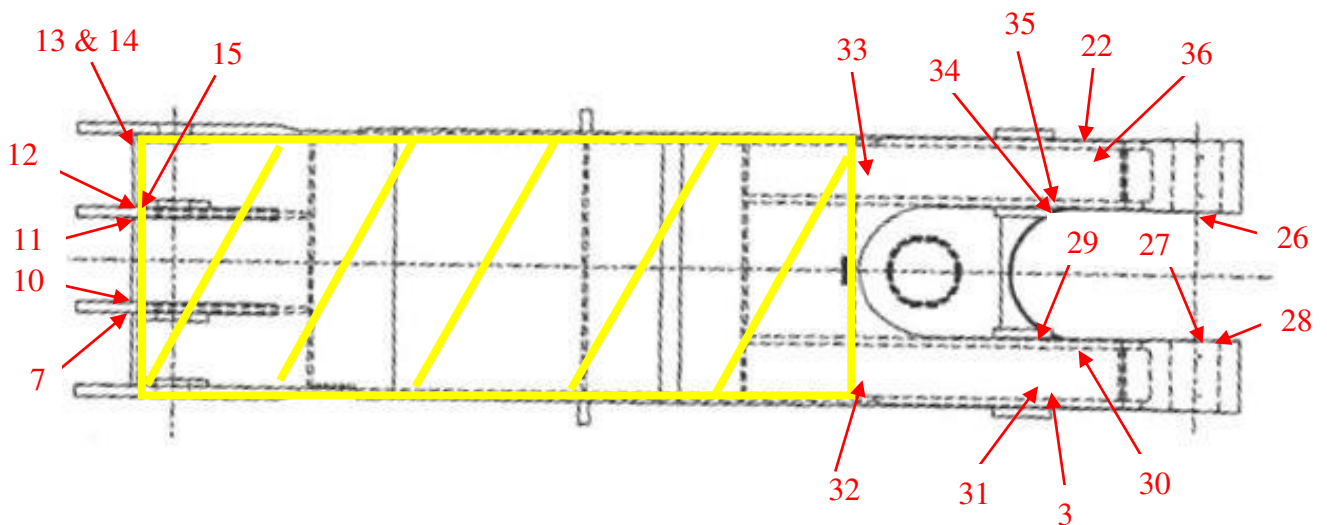
Approved Signatory

## RESULTS OF EXAMINATION CONTINUED

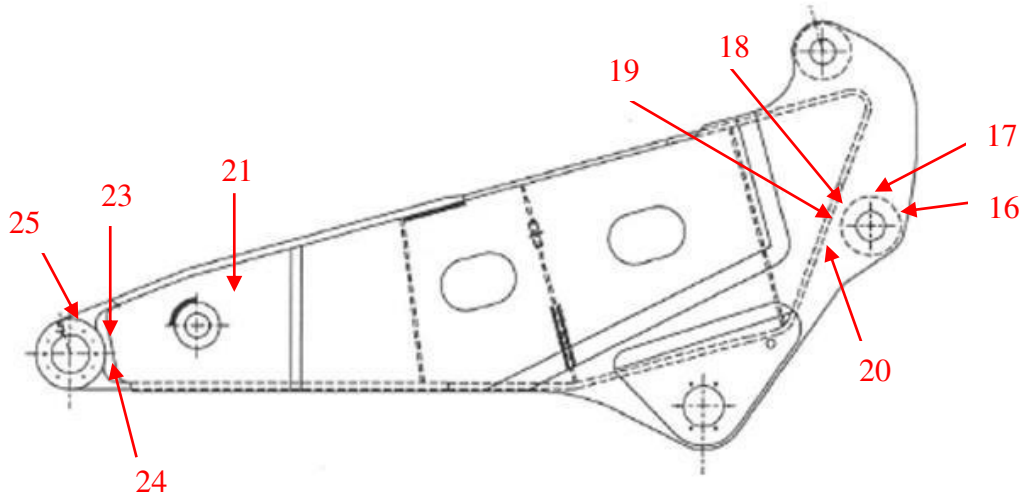
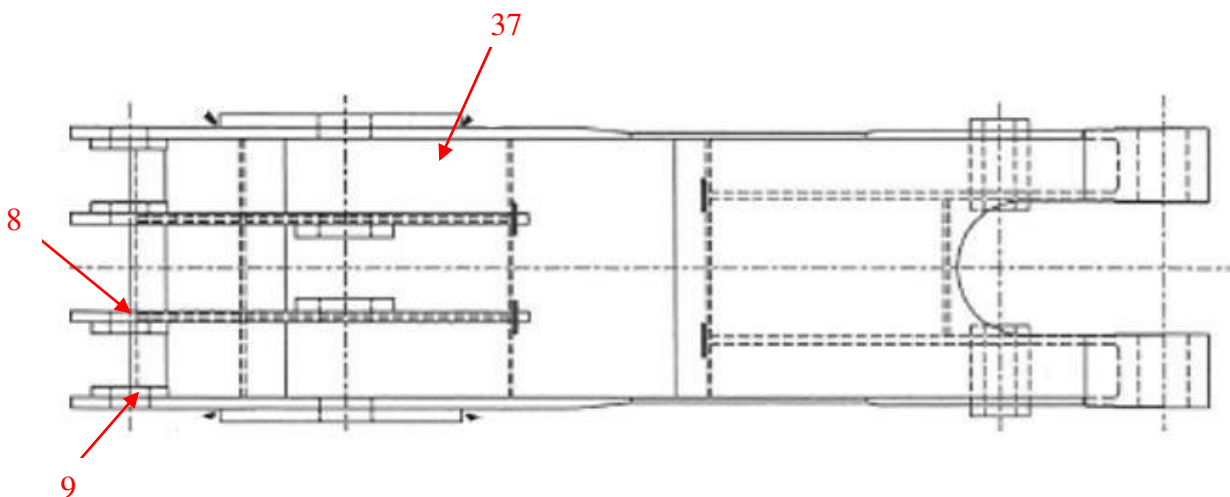
**FIGURE 1 – EXTERNAL BODY RIGHT SIDE WALL**



**FIGURE 2 – EXTERNAL BODY TOP**



Note: Highlighted Area not Inspected

**RESULTS OF EXAMINATION CONTINUED****FIGURE 3 – EXTERNAL BODY LEFT SIDE WALL****FIGURE 4 – EXTERNAL BODY UNDERSIDE**

**RESULTS OF EXAMINATION CONTINUED**

**TABLE 1.0 – EXTERNAL BODY DEFECTS:**

<b>Defect No.</b>	<b>Length in mm</b>	<b>Defect No.</b>	<b>Length in mm</b>
<b>No. 1</b>	130	<b>No. 20</b>	15
<b>No. 2</b>	270	<b>No. 21</b>	20
<b>No. 3</b>	140	<b>No. 22</b>	100
<b>No. 4</b>	15	<b>No. 23</b>	10
<b>No. 5</b>	20	<b>No. 24</b>	10
<b>No. 6</b>	20	<b>No. 25</b>	10, 50
<b>No. 7</b>	100	<b>No. 26</b>	30
<b>No. 8</b>	400	<b>No. 27</b>	50, 15
<b>No. 9</b>	400	<b>No. 28</b>	20
<b>No. 10</b>	500	<b>No. 29</b>	130
<b>No. 11</b>	350	<b>No. 30</b>	300
<b>No. 12</b>	50, 100	<b>No. 31</b>	130
<b>No. 13</b>	5, 10	<b>No. 32</b>	100
<b>No. 14</b>	80	<b>No. 33</b>	100
<b>No. 15</b>	70	<b>No. 34</b>	80
<b>No. 16</b>	120	<b>No. 35</b>	90
<b>No. 17</b>	70	<b>No. 36</b>	120
<b>No. 18</b>	150	<b>No. 37</b>	50
<b>No. 19</b>	20		

PHOTOGRAPH NO. 1 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #1



PHOTOGRAPH NO. 2 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #2



PHOTOGRAPH NO. 3 - EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #3



PHOTOGRAPH NO. 4 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #4



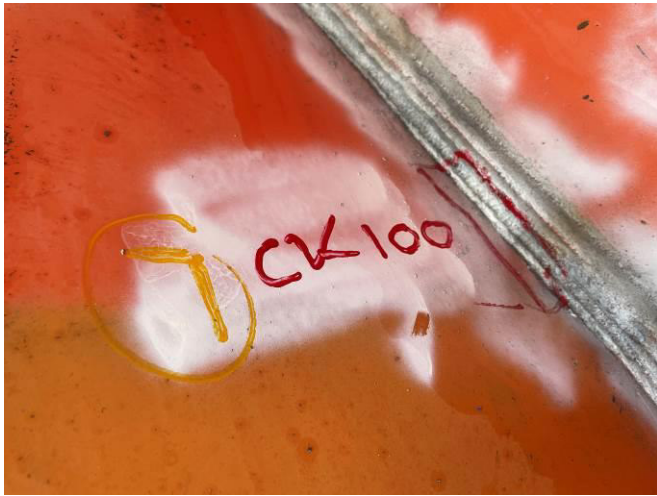
PHOTOGRAPH NO. 5 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #5



PHOTOGRAPH NO. 6 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #6



PHOTOGRAPH NO. 7 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #7



PHOTOGRAPH NO. 8 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #8



PHOTOGRAPH NO. 9 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #9



PHOTOGRAPH NO. 10 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #10



PHOTOGRAPH NO. 11 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #11



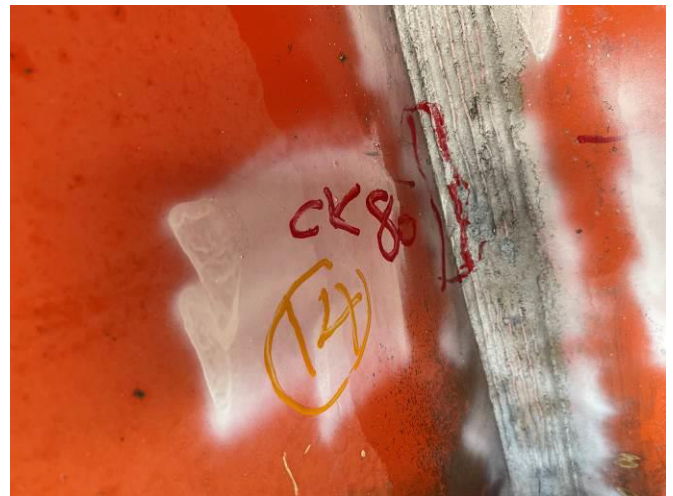
PHOTOGRAPH NO. 12 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #12



PHOTOGRAPH NO. 13 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #13



PHOTOGRAPH NO. 14 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #14



PHOTOGRAPH NO. 15 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #15



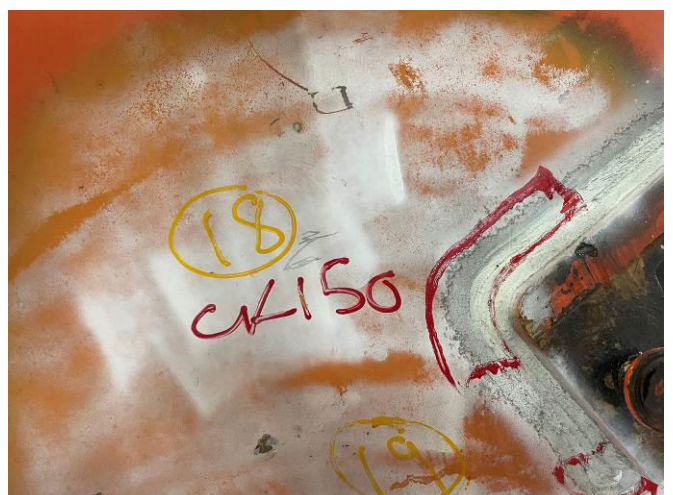
PHOTOGRAPH NO. 16 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #16



PHOTOGRAPH NO. 17 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #17



PHOTOGRAPH NO. 18 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #18





PHOTOGRAPH NO. 19 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #19



PHOTOGRAPH NO. 20 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #20



PHOTOGRAPH NO. 21 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #21



PHOTOGRAPH NO. 22 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #22



PHOTOGRAPH NO. 23 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #23



PHOTOGRAPH NO. 24 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #24



PHOTOGRAPH NO. 25 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #25



PHOTOGRAPH NO. 26 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #26



PHOTOGRAPH NO. 27 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #27



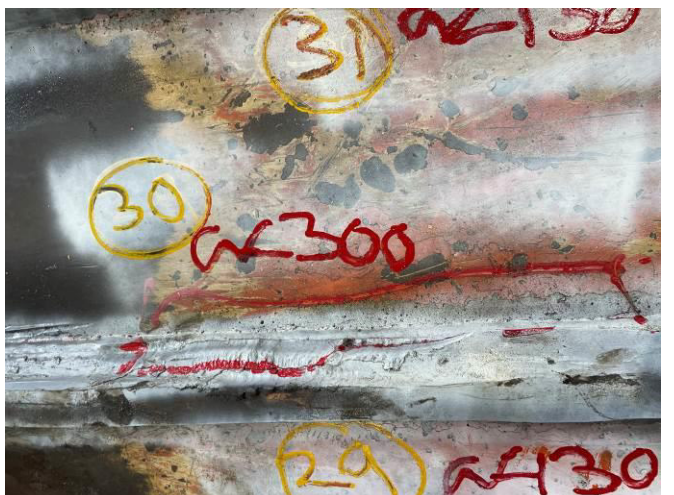
PHOTOGRAPH NO. 28 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #28



PHOTOGRAPH NO. 29 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #29



PHOTOGRAPH NO. 30 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #30



PHOTOGRAPH NO. 31 – EXTERNAL STICK  
TYPICAL VIEW OF DEFECT #31



PHOTOGRAPH NO. 32 – EXTERNAL STICK  
TYPICAL VIEW OF DEFECT #32



PHOTOGRAPH NO. 33 – EXTERNAL STICK  
TYPICAL VIEW OF DEFECT #33



PHOTOGRAPH NO. 34 – EXTERNAL STICK  
TYPICAL VIEW OF DEFECT #34



PHOTOGRAPH NO. 35 – EXTERNAL STICK  
TYPICAL VIEW OF DEFECT #35



PHOTOGRAPH NO. 36 – EXTERNAL STICK  
TYPICAL VIEW OF DEFECT #36



PHOTOGRAPH NO. 37 – EXTERNAL STICK  
TYPICAL VIEW OF DEFECT #37



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PHOTOGRAPH NO. 38 – GENERAL VIEW OF 5500 STICK



PHOTOGRAPH NO. 39 – GENERAL VIEW OF 5500 STICK



PHOTOGRAPH NO. 40 – GENERAL VIEW OF 5500 STICK



PHOTOGRAPH NO. 41 – GENERAL VIEW OF 5500 STICK



PHOTOGRAPH NO. 42 – GENERAL VIEW OF 5500 STICK



PHOTOGRAPH NO. 43 – GENERAL VIEW OF 5500 STICK





## N.D.T. TEST REPORT

JB:sk  
04APR24

**REPORT No.:** R24-0947a Page 1 of 18

**CLIENT:** CQ Field Mining Services  
40 Production Drive  
Paget, Qld 4740

**CLIENT CONTACT:** Mr. B. Sedcole

**ORDER No.:** 56901

**JOB No.:** 29044

**DRAWING No.:** Not Specified

**ITEM:** EX5500 Stick

**DESCRIPTION:** *Initial* NDT & Inspection of EX5500 Stick – Additional Testing  
at CQ Field Mining Services Workshop, Mackay.

**TECHNICIAN/S:** Mr. J. Bozier / Mr. B. Bell

**DATE OF TEST:** 27MAR24 / 28MAR24

**WORKSHEET REF. No.:** MPI 24 - 45659  
CON 24 - 3369



**INSPECTION DATA:**

PROCEDURE No.: TP-301

TEST STANDARD: AS 1171-1998

ASSOCIATED STANDARD: Not Applicable

SURFACE FINISH: As Welded

SURFACE PREPARATION: Mechanical Cleaned (Needle Gunned)

SURFACE COATINGS: Nil

SURFACE CONDITION:  < 6.3µm Ra,  < 3.2µm Ra

ACC/REJ LIMITS: Record & Report all Cracking

MATERIAL SPECIFICATION: Carbon Steel – No Further Specifications

LIMITATION: Nil

**EQUIPMENT:**

Ultrasonic     Radiographic     Penetrant  
 MPI             Other – Visual

Parker B300S Contour Probe AMP-047  
Castrol Flux Indicator Strip  
Headlamp

MAGNETISATION: Continuous Method

DEMAGNETISATION: No

REF. SENSITIVITY: MPI – 3 Lines Castrol Flux Indicator

CONSUMABLES: Ardrox, Black Magnetic Ink 800/3, Batch # 4980857866  
Ardrox, White Contrast Paint 8901/W, Batch # 4980129572

TEMPERATURE:  10° - 14°     15° - 45°     46° - 50°

RECORD: Photograph

LIGHTING: 1200 Lux

**RESULTS OF EXAMINATION**

**INSPECTION OF EX5500 STICK:**

**Initial Magnetic Particle Inspection:**

**Worksheet No. 24 - 45659**

<b>Identification</b>	<b>Result</b>
External Top Side Job No. 29044 <i>100% Inspection of Prepared Welds</i>	➤ <b>Cracking Evident</b> - Refer to Figures 1 & Table 1.0 for Results
Internal Bay 'A' Job No. 29044 <i>100% Inspection of Prepared Welds</i>	➤ Nil Cracking Evident - Refer to Figure 2
Internal Bay 'B' Job No. 29044 <i>100% Inspection of Prepared Welds</i>	➤ <b>Cracking Evident</b> - Refer to Figures 3 & Table 2.0 for Results
Internal Bay 'C' Job No. 29044 <i>100% Inspection of Prepared Welds</i>	➤ <b>Cracking Evident</b> - Refer to Figures 4 & Table 3.0 for Results

**Note 1: Lighting Conditions comply with the Requirements of AS 1171 Section 3.5.2 – 1998**

**Technicians:**

**Joshua Bozier**

**Brodie Bell**



**J. Bozier - Technician**

Approved NDT Signatory

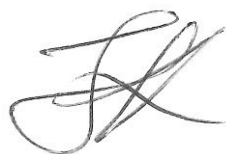
AS 3998 / ISO 9712 Level 2

MT, UT

(AINDT Registration No.6277)

**SUMMARY OF EXAMINATION****INSPECTION OF EX5500 STICK:****Magnetic Particle Inspection:****Worksheet No. 24 - 45659**

<b>Identification</b>	<b>Total No. of Defects</b>	<b>Total Length of Defects</b>	<b>Interpretation</b>
External Top Side	5	660mm	New Cracking Evident
Internal Bay 'A'	-	-	Nil Cracking Evident
Internal Bay 'B'	5	540mm	New Cracking Evident
Internal Bay 'C'	34	14040mm	New Cracking Evident

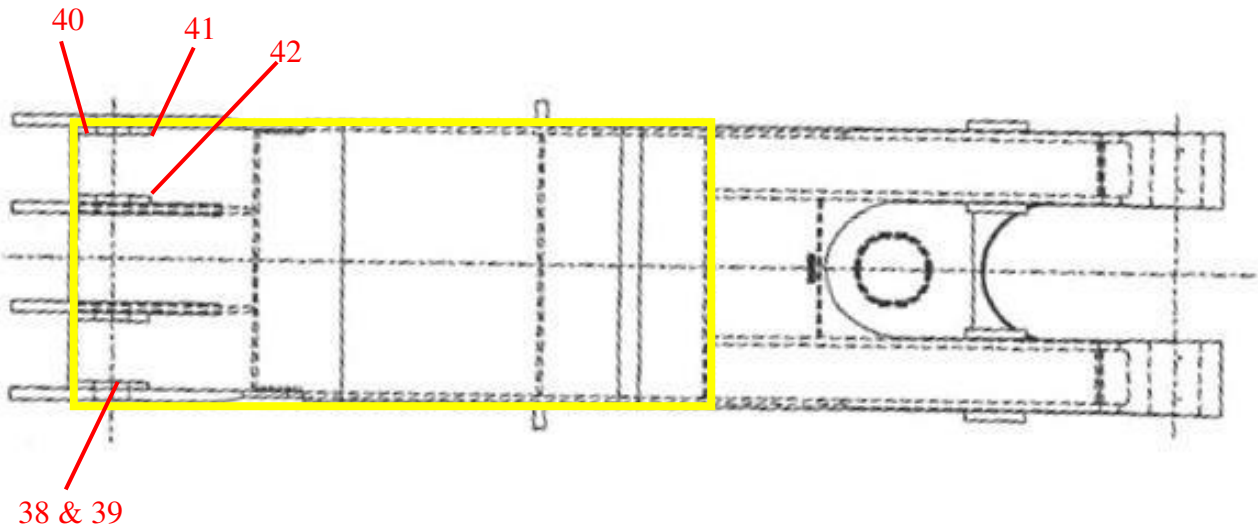
*Note 1: Lighting Conditions comply with the Requirements of AS 1171 Section 3.5.2 1998***Technicians:****Joshua Bozier****Brodie Bell****J. Bozier - Technician**

Approved NDT Signatory

AS 3998 / ISO 9712 Level 2

MT, UT

(AINDT Registration No.6277)

**RESULTS OF EXAMINATION CONTINUED****FIGURE 1 – EXTERNAL TOP SIDE**

Note: Highlighted Area Inspected

**TABLE 1.0 – EXTERNAL TOP SIDE DEFECTS:**

Defect No.	Length in mm	Defect No.	Length in mm
No. 38	150	No. 41	300
No. 39	70	No. 42	120
No. 40	20		

PHOTOGRAPH NO. 1 – EXTERNAL TOP SIDE  
TYPICAL VIEW OF DEFECT #38



PHOTOGRAPH NO. 2 – EXTERNAL TOP SIDE  
TYPICAL VIEW OF DEFECT #39



PHOTOGRAPH NO. 3 - EXTERNAL TOP SIDE  
TYPICAL VIEW OF DEFECT #40



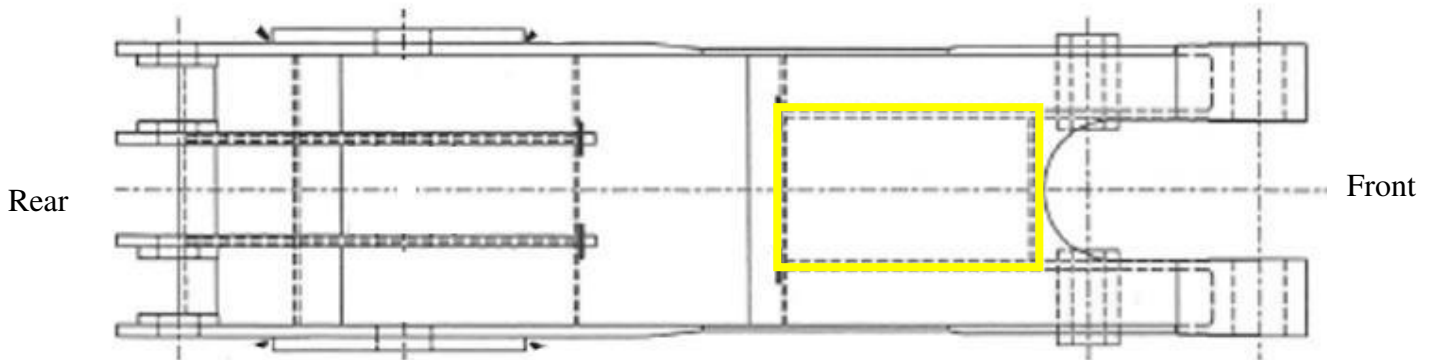
PHOTOGRAPH NO. 4 – EXTERNAL TOP SIDE  
TYPICAL VIEW OF DEFECT #41



PHOTOGRAPH NO. 5 – EXTERNAL BODY  
TYPICAL VIEW OF DEFECT #42



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**RESULTS OF EXAMINATION CONTINUED****FIGURE 2 – INTERNAL BAY ‘A’**

Note: Highlighted Area Inspected

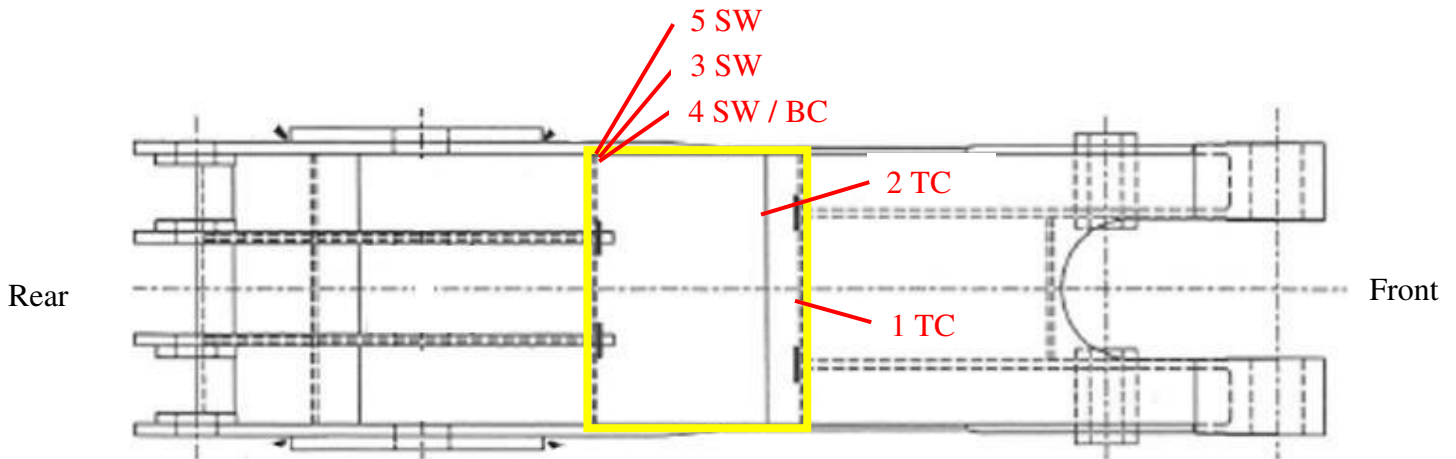
PHOTOGRAPH NO. 6 – GENERAL VIEW OF INTERNAL BAY ‘A’



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## RESULTS OF EXAMINATION CONTINUED

**FIGURE 3 – INTERNAL BAY ‘B’**



Note: Highlighted Area Inspected

TC = Top Coad  
 BC = Bottom Cord  
 SW = Side Wall

**TABLE 2.0 – INTERNAL BAY ‘B’ DEFECTS:**

Defect No.	Length in mm	Defect No.	Length in mm
No. 1	30	No. 4	200
No. 2	50	No. 5	80
No. 3	180		

PHOTOGRAPH NO. 7 – INTERNAL BAY ‘B’  
TYPICAL VIEW OF DEFECT #1



PHOTOGRAPH NO. 8 – INTERNAL BAY ‘B’  
TYPICAL VIEW OF DEFECT #2



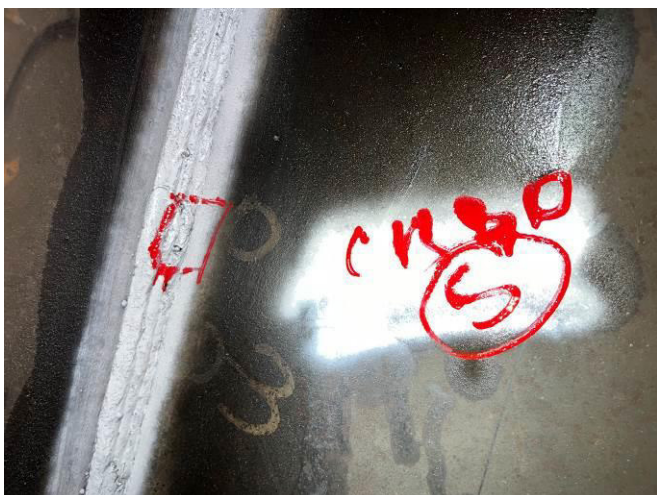
PHOTOGRAPH NO. 9 - INTERNAL BAY ‘B’  
TYPICAL VIEW OF DEFECT #3



PHOTOGRAPH NO. 10 – INTERNAL BAY ‘B’  
TYPICAL VIEW OF DEFECT #4



PHOTOGRAPH NO. 11 – INTERNAL BAY ‘B’  
TYPICAL VIEW OF DEFECT #5

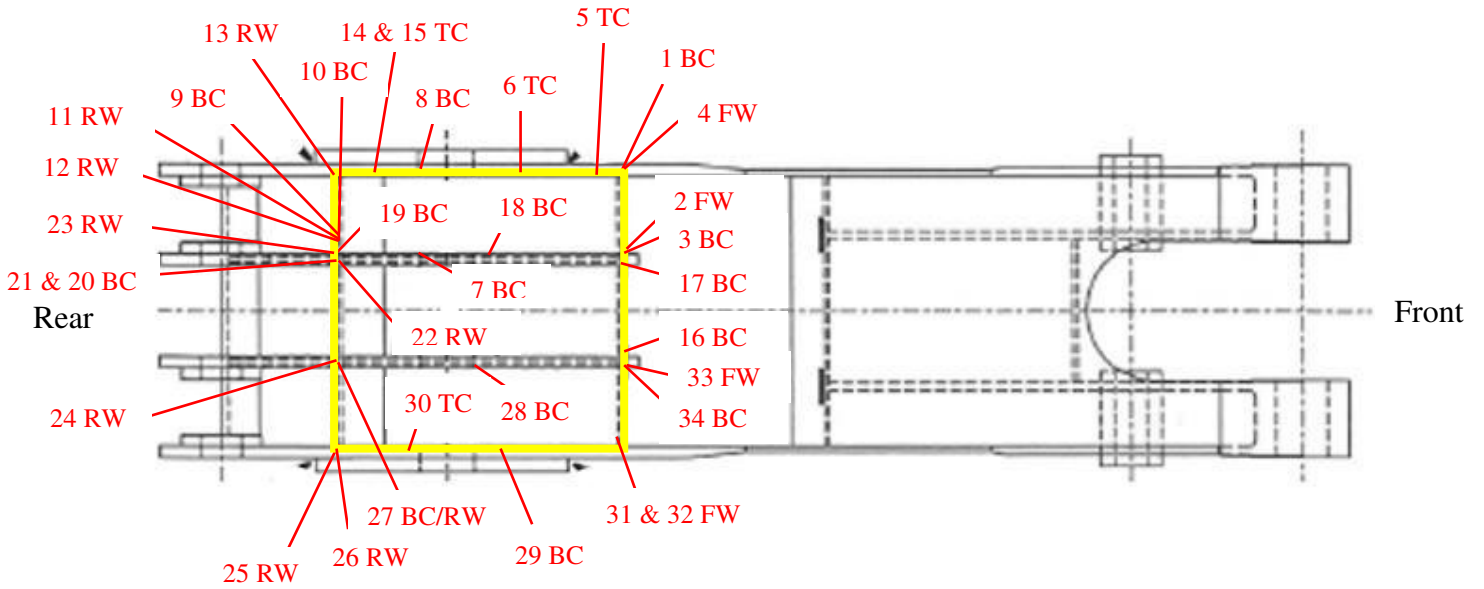


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## RESULTS OF EXAMINATION CONTINUED

**FIGURE 4 – INTERNAL BAY ‘C’**



Note: Highlighted Area Inspected

- TC = Top Coad
- BC = Bottom Cord
- SW = Side Wall
- FW = Front Wall
- RW = Rear Wall

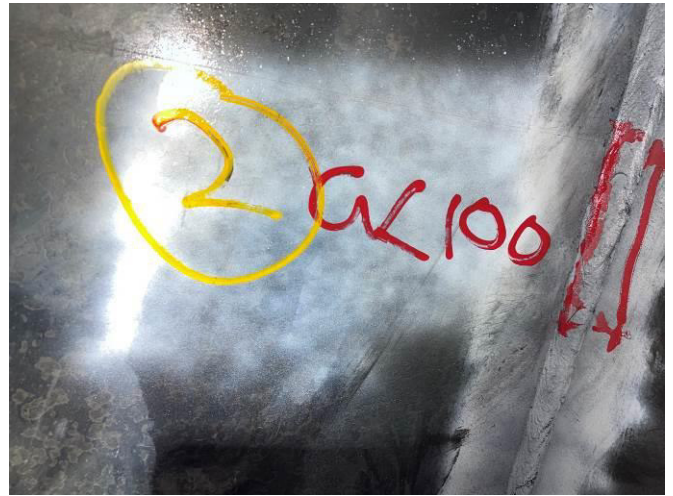
**RESULTS OF EXAMINATION CONTINUED****TABLE 3.0 – INTERNAL BAY ‘C’ DEFECTS:**

<b>Defect No.</b>	<b>Length in mm</b>	<b>Defect No.</b>	<b>Length in mm</b>
<b>No. 1</b>	50	<b>No. 18</b>	2100
<b>No. 2</b>	100	<b>No. 19</b>	40
<b>No. 3</b>	80	<b>No. 20</b>	40
<b>No. 4</b>	100	<b>No. 21</b>	300
<b>No. 5</b>	190	<b>No. 22</b>	200
<b>No. 6</b>	400	<b>No. 23</b>	160
<b>No. 7</b>	1200	<b>No. 24</b>	1100
<b>No. 8</b>	1200	<b>No. 25</b>	500
<b>No. 9</b>	30	<b>No. 26</b>	350
<b>No. 10</b>	130	<b>No. 27</b>	190
<b>No. 11</b>	600	<b>No. 28</b>	1500
<b>No. 12</b>	480	<b>No. 29</b>	300
<b>No. 13</b>	850	<b>No. 30</b>	10, 10
<b>No. 14</b>	100, 120	<b>No. 31</b>	140
<b>No. 15</b>	300	<b>No. 32</b>	120
<b>No. 16</b>	20	<b>No. 33</b>	800
<b>No. 17</b>	150	<b>No. 34</b>	80

PHOTOGRAPH NO. 12 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #1



PHOTOGRAPH NO. 13 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #2



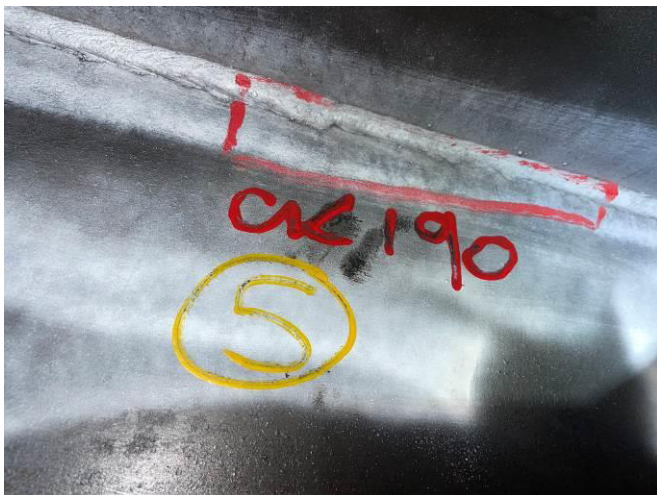
PHOTOGRAPH NO. 14 - INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #3



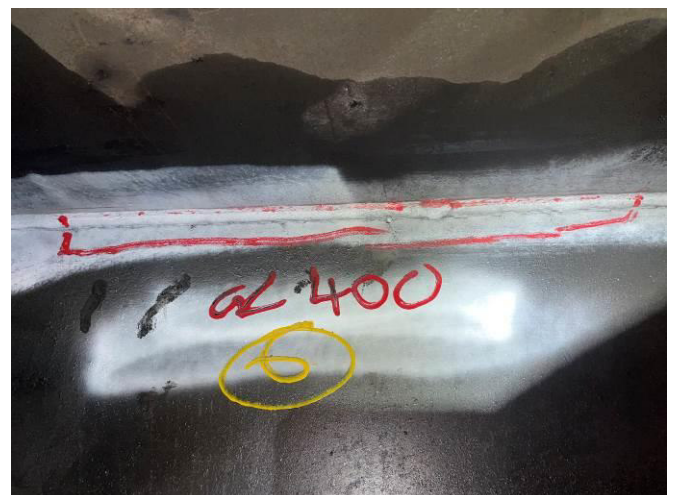
PHOTOGRAPH NO. 15 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #4



PHOTOGRAPH NO. 16 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #5



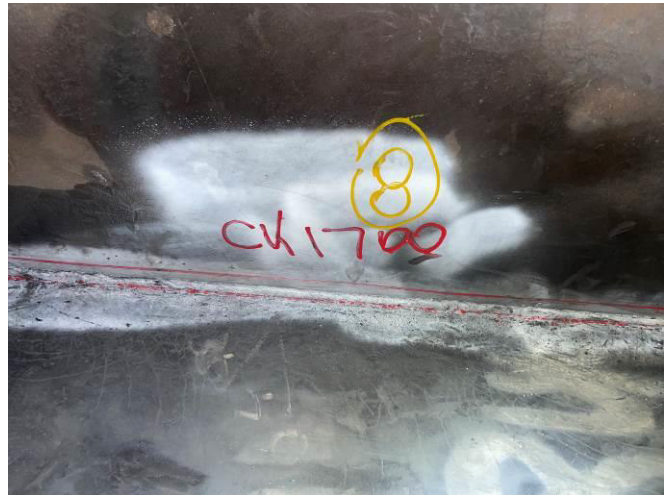
PHOTOGRAPH NO. 17 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #6



PHOTOGRAPH NO. 18 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #7



PHOTOGRAPH NO. 19 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #8



PHOTOGRAPH NO. 20 - INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #9



PHOTOGRAPH NO. 21 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #10



PHOTOGRAPH NO. 22 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #11



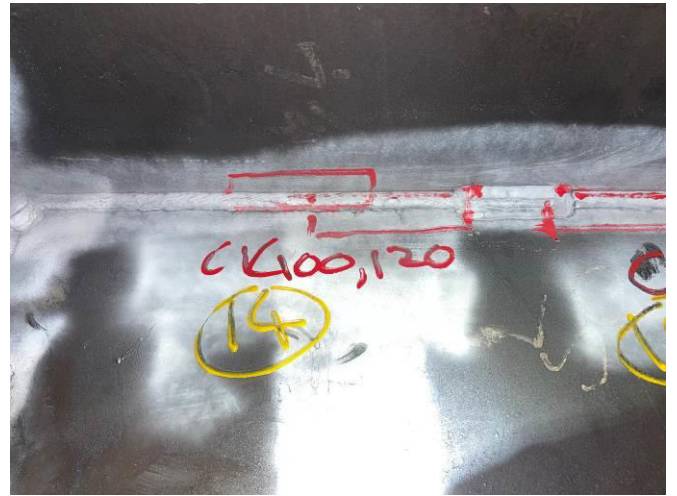
PHOTOGRAPH NO. 23 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #12



PHOTOGRAPH NO. 24 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #13



PHOTOGRAPH NO. 25 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #14



PHOTOGRAPH NO. 26 - INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #15



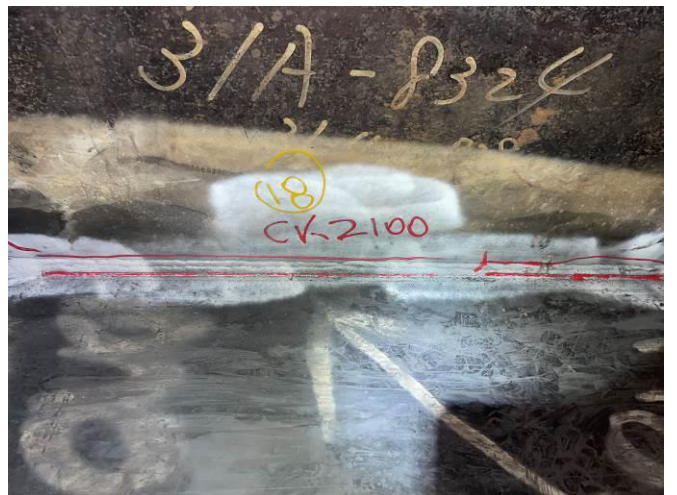
PHOTOGRAPH NO. 27 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #16



PHOTOGRAPH NO. 28 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #17



PHOTOGRAPH NO. 29 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #18



PHOTOGRAPH NO. 30 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #19



PHOTOGRAPH NO. 31 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #20



PHOTOGRAPH NO. 32 - INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #21



PHOTOGRAPH NO. 33 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #22



PHOTOGRAPH NO. 34 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #23



PHOTOGRAPH NO. 35 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #24



PHOTOGRAPH NO. 36 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #25



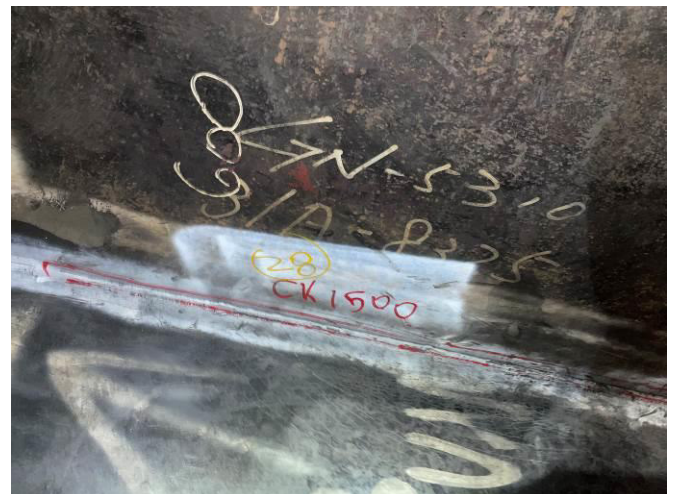
PHOTOGRAPH NO. 37 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #26



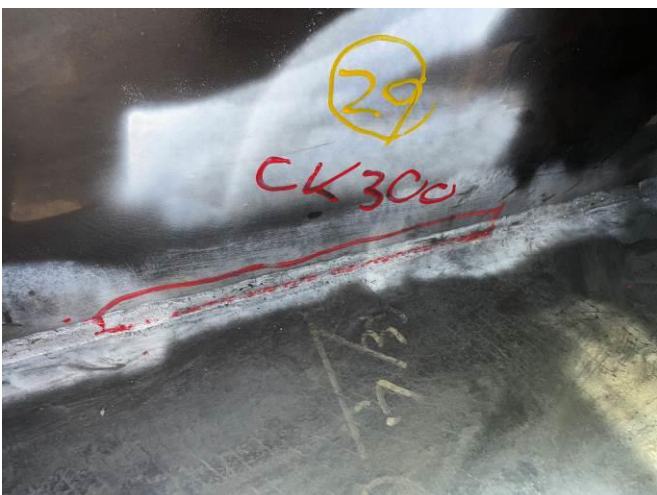
PHOTOGRAPH NO. 38 - INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #27



PHOTOGRAPH NO. 39 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #28



PHOTOGRAPH NO. 40 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #29



PHOTOGRAPH NO. 41 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #30



PHOTOGRAPH NO. 42 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #31



PHOTOGRAPH NO. 43 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #32



PHOTOGRAPH NO. 44 - INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #33



PHOTOGRAPH NO. 45 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF DEFECT #34





PHOTOGRAPH NO. 46 – GENERAL VIEW OF EX5500 STICK





## N.D.T. TEST REPORT

JB:sk  
01MAY24

**REPORT No.:**

R24-0947b

Page 1 of 28

**CLIENT:**

CQ Field Mining Services  
40 Production Drive  
Paget, Qld 4740

**CLIENT CONTACT:**

Mr. B. Sedcole

**ORDER No.:**

56902

**JOB No.:**

29044

**DRAWING No.:**

Not Specified

**ITEM:**

EX5500 Stick

**DESCRIPTION:**

*Final* NDT & Inspection of EX5500 Stick  
at CQ Field Mining Services Workshop, Mackay.

**TECHNICIAN/S:**

Mr. J. Bozier / Mr. J. Friese / Mr. B. Bell

**DATE OF TEST:**

15APR24 / 16APR24 / 18APR24 / 24APR24

**WORKSHEET REF. No.:**

MPI 24 – 45789  
VIS 24 – 9385  
UT 24 – 10466

**INSPECTION DATA:**

PROCEDURE No.: TP-001 / TP-301 / TP-702

TEST STANDARD: AS 3978-2003 / AS 1171-1998 / AS 2207-2007

ASSOCIATED STANDARD: AS/NZS 1554.1-2014

SURFACE FINISH: As Welded

SURFACE PREPARATION: Blended

SURFACE COATINGS: Nil

SURFACE CONDITION:  < 6.3µm Ra,  < 3.2µm Ra

ACC/REJ LIMITS: AS/NZS 1554.1 2014 Cat SP Table 6.2.2  
AS/NZS 1554.1 2014 Table 6.2.1

MATERIAL SPECIFICATION: Carbon Steel – No Further Specification

TEST LIMITATIONS: 0°, 45°, 60° & 70° Scans

**EQUIPMENT:**

Ultrasonic     Radiographic     Penetrant  
 MPI             Visual - Other

Parker B300S Contour Probe AMP-047  
Castrol Flux Indicator Strip  
USM 36 Flaw Detector AUT-041  
Krautkramer-MSEB-4E 0° Ultrasonic Transducer AUT-139  
SIUI AFP2-89-45L 45° Ultrasonic Transducer AUT-171  
SIUI AFP2-89-60L 60° Ultrasonic Transducer AUT-172  
SIUI AFP2-89-70L 70° Ultrasonic Transducer AUT-173  
SIUI AFP4-89-45L 45° Ultrasonic Transducer AUT-174  
SIUI AFP4-89-60L 60° Ultrasonic Transducer AUT-175  
SIUI AFP4-89-70L 70° Ultrasonic Transducer AUT-176  
Calibration Block No.1 IIW V1 AUT-020  
Calibration Block No.2 IOW AUT-021  
Metric Universal Calibration Block AUT-029  
Headlamp

MAGNETISATION: Continuous Method

DEMAGNETISATION: No

REF. SENSITIVITY: MPI – 3 Lines Castrol Flux Indicator

CONSUMABLES: Ardrex, Black Magnetic Ink 800/3, Batch #4980857866  
Ardrex, White Contrast Paint 8901W, Batch #4980129572

**INSPECTION DATA CONTINUED:**

LIGHTING: 1200 Lux

TEMPERATURE:  10° - 14°     15° - 45°     46° - 50°

RECORD: Photograph

% COMPLETION: 100%

ACCESS: 100%

MAGNIFICATION: Nil

**ULTRASONIC INSPECTION DATA:**

THICKNESS RANGE: 0 – 28mm

RANGE: 0° Scan: 0 – 60mm  
45°, 60° & 70° Scan: 0 - 250mm

REF. SENSITIVITY: UT – 2<sup>nd</sup> BWEFSH / 80% Reference

EVALUATION SENSITIVITY: Level 2

SCAN POSITION: UMB

SURFACE CONDITION: SP1

WELD PROCESS: Not Applicable

SIZING: 6dB / 20dB

TEST ACCURACY: ± .5mm

COUPLANT: Kerosene

CURVATURE COMPENSATION: Not Applicable

**RESULTS OF EXAMINATION**

**INSPECTION OF EX5500 STICK:**

**Final Magnetic Particle Inspection:**

**Worksheet No. 24 - 45789**

<b>Identification</b>	<b>Result</b>
External Stick Job No. 29044 <i>100% Inspection of Weld Repairs</i> <i>100% Inspection of (3x) New Man Hole Covers</i> <i>100% Inspection of New Bash Plate Welds</i> <i>100% Inspection of Bash Plate Mount Welds</i>	<ul style="list-style-type: none"> <li>➤ Nil Cracking / Defects Evident - Refer to Figures 1 to 4 &amp; Table 1.0</li> <li>➤ Complies with the Requirements of AS/NZS 1554.1 2014 Cat SP Table 6.2.2</li> </ul>
Internal Bay 'B' Job No. 29044 <i>100% Inspection of Weld Repairs</i>	<ul style="list-style-type: none"> <li>➤ Nil Cracking / Defects Evident - Refer to Figures 5 &amp; Table 2.0</li> <li>➤ Complies with the Requirements of AS/NZS 1554.1 2014 Cat SP Table 6.2.2</li> </ul>
Internal Bay 'C' Job No. 29044 <i>100% Inspection of Weld Repairs</i>	<ul style="list-style-type: none"> <li>➤ Nil Cracking / Defects Evident - Refer to Figures 6 &amp; Table 3.0</li> <li>➤ Complies with the Requirements of AS/NZS 1554.1 2014 Cat SP Table 6.2.2</li> </ul>
External Stick Job No. 29044 <i>100% Inspection of (3x) New Man Hole Covers</i> <i>100% Inspection of New Bash Plate Welds</i> <i>100% Inspection of Bash Plate Mount Welds</i>	<ul style="list-style-type: none"> <li>➤ Nil Cracking / Defects Evident</li> <li>➤ Complies with the Requirements of AS/NZS 1554.1 2014 Cat SP Table 6.2.2</li> </ul>

**Note 1: Lighting Conditions comply with the Requirements of AS 1171 Section 3.5.2 - 1998**

### RESULTS OF EXAMINATION CONTINUED

#### INSPECTION OF EX5500 STICK:

**Visual Inspection:**
**Worksheet No. 24 – 9385**

Identification	Result
External Stick Job No. 29044 <i>100% Inspection of Weld Repairs</i> <i>100% Inspection of (3x) New Man Hole Covers</i>	<ul style="list-style-type: none"> <li>➤ Nil Defects Evident - Refer to Figures 1 to 4 &amp; Table 1.0</li> <li>➤ Complies with the Requirements of AS/NZS 1554.1 2014 Cat SP Table 6.2.2</li> </ul>
Internal Bay ‘B’ Job No. 29044 <i>100% Inspection of Weld Repairs</i>	<ul style="list-style-type: none"> <li>➤ Nil Defects Evident - Refer to Figures 5 Table 2.0</li> <li>➤ Complies with the Requirements of AS/NZS 1554.1 2014 Cat SP Table 6.2.2</li> </ul>
Internal Bay ‘C’ Job No. 29044 <i>100% Inspection of Weld Repairs</i>	<ul style="list-style-type: none"> <li>➤ Nil Defects Evident - Refer to Figures 6 &amp; Table 3.0</li> <li>➤ Complies with the Requirements of AS/NZS 1554.1 2014 Cat SP Table 6.2.2</li> </ul>
External Stick Job No. 29044 <i>100% Inspection of (3x) New Man Hole Covers</i>	<ul style="list-style-type: none"> <li>➤ Nil Defects Evident</li> <li>➤ Complies with the Requirements of AS/NZS 1554.1 2014 Cat SP Table 6.2.2</li> </ul>

**Note 1: Lighting Conditions comply with the Requirements of AS 3978 Section 6.1 – 2003**

**Ultrasonic Inspection:**
**Worksheet No. 24 -10466**

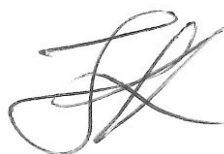
Identification	Result
External Stick Job No. 29044 <i>20% Inspection of (3x) New Man Hole Covers</i>	<ul style="list-style-type: none"> <li>➤ Nil Recordable Discontinuities Evident</li> <li>➤ Complies with the Requirements of AS/NZS 1554.1 2014 Table 6.2.1</li> </ul>

**Note: Lighting Conditions comply with the Requirements of AS 3978 Section 6.1 2003**

**SUMMARY OF EXAMINATION****INSPECTION OF EX5500 STICK:****Magnetic Particle Inspection:****Worksheet No. 24 – 45789 / 9385**

<b>Identification</b>	<b>Total No. of Repairs</b>	<b>Interpretation</b>
External Stick	42	Defects Repaired Since Last Inspection
Internal Bay 'B'	5	Defects Repaired Since Last Inspection
Internal Bay 'C'	34	Defects Repaired Since Last Inspection

**Note 1: Lighting Conditions comply with the Requirements of AS 1171 Section 3.5.2 1998 & AS 3978 Section 6.1 2003**

**Technicians:****Joshua Bozier****Jayden Friese****Brodie Bell****J. Bozier - Technician**

Approved NDT Signatory

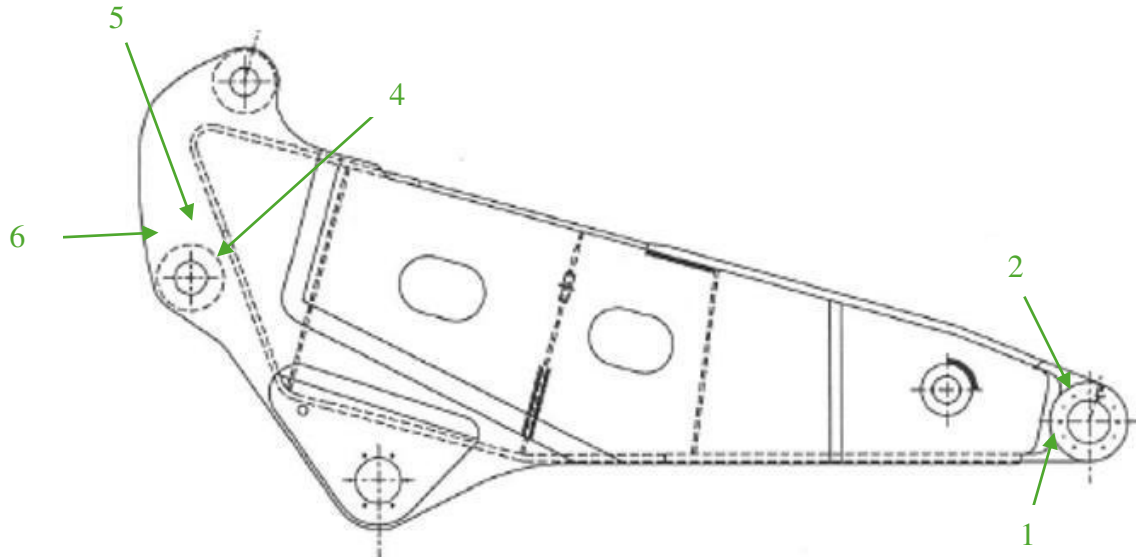
AS 3998 / ISO 9712 Level 2

MT, UT

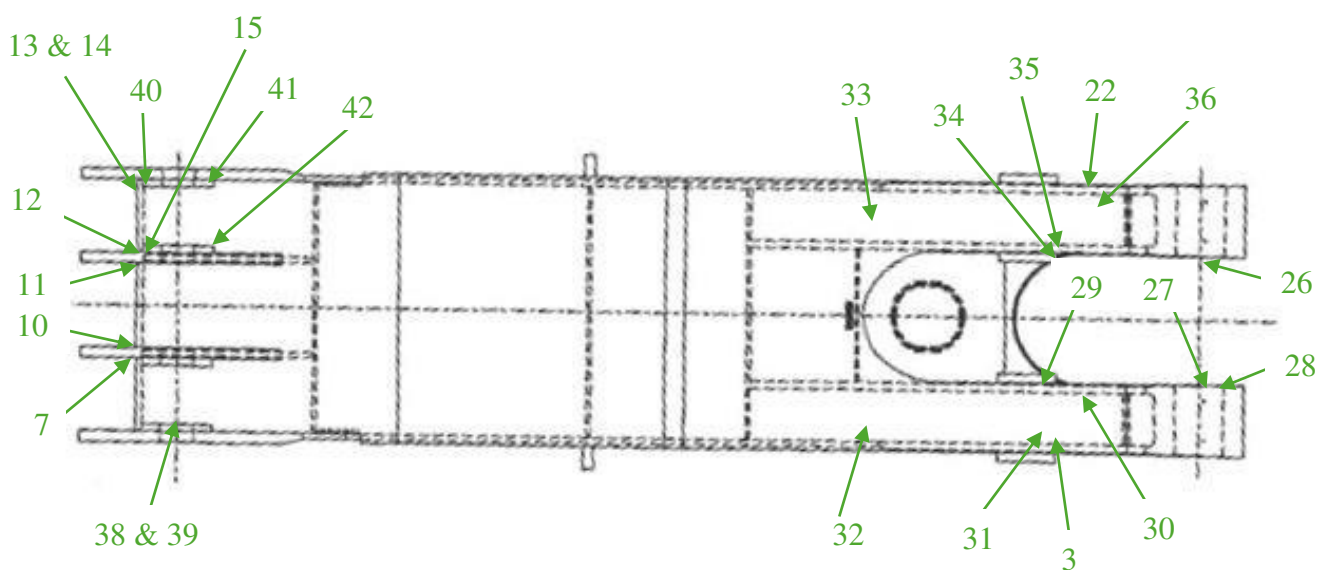
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## RESULTS OF EXAMINATION CONTINUED

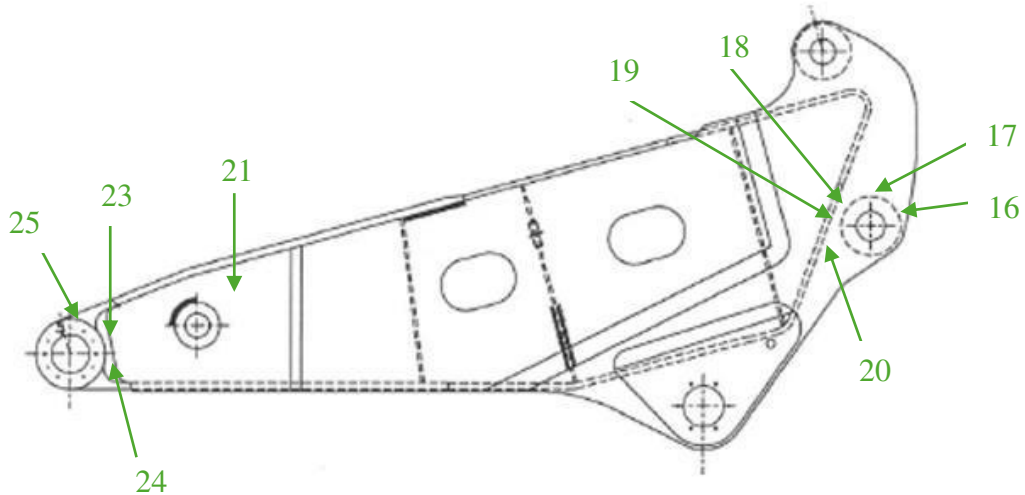
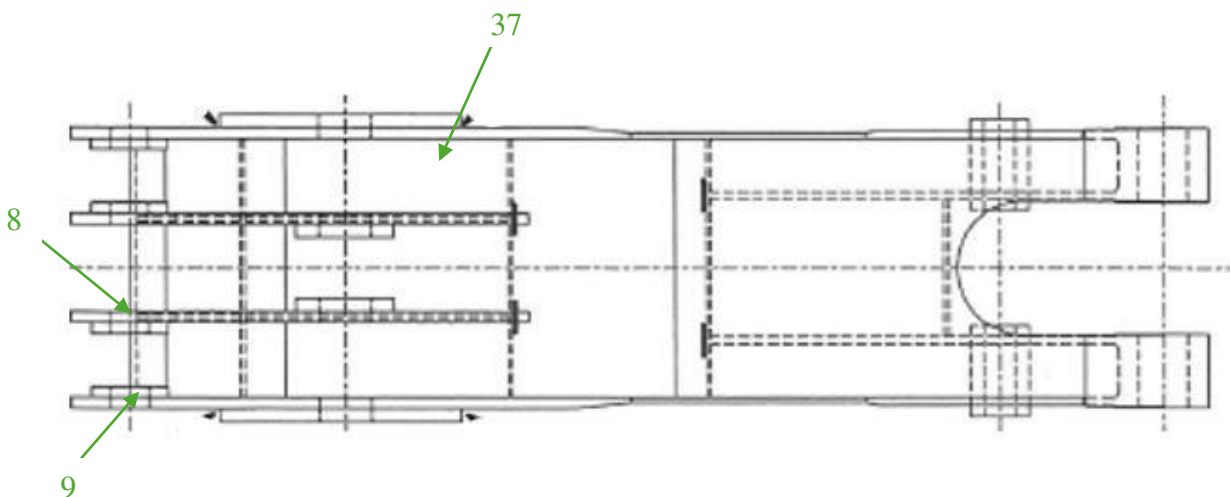
**FIGURE 1 – EXTERNAL STICK RIGHT SIDE WALL**



**FIGURE 2 – EXTERNAL STICK TOP**





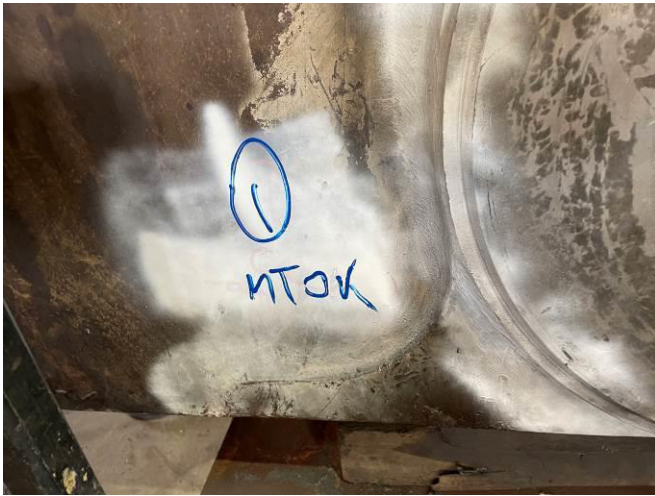
**RESULTS OF EXAMINATION CONTINUED****FIGURE 3 – EXTERNAL STICK LEFT SIDE WALL****FIGURE 4 – EXTERNAL STICK UNDERSIDE**

**RESULTS OF EXAMINATION CONTINUED**

**TABLE 1.0 – EXTERNAL STICK REPAIRED DEFECTS:**

<b>Defect No.</b>	<b>Length in mm</b>	<b>Defect No.</b>	<b>Length in mm</b>
<b>No. 1</b>	130	<b>No. 22</b>	100
<b>No. 2</b>	270	<b>No. 23</b>	10
<b>No. 3</b>	140	<b>No. 24</b>	10
<b>No. 4</b>	15	<b>No. 25</b>	10, 50
<b>No. 5</b>	20	<b>No. 26</b>	30
<b>No. 6</b>	20	<b>No. 27</b>	50, 15
<b>No. 7</b>	100	<b>No. 28</b>	20
<b>No. 8</b>	400	<b>No. 29</b>	130
<b>No. 9</b>	400	<b>No. 30</b>	300
<b>No. 10</b>	500	<b>No. 31</b>	130
<b>No. 11</b>	350	<b>No. 32</b>	100
<b>No. 12</b>	50, 100	<b>No. 33</b>	100
<b>No. 13</b>	5, 10	<b>No. 34</b>	80
<b>No. 14</b>	80	<b>No. 35</b>	90
<b>No. 15</b>	70	<b>No. 36</b>	120
<b>No. 16</b>	120	<b>No. 37</b>	50
<b>No. 17</b>	70	<b>No. 38</b>	150
<b>No. 18</b>	150	<b>No. 39</b>	70
<b>No. 19</b>	20	<b>No. 40</b>	20
<b>No. 20</b>	15	<b>No. 41</b>	300
<b>No. 21</b>	20	<b>No. 42</b>	120

PHOTOGRAPH NO. 1 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #1



PHOTOGRAPH NO. 2 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #2



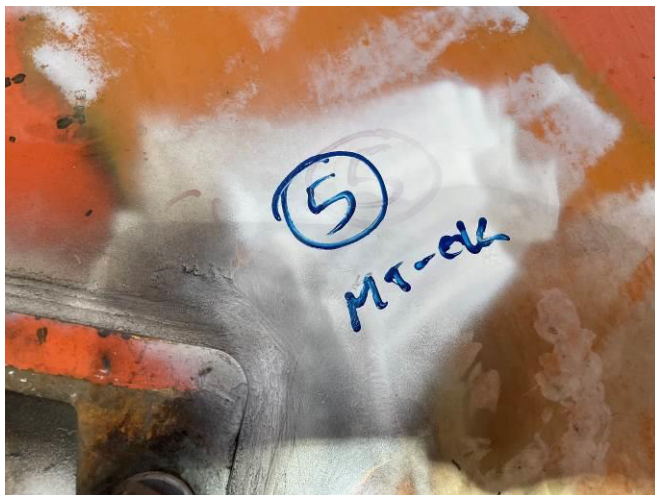
PHOTOGRAPH NO. 3 - EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #3



PHOTOGRAPH NO. 4 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #4



PHOTOGRAPH NO. 5 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #5



PHOTOGRAPH NO. 6 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #6



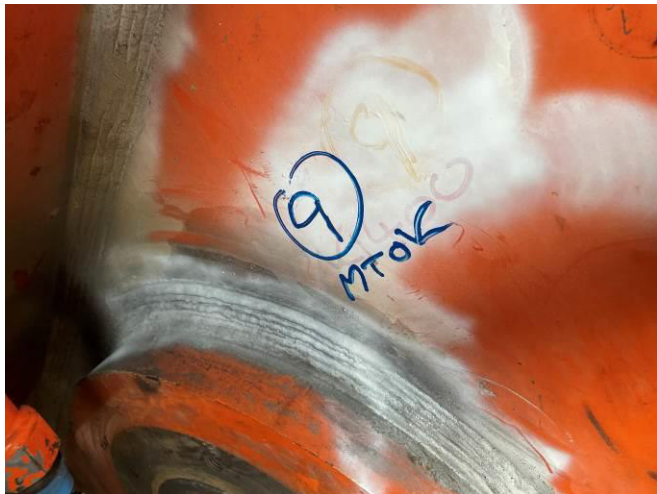
PHOTOGRAPH NO. 7 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #7



PHOTOGRAPH NO. 8 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #8



PHOTOGRAPH NO. 9 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #9



PHOTOGRAPH NO. 10 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #10



PHOTOGRAPH NO. 11 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #11



PHOTOGRAPH NO. 12 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #12



PHOTOGRAPH NO. 13 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #13



PHOTOGRAPH NO. 14 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #14



PHOTOGRAPH NO. 15 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #15



PHOTOGRAPH NO. 16 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #16



PHOTOGRAPH NO. 17 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #17



PHOTOGRAPH NO. 18 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #18



PHOTOGRAPH NO. 19 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #19



PHOTOGRAPH NO. 20 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #20



PHOTOGRAPH NO. 21 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #21



PHOTOGRAPH NO. 22 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #22



PHOTOGRAPH NO. 23 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #23



PHOTOGRAPH NO. 24 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #24



PHOTOGRAPH NO. 25 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #25



PHOTOGRAPH NO. 26 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #26



PHOTOGRAPH NO. 27 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #27



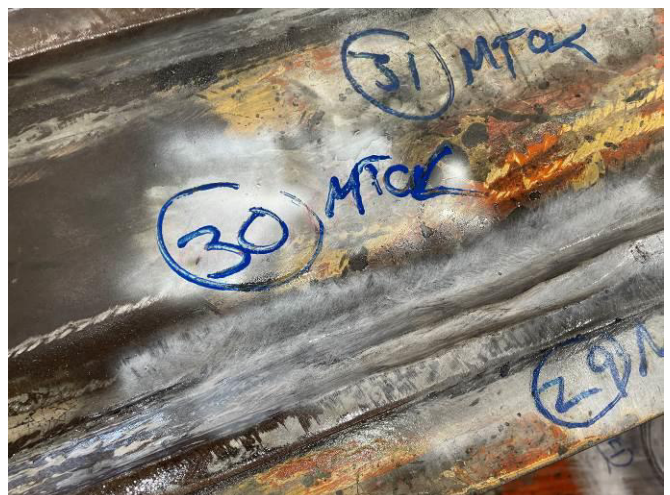
PHOTOGRAPH NO. 28 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #28



PHOTOGRAPH NO. 29 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #29



PHOTOGRAPH NO. 30 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #30



PHOTOGRAPH NO. 31 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #31



PHOTOGRAPH NO. 32 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #32



PHOTOGRAPH NO. 33 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #33



PHOTOGRAPH NO. 34 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #34



PHOTOGRAPH NO. 35 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #35



PHOTOGRAPH NO. 36 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #36

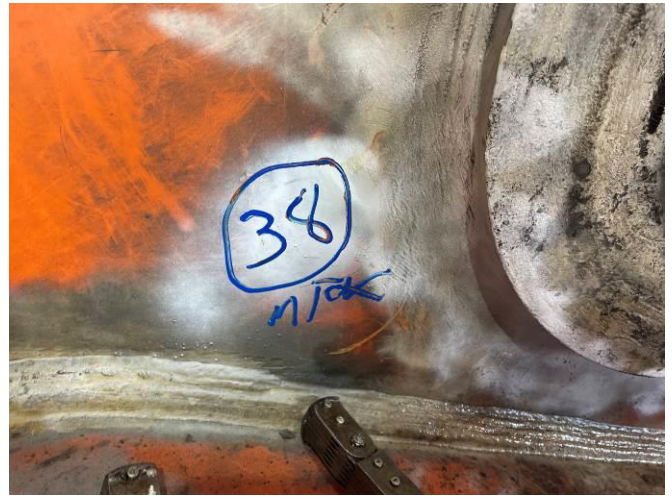




PHOTOGRAPH NO. 37 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #37



PHOTOGRAPH NO. 38 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #38



PHOTOGRAPH NO. 39 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #39



PHOTOGRAPH NO. 40 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #40



PHOTOGRAPH NO. 41 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #41

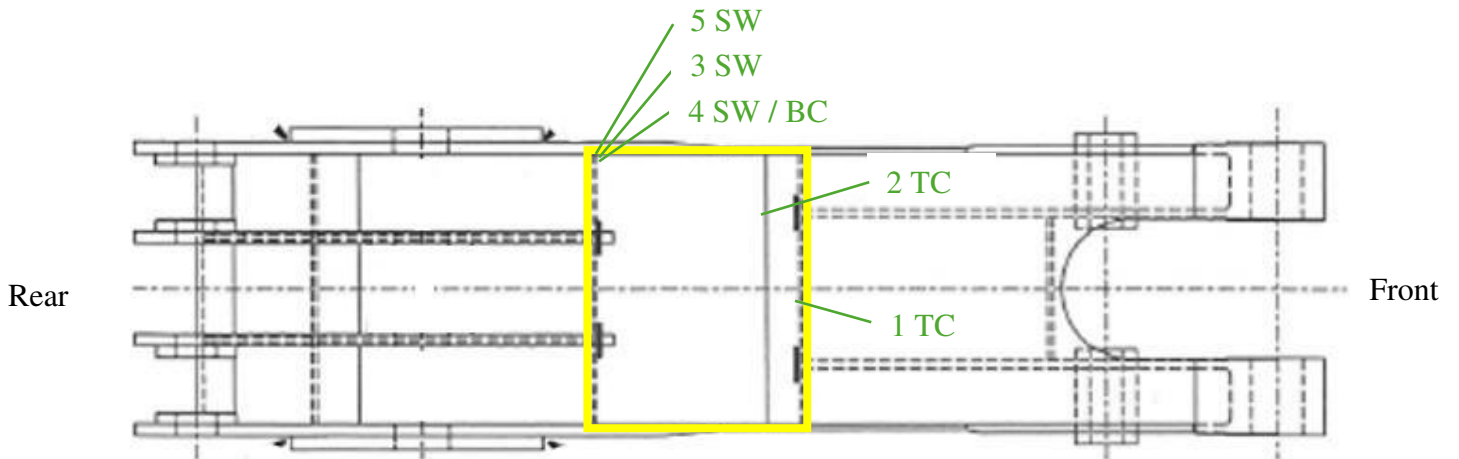


PHOTOGRAPH NO. 42 – EXTERNAL STICK  
TYPICAL VIEW OF REPAIRED DEFECT #42



## RESULTS OF EXAMINATION CONTINUED

**FIGURE 5 – INTERNAL BAY ‘B’**



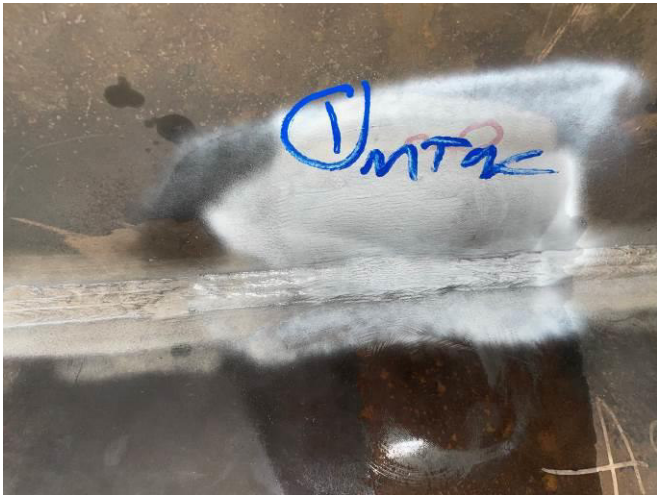
Note: Highlighted Area Inspected

TC = Top Cord  
 BC = Bottom Cord  
 SW = Side Wall

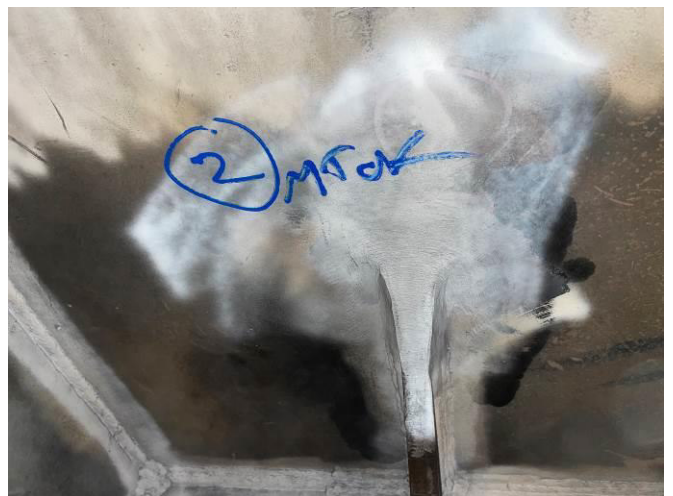
**TABLE 2.0 – INTERNAL BAY ‘B’ REPAIRED DEFECTS:**

Defect No.	Length in mm	Defect No.	Length in mm
No. 1	30	No. 4	200
No. 2	50	No. 5	80
No. 3	180		

PHOTOGRAPH NO. 43 – INTERNAL BAY ‘B’  
TYPICAL VIEW OF REPAIRED DEFECT #1



PHOTOGRAPH NO. 44 – INTERNAL BAY ‘B’  
TYPICAL VIEW OF REPAIRED DEFECT #2



PHOTOGRAPH NO. 45 - INTERNAL BAY ‘B’  
TYPICAL VIEW OF REPAIRED DEFECT #3



PHOTOGRAPH NO. 46 – INTERNAL BAY ‘B’  
TYPICAL VIEW OF REPAIRED DEFECT #4



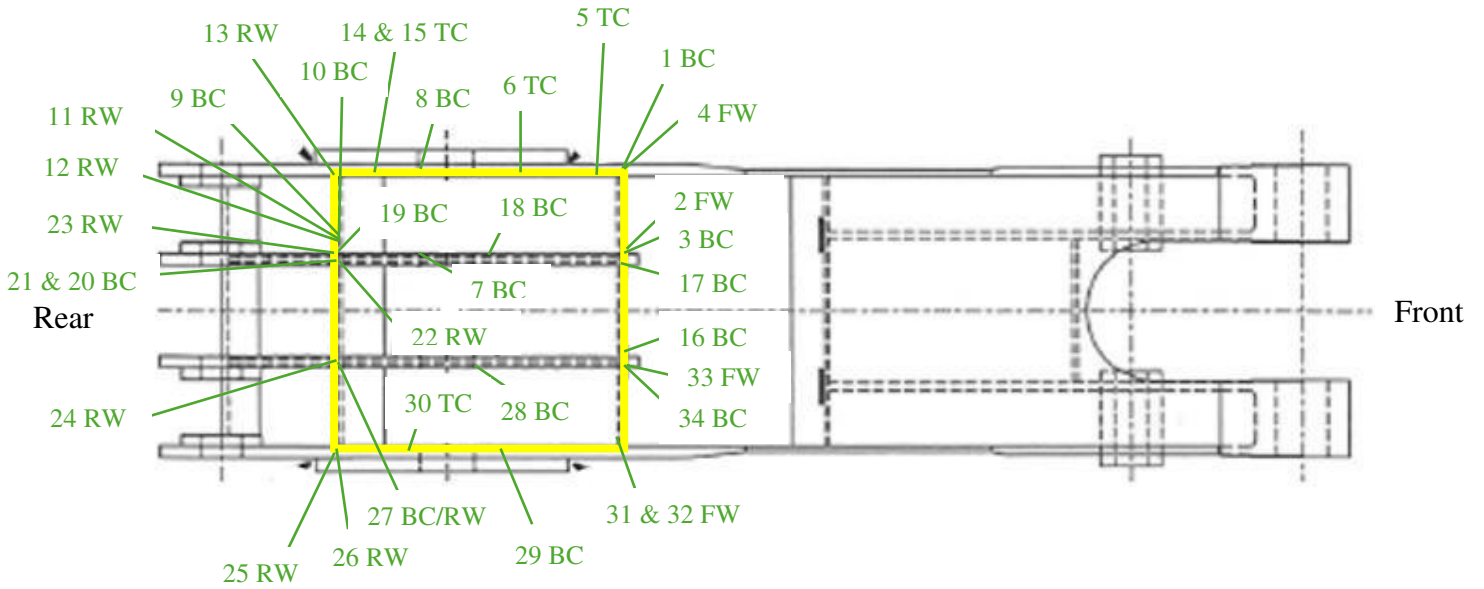
PHOTOGRAPH NO. 47 – INTERNAL BAY ‘B’  
TYPICAL VIEW OF REPAIRED DEFECT #5



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## RESULTS OF EXAMINATION CONTINUED

**FIGURE 6 – INTERNAL BAY ‘C’**



Note: Highlighted Area Inspected

- TC = Top Coad
- BC = Bottom Cord
- SW = Side Wall
- FW = Front Wall
- RW = Rear Wall

**RESULTS OF EXAMINATION CONTINUED**

**TABLE 3.0 – INTERNAL BAY ‘C’ REPAIRED DEFECTS:**

<b>Defect No.</b>	<b>Length in mm</b>	<b>Defect No.</b>	<b>Length in mm</b>
<b>No. 1</b>	50	<b>No. 18</b>	2100
<b>No. 2</b>	100	<b>No. 19</b>	40
<b>No. 3</b>	80	<b>No. 20</b>	40
<b>No. 4</b>	100	<b>No. 21</b>	300
<b>No. 5</b>	190	<b>No. 22</b>	200
<b>No. 6</b>	400	<b>No. 23</b>	160
<b>No. 7</b>	1200	<b>No. 24</b>	1100
<b>No. 8</b>	1200	<b>No. 25</b>	500
<b>No. 9</b>	30	<b>No. 26</b>	350
<b>No. 10</b>	130	<b>No. 27</b>	190
<b>No. 11</b>	600	<b>No. 28</b>	1500
<b>No. 12</b>	480	<b>No. 29</b>	300
<b>No. 13</b>	850	<b>No. 30</b>	10, 10
<b>No. 14</b>	100, 120	<b>No. 31</b>	140
<b>No. 15</b>	300	<b>No. 32</b>	120
<b>No. 16</b>	20	<b>No. 33</b>	800
<b>No. 17</b>	150	<b>No. 34</b>	80

PHOTOGRAPH NO. 48 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #1



PHOTOGRAPH NO. 49 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #2



PHOTOGRAPH NO. 50 - INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #3



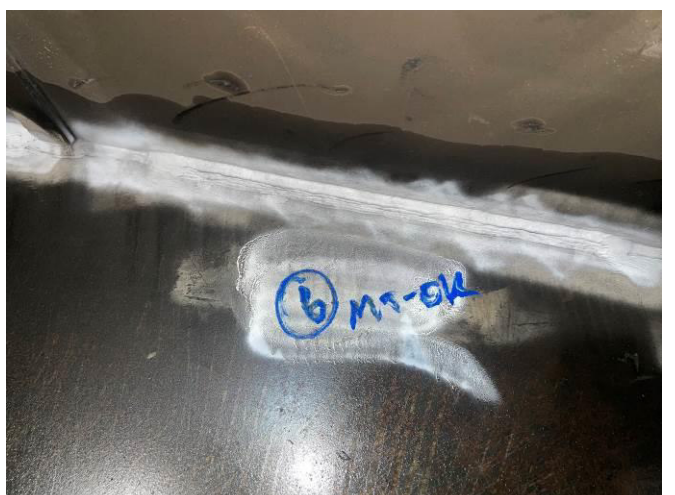
PHOTOGRAPH NO. 51 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #4



PHOTOGRAPH NO. 52 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #5



PHOTOGRAPH NO. 53 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #6



PHOTOGRAPH NO. 54 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #7



PHOTOGRAPH NO. 55 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #8



PHOTOGRAPH NO. 56 - INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #9



PHOTOGRAPH NO. 57 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #10



PHOTOGRAPH NO. 58 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #11



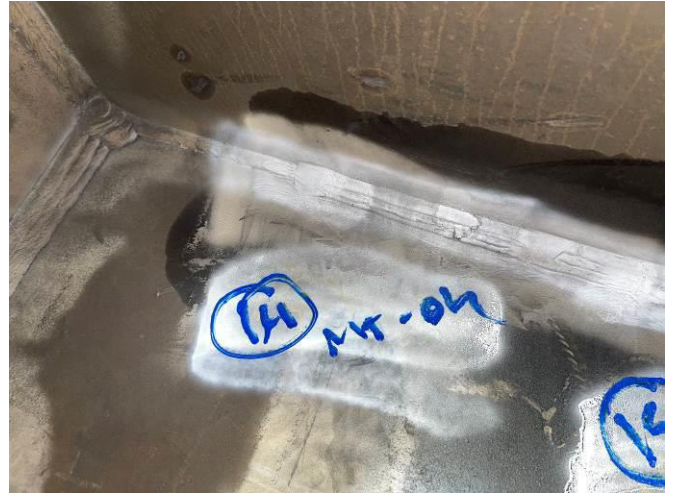
PHOTOGRAPH NO. 59 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #12



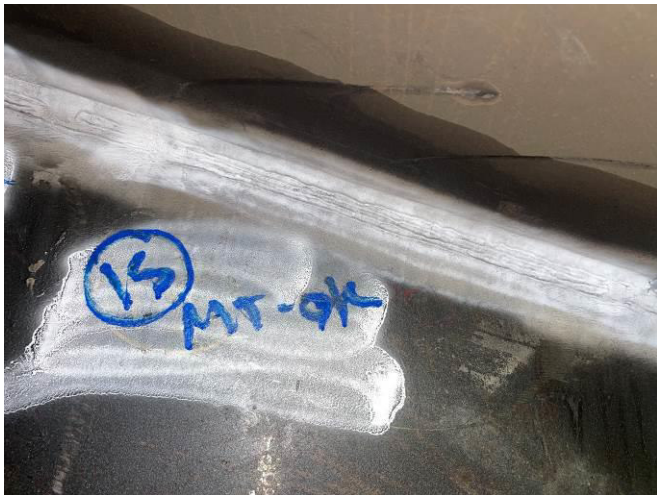
PHOTOGRAPH NO. 60 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #13



PHOTOGRAPH NO. 61 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #14



PHOTOGRAPH NO. 62 - INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #15



PHOTOGRAPH NO. 63 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #16



PHOTOGRAPH NO. 64 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #17



PHOTOGRAPH NO. 65 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #18





PHOTOGRAPH NO. 66 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #19



PHOTOGRAPH NO. 67 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #20



PHOTOGRAPH NO. 68 - INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #21



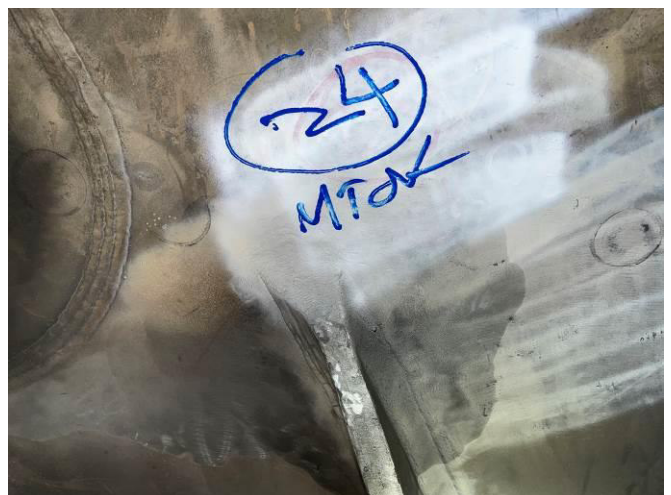
PHOTOGRAPH NO. 69 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #22



PHOTOGRAPH NO. 70 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #23



PHOTOGRAPH NO. 71 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #24



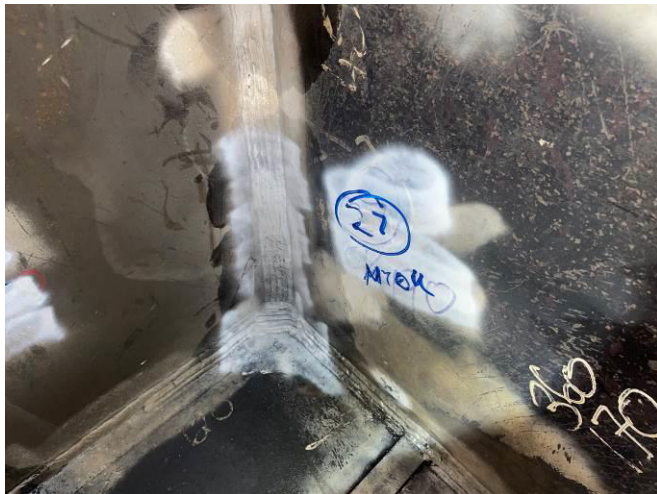
PHOTOGRAPH NO. 72 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #25



PHOTOGRAPH NO. 73 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #26



PHOTOGRAPH NO. 74 - INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #27



PHOTOGRAPH NO. 75 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #28



PHOTOGRAPH NO. 76 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #29



PHOTOGRAPH NO. 77 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #30



PHOTOGRAPH NO. 78 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #31



PHOTOGRAPH NO. 79 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #32



PHOTOGRAPH NO. 80 - INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #33



PHOTOGRAPH NO. 81 – INTERNAL BAY ‘C’  
TYPICAL VIEW OF REPAIRED DEFECT #34



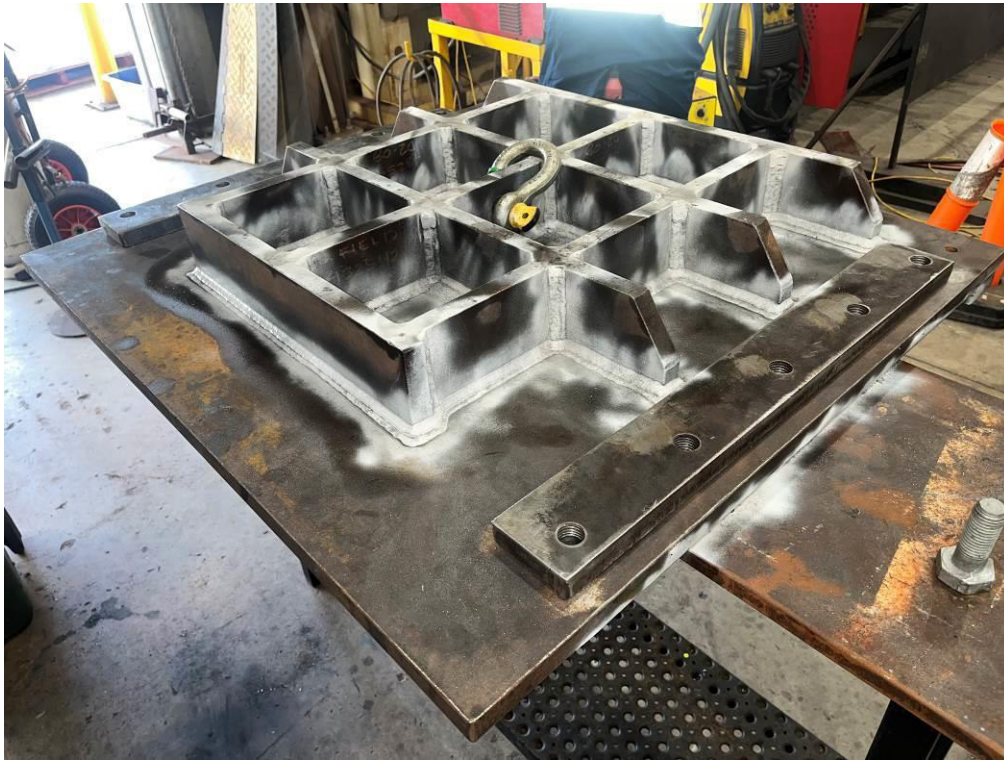
PHOTOGRAPH NO. 82 – GENERAL VIEW OF EX5500 STICK



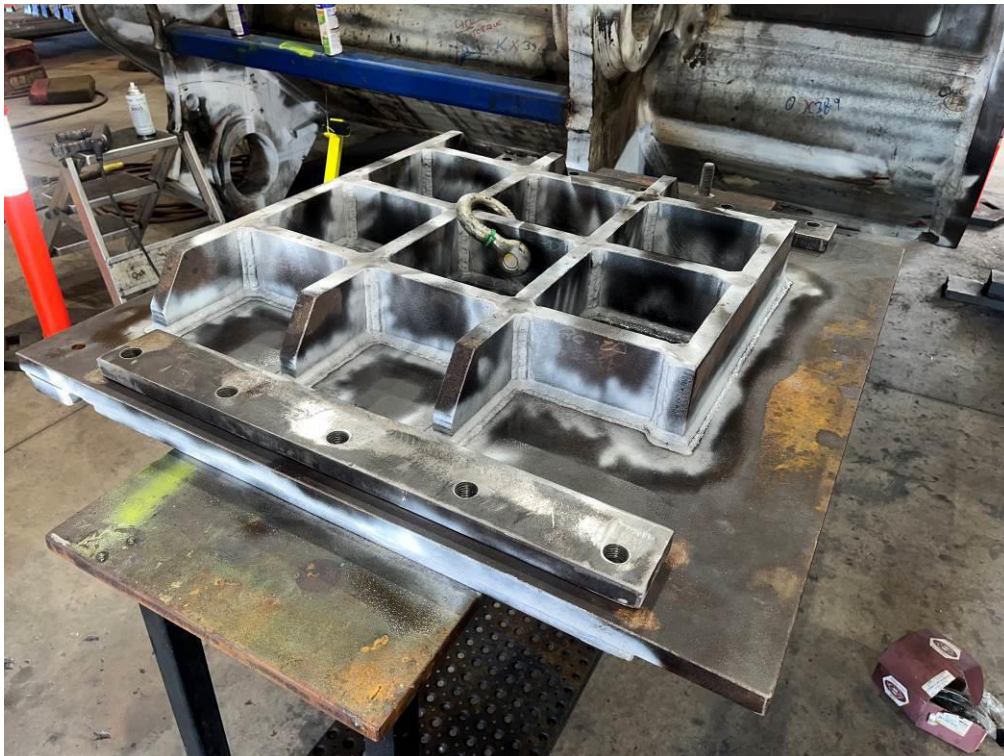
PHOTOGRAPH NO. 83 – GENERAL VIEW OF EX5500 STICK



PHOTOGRAPH NO. 84 – GENERAL VIEW OF EX5500 STICK – BASH PLATE



PHOTOGRAPH NO. 85 – GENERAL VIEW OF EX5500 STICK – BASH PLATE



*Section 5*

# WELDING RECORDS

Document Name	Document ID	Version	Issue Date	Page
Workshop MDR	F_QA-013	1	10.02.2019	Page 7 of 8

# WELDING PROCEDURE SPECIFICATION



WELDING PROCEDURE SPECIFICATION NUMBER		WMS_WPS-032	
<b>Code / Standard:</b>	AS/NZS 1554.1 SP	<b>Edge Preparation:</b>	Flame Cut & Grind or Machined
<b>Process:</b>	FCAW	<b>Power Source:</b>	DC Constant Voltage Transformer or Inverter
<b>Joint Type:</b>	Single Bevel Butt With Backing (BW,ss,mb)	<b>Technique:</b>	Stringer
<b>Joint Position:</b>	4G (PE)	<b>Multi-run or Single:</b>	Multi
<b>Positions Qualified:</b>	1G (PA), 2G (PC) & 4G (PD & PE)	<b>Torch Angle:</b>	5° Drag
<b>PQR Number:</b>	IS4R-WPQR-003	<b>Inter Pass Cleaning:</b>	Grind & Brush
<b>Revision:</b>	0	<b>Root Opening (G):</b>	6mm
<b>Date Issued:</b>	02/03/20	<b>Root Face (F):</b>	0mm
<b>Welder:</b>	Craig Evans	<b>Grove Angle (DEG):</b>	45° Included (AS1554 +10° to -5°)
<b>Location:</b>	Mackay Facility	<b>Backing:</b>	6mm GR250 plate

## WELDING CONSUMABLE DETAIL

Consumable No 1		Consumable No 2		Shield Gas/Flux	
Classification/Grade:	B T 49 3 T12 1 C A U H10	Classification/Grade:	NA	Shield Gas:	Argosshield 52 - Ar+25% CO
Diameter:	1.6mm	Diameter:	NA	Flow Rate:	20L/M +≥25%/-≥10%
Trade Name:	Verti-Cor 3XP E71T-1 H8	Trade Name:	NA	Purge Rate:	N/A
Batch #:	7486	Batch #:	NA	Flux:	N/A
Stickout:	15-20mm	Stickout:	NA		

WELD PREPARATION	SEQUENCE/POSITION	MATERIAL SPECIFICATION				
	Side 1		<b>TYPE/GRADE</b>	<b>GROUP</b>	<b>T</b>	<b>Diameter</b>
	Side 2		AS 1554	mm	mm	
		1	AS/NZS 3678 Gr. 350	5	12	N/A
		2	AS/NZS 3678 Gr. 350	5	12	N/A
		RANGE QUALIFIED		AS 1554.1: 6mm to 25mm		
		<b>THERMAL TREATMENT</b>				
		PREHEAT:		50°C		
		MAX INTERPASS:		175°C		
		P.W.H.T.:		NIL		

WELD PASS DETAILS					ELECTRODE DESCRIPTION		PREHEAT	WELDING PARAMETERS									
PROCESS	PASS NO.	SIDE NO.	POS	DIR	TYPE	ELECTRODE SIZE mm	SPEC	TEMP °C	AMPS		VOLTS		POL	TRAVEL SPEED (mm/min)		HEAT INPUT (KJ/mm)	
									Min	Max	Min	Max		Min	Max	Min	Max
FCAW Root	1	1	3G	Up	136	1.6mm	Verti-Cor 3XP E71T-1 H8	50°C	214.2	261.8	22.5	25.9	DC+	332.4	449.7	0.8	1.0
									<b>Actual 238</b>		<b>Actual 24.2</b>		<b>Actual 391</b>		<b>Actual 0.88</b>		
FCAW Hot Pass	2-3	1	3G	Up	136	1.6mm	Verti-Cor 3XP E71T-1 H8	50°C	199.8	244.2	22.5	25.9	DC+	303.0	410.0	0.8	1.0
									<b>Actual 222</b>		<b>Actual 24.2</b>		<b>Actual 356.5</b>		<b>Actual 0.91</b>		
FCAW Fill	4-6	1	3G	Up	136	1.6mm	Verti-Cor 3XP E71T-1 H8	50°C	205.7	251.46	22.5	25.9	DC+	279.7	378.4	0.9	1.1
									<b>Actual 228.6</b>		<b>Actual 24.2</b>		<b>Actual 329</b>		<b>Actual 1.01</b>		
FCAW Cap	7-9	1	3G	Up	136	1.6mm	Verti-Cor 3XP E71T-1 H8	50°C	192.9	235.73	22.5	25.9	DC+	261.0	353.1	0.9	1.2
									<b>Actual 214.3</b>		<b>Actual 24.2</b>		<b>Actual 307</b>		<b>Actual 1.05</b>		

TESTING REQUIRED & RESULTS	NOTES		
Refer to supporting PQR for the following testing reports:  Visual: IS4R-RPT-0087 Mechanical: IS4R-RPT-0085 NDT: M21-1118 Chemical: BE00027892/MC/PK/XII/19	Preheat - Ensure preheat is applied according to the relevant material within the group and/or the combined joint thickness as per preheat calculations outlined in WTIA Tech Note 1 for compliance to AS 1554.1. - Interpass temperature is limited due to CVN impact requirements and temper preservation for this material.  General - Ensure joints are free from contaminants.		
	MINIMUM PREHEAT & MAXIMUM INTERPASS TEMP Gr. 350		
	THICKNESS	PREHEAT	INTERPASS
	≥26<50	50°C	175°C
	≥50<100	75°C	200°C
	≥100	140°C	220°C

<b>Complied By:</b>	Clancy Crerar -iScope-	<b>Reviewed By:</b>	Craig Evans -iScope-	<b>Reviewed By:</b>	
<b>Signed:</b>		<b>Signed:</b>		<b>Signed:</b>	
	AU/IWI B/0895		WTIA AU/IWS/6082 / WTIA SS-2054 / AU/IWI B/00746		



iScope 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 the standard and category specifications.





# WELDING PROCEDURE SPECIFICATION



WELDING PROCEDURE SPECIFICATION NUMBER		WMS_WPS-070	
<b>Code / Standard:</b>	AS/NZS 1554.5:2014	<b>Edge Preparation:</b>	Flame Cut & Grind or Machined
<b>Process:</b>	FCAW	<b>Power Source:</b>	DC Constant Voltage Transformer or Inverter
<b>Joint Type:</b>	Double Bevel Butt	<b>Technique:</b>	Stringer
<b>Joint Position:</b>	3G (PF)	<b>Torch Angle:</b>	5° Push
<b>Positions Qualified:</b>	3G (PF)	<b>Inter Pass Cleaning:</b>	Grind & Brush
<b>Multi-run or Single:</b>	Multi	<b>Root Opening:</b>	0mm to 3mm
<b>PQR Number:</b>	IS4R-WPQR-118	<b>Root Face:</b>	0mm to 2.5mm
<b>Revision:</b>	0	<b>Grove Angle:</b>	40° to 55° Included
<b>Date Issued:</b>	21/06/2023	<b>Backing:</b>	Nil

## WELDING CONSUMABLE DETAIL

Consumable No 1		Consumable No 2		Shield Gas/Flux	
Classification/Grade: AS/NZS ISO 14341	B T 49 3 T12 1 M A N2 U H5	Classification/Grade: AS/NZS ISO 14341	N/A	Shield Gas Composition: ISO 14175	M26-ArCO-16/2.75
Diameter:	1.6mm	Diameter:	N/A	Flow Rate:	18-25 L/M
Trade Name:	Verti-Cor 3XP E71T-12M H4	Trade Name:	N/A	Purge Rate:	N/A
Stickout:	15-20mm	Stickout:	N/A	Flux:	N/A

WELD PREPARATION		SEQUENCE/POSITION		MATERIAL SPECIFICATION				
		<p style="text-align: center;">Side 1</p> <p style="text-align: center;">Side 2</p> <p style="text-align: center;">Number of weld passes are indicative to nominated weld procedure and may vary</p>		TYPE/GRADE		GROUP	T	Diameter
						AS 1554	mm	mm
				1	AS3678 Gr350	Steel Type: 1, 2, 4, 5 Weldability Group: ≤6	40	NA
				1	AS3678 Gr350	Steel Type: 1, 2, 4, 5 Weldability Group: ≤6	40	NA
<b>RANGE QUALIFIED</b>								
Thickness: 20mm to Unlimited								
<b>THERMAL TREATMENT</b>								
PREHEAT:				Refer to Table in Notes				
MAX INTERPASS:				220°C				

WELD PASS DETAILS					ELECTRODE DESCRIPTION			PREHEAT	WELDING PARAMETERS								
PROCESS	PASS NO.	SIDE NO.	POS	DIR	TYPE	ELECTRODE SIZE mm	SPEC	TEMP °C	AMPS		VOLTS		POL	TRAVEL SPEED (mm/min)		HEAT INPUT (KJ/mm)	
									Actual -10%	Actual +10%	Min	Max		Actual -15%	Actual +15%	Min	Max
FCAW Root	1	1	3G (PF)	Up	136	1.6mm	A5.20 E71T-12M H4	75°C	228	278	23.4	27.0	DC+	173	233	1.37	2.61
									<b>Actual 253</b>		<b>Actual 25.2</b>		<b>Actual 203</b>		<b>Actual 1.99</b>		
FCAW Hot Pass	2	1	3G (PF)	Up	136	1.6mm	A5.20 E71T-12M H4	75°C	221	270	23.4	27.0	DC+	277	374	0.83	1.58
									<b>Actual 245</b>		<b>Actual 25.2</b>		<b>Actual 325</b>		<b>Actual 1.20</b>		
FCAW Fill & Cap	3 - 10	1	3G (PF)	Up	136	1.6mm	A5.20 E71T-12M H4	75°C	229	280	23.0	26.4	DC+	235	318	0.99	1.89
									<b>Actual 254</b>		<b>Actual 24.7</b>		<b>Actual 276</b>		<b>Actual 1.44</b>		
FCAW Root	1	2	3G (PF)	Up	136	1.6mm	A5.20 E71T-12M H4	75°C	236	288	22.9	26.3	DC+	184	248	1.30	2.48
									<b>Actual 262</b>		<b>Actual 24.6</b>		<b>Actual 216</b>		<b>Actual 1.89</b>		
FCAW Hot Pass	2	2	3G (PF)	Up	136	1.6mm	A5.20 E71T-12M H4	75°C	231	283	22.9	26.3	DC+	249	338	0.94	1.79
									<b>Actual 257</b>		<b>Actual 24.6</b>		<b>Actual 294</b>		<b>Actual 1.37</b>		
FCAW Fill & Cap	3 - 12	2	3G (PF)	Up	136	1.6mm	A5.20 E71T-12M H4	75°C	223	273	22.9	26.3	DC+	222	300	1.02	1.94
									<b>Actual 248</b>		<b>Actual 24.6</b>		<b>Actual 261</b>		<b>Actual 1.48</b>		

## NOTES

<b>Preheat</b> - Ensure preheat is applied according to the relevant material within the group and/or the combined joint thickness as per preheat calculations outlined in WTIA Tech Note 1 for compliance to AS 1554.5. - Interpass temperature is limited due to CVN impact requirements and temper preservation for this material.			MINIMUM PREHEAT & MAXIMUM INTERPASS TEMP Gr350		
			CJT	PREHEAT	INTERPASS
			<50	50°C	180°C
			≥50<100	75°C	220°C
			≥100	140°C	220°C

<b>Complied By:</b>	Clancy Crerar -iScope-	<b>Reviewed By:</b>	Craig Evans -iScope-	<b>Reviewed By:</b>	
<b>Signed:</b>		<b>Signed:</b>		<b>Signed:</b>	
AU/IWI B/0895 / CC184154-02		WTIA AU/IWS/6082 / WTIA SS-2054 / AU/IWI 5201730			

iScope 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 the standard and category specifications.



Mining Services

## WELDING & PRE-HEAT RECORD SHEET

Client:		Mine spec		Job No: 29044		Date: 28/3/2024		Weld Procedure:		WMS_WPS-064			
Scope#		0		Description: Crack Repairs - Fillet Weld		Weld Size & Finish		Fill & Blend Cracked Areas To Match Existing Contour					
Job Description:		EX 5600 Stick				Drawing No:							
Welder ID	Joint Type/ ID	Weld Procedure No	Recommended Preheat Temp °c	Actual Preheat Temp °c	Date Taken	Time Taken	Volts	Amps	Plant ID	Consumable Used	Consumable Batch No:	Inspected By: Print Name	Inspected By: Initials
CP312	1G	WMS_WPS-064	50°	52°	28/3/24	6:00 AM	23.2 V	160	A	E71T-12M H4 - 1.6mm	2001508093		
CP312	4	WMS_WPS-064	50°	51°		7:00 AM	23.2 V	160	A	E71T-12M H4 - 1.6mm	2001508093		
CP312		WMS_WPS-064	50°	54°		8:00 AM	23.2 V	160	A	E71T-12M H4 - 1.6mm	2001508093		
CP312	6	WMS_WPS-064	50°	53°		9:00 AM	23.2 V	160	A	E71T-12M H4 - 1.6mm	2001508093		
CP312	6	WMS_WPS-064	50°	55°		10:00 AM	23.2 V	160	A	E71T-12M H4 - 1.6mm	2001508093		
CP312	6	WMS_WPS-064	50°	52°		11:00 AM	23.2 V	160	A	E71T-12M H4 - 1.6mm	2001508093		
CP312	2G	WMS_WPS-064	50°	57°		12: PM	23.2 V	160	A	E71T-12M H4 - 1.6mm	2001508093		
CP312	4	WMS_WPS-064	50°	55°		1:00 PM	23.2 V	160	A	E71T-12M H4 - 1.6mm	2001508093		
CP312	7	WMS_WPS-064	50°	54		2:00 PM	23.2 V	160	A	E71T-12M H4 - 1.6mm	2001508093		
		WMS_WPS-064	50°				V		A	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°				V		A	E71T-12M H4 - 1.6mm			

Bimal  
Baid

\* NOTE: Readings to be recorded first when the recommended temperature is reached & once every Hour during Welding.

### PRE-HEAT and CONSUMABLE GUIDE

Material	20mm & Under	20mm - 40mm	40mm - 60mm	60mm <	Process	Consumable
Q & T 80	100°C	100°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 400	150°C	150°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 450	150°C	150°C	150°C	150°C	FCAW	E81T1-N1-H4
GR250	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
GR350	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
Cruesabro	30°C	30°C	30°C	30°C	FCAW	E71T1-H8

Uncontrolled If Printed



Mining Services

## WELDING & PRE-HEAT RECORD SHEET

Client:		Mine spec		Job No: 29044		Date:		Weld Procedure:		WMS_WPS-064			
Scope# 1.02		Description: Crack Repairs - Fillet Weld				Weld Size & Finish		Fill & Blend Cracked Areas To Match Existing Contour					
Job Description:		EX 5600 Stick				Drawing No:							
Welder ID	Joint Type/ID	Weld Procedure No	Recommended Preheat Temp °c	Actual Preheat Temp °c	Date Taken	Time Taken	Volts	Amps	Plant ID	Consumable Used	Consumable Batch No:	Inspected By: Print Name	Inspected By: Initials
CMUO	Fillet	WMS_WPS-064	50°	52°C	8-4-24	6:11 AM	25 V	190 A		E71T-12M H4 - 1.6mm	2001508093	Brad Bail	B
		WMS_WPS-064	50°	56°C		7:24 AM				E71T-12M H4 - 1.6mm			
	IF	WMS_WPS-064	50°	58°C		8:36 AM				E71T-12M H4 - 1.6mm			
	211	WMS_WPS-064	50°	54°C		9:41 AM				E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°	57°C		10:58 AM				E71T-12M H4 - 1.6mm			
	"	WMS_WPS-064	50°	60°C		12:02 PM				E71T-12M H4 - 1.6mm			
	2F	WMS_WPS-064	50°	57°C		1:07 PM				E71T-12M H4 - 1.6mm			
	4	WMS_WPS-064	50°	57°C		2:15 PM				E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°							E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°							E71T-12M H4 - 1.6mm			
	4	WMS_WPS-064	50°							E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°							E71T-12M H4 - 1.6mm			

\* NOTE: Readings to be recorded first when the recommended temperature is reached & once every Hour during Welding.

### PRE-HEAT and CONSUMABLE GUIDE

Material	20mm & Under	20mm - 40mm	40mm - 60mm	60mm <	Process	Consumable
Q & T 80	100°C	100°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 400	150°C	150°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 450	150°C	150°C	150°C	150°C	FCAW	E81T1-N1-H4
GR250	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
GR350	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
Cruesabro	30°C	30°C	30°C	30°C	FCAW	E71T1-H8

Uncontrolled If Printed



Mining Services

## WELDING & PRE-HEAT RECORD SHEET

Client:		Mine spec		Job No: 29044		Date: 8/4/24		Weld Procedure:		WMS_WPS-064			
Scope#		0		Description: Crack Repairs - Fillet Weld		Weld Size & Finish		Fill & Blend Cracked Areas To Match Existing Contour					
Job Description:		EX 5600 Stick				Drawing No:							
Welder ID	Joint Type/ ID	Weld Procedure No	Recommended Preheat Temp °c	Actual Preheat Temp °c	Date Taken	Time Taken	Volts	Amps	Plant ID	Consumable Used	Consumable Batch No:	Inspected By: Print Name	Inspected By: Initials
350	209	WMS_WPS-064	50°	85	8/4/24	8:00	24 V	190 A		E71T-12M H4 - 1.6mm	3XP		
350	209	WMS_WPS-064	50°	86	↓	9:00	24 V	190 A		E71T-12M H4 - 1.6mm	↓		
350	409	WMS_WPS-064	50°	87		10:00	24 V	190 A		E71T-12M H4 - 1.6mm			
350	409	WMS_WPS-064	50°	89		11:00	24 V	190 A		E71T-12M H4 - 1.6mm			
350	309	WMS_WPS-064	50°	90		12:00	24 V	190 A		E71T-12M H4 - 1.6mm			
350	309	WMS_WPS-064	50°	91		01:00	24 V	190 A		E71T-12M H4 - 1.6mm			
350	309	WMS_WPS-064	50°	92		02:00	24 V	190 A		E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°					V	A			E71T-12M H4 - 1.6mm	
		WMS_WPS-064	50°					V	A			E71T-12M H4 - 1.6mm	
		WMS_WPS-064	50°				V	A		E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°				V	A		E71T-12M H4 - 1.6mm			

\* NOTE: Readings to be recorded first when the recommended temperature is reached & once every Hour during Welding.

### PRE-HEAT and CONSUMABLE GUIDE

Material	20mm & Under	20mm - 40mm	40mm - 60mm	60mm<	Process	Consumable
Q & T 80	100°C	100°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 400	150°C	150°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 450	150°C	150°C	150°C	150°C	FCAW	E81T1-N1-H4
GR250	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
GR350	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
Cruesabro	30°C	30°C	30°C	30°C	FCAW	E71T1-H8

Uncontrolled If Printed



Mining Services

## WELDING & PRE-HEAT RECORD SHEET

Client:		Mine spec		Job No: 29044		Date:		Weld Procedure:		WMS_WPS-064			
Scope# 1.02		Description: Crack Repairs - Fillet Weld				Weld Size & Finish		Fill & Blend Cracked Areas To Match Existing Contour					
Job Description:		EX 5600 Stick				Drawing No:							
Welder ID	Joint Type/ID	Weld Procedure No	Recommended Preheat Temp °C	Actual Preheat Temp °C	Date Taken	Time Taken	Volts	Amps	Plant ID	Consumable Used	Consumable Batch No:	Inspected By: Print Name	Inspected By: Initials
CARLO	Fillet	WMS_WPS-064	50°	57°	9-4-24	5:18 AM	28 V	190 A		E71T-12M H4 - 1.6mm	200508093	P. B. B.	P.
	IF	WMS_WPS-064	50°	54°		6:24 AM				E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°	57°		7:37 AM				E71T-12M H4 - 1.6mm			
	4	WMS_WPS-064	50°	54°		8:41 AM				E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°	58°		9:09 AM				E71T-12M H4 - 1.6mm			
	2F	WMS_WPS-064	50°	62°		10:44 AM				E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°	64°		11:50 AM				E71T-12M H4 - 1.6mm			
	4	WMS_WPS-064	50°	53°		1:39 PM				E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°	59°		2:29 PM				E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°							E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°							E71T-12M H4 - 1.6mm			

\* NOTE: Readings to be recorded first when the recommended temperature is reached & once every Hour during Welding.

### PRE-HEAT and CONSUMABLE GUIDE

Material	20mm & Under	20mm - 40mm	40mm - 60mm	60mm <	Process	Consumable
Q & T 80	100°C	100°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 400	150°C	150°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 450	150°C	150°C	150°C	150°C	FCAW	E81T1-N1-H4
GR250	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
GR350	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
Cruesabro	30°C	30°C	30°C	30°C	FCAW	E71T1-H8

\*Uncontrolled if Printed



## WELDING & PRE-HEAT RECORD SHEET

Mining Services

Client:		Mine spec		Job No: 29044		Date:		Weld Procedure:		WMS_WPS-064			
Scope# 1.02		Description: Crack Repairs - Fillet Weld				Weld Size & Finish		Fill & Blend Cracked Areas To Match Existing Contour					
Job Description:		EX 5600 Stick				Drawing No:							
Welder ID	Joint Type/ ID	Weld Procedure No	Recommended Preheat Temp °c	Actual Preheat Temp °c	Date Taken	Time Taken	Volts	Amps	Plant ID	Consumable Used	Consumable Batch No:	Inspected By: Print Name	Inspected By: Initials
CARD	16	WMS_WPS-064	50°	53°C	10-4-20	5:31 AM	25	190	A	E71T-12M H4 - 1.6mm	2001508093	Bhal Baird	B
		WMS_WPS-064	50°	56°C		6:24 AM			A	E71T-12M H4 - 1.6mm			
	h	WMS_WPS-064	50°	60°C		7:33 AM			A	E71T-12M H4 - 1.6mm			
	u	WMS_WPS-064	50°	64°C		8:40 AM			A	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°	54°C		9:37 AM			A	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°	58°C		10:42 AM			A	E71T-12M H4 - 1.6mm			
	26	WMS_WPS-064	50°	62°C		11:50 AM			A	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°	55°C		1:39 PM			A	E71T-12M H4 - 1.6mm			
	4	WMS_WPS-064	50°	59°C		2:22 PM			A	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°						A	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°						A	E71T-12M H4 - 1.6mm			

\* NOTE: Readings to be recorded first when the recommended temperature is reached & once every Hour during Welding.

### PRE-HEAT and CONSUMABLE GUIDE

Material	20mm & Under	20mm - 40mm	40mm - 60mm	60mm<	Process	Consumable
Q & T 80	100°C	100°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 400	150°C	150°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 450	150°C	150°C	150°C	150°C	FCAW	E81T1-N1-H4
GR250	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
GR350	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
Cruesabro	30°C	30°C	30°C	30°C	FCAW	E71T1-H8

Uncontrolled If Printed



## WELDING & PRE-HEAT RECORD SHEET

Mining Services

Client:		Mine spec		Job No: 29044		Date:		Weld Procedure:		WMS_WPS-064			
Scope#		1.02		Description: Crack Repairs - Fillet Weld		Weld Size & Finish		Fill & Blend Cracked Areas To Match Existing Contour					
Job Description:		EX 5600 Stick				Drawing No:							
Welder ID	Joint Type/ID	Weld Procedure No	Recommended Preheat Temp °C	Actual Preheat Temp °C	Date Taken	Time Taken	Volts	Amps	Plant ID	Consumable Used	Consumable Batch No:	Inspected By: Print Name	Inspected By: Initials
CAND	16	WMS_WPS-064	50°		11-4-24	5:18 AM	25	V 190	A	E71T-12M H4 - 1.6mm	2001508093	Basil	B
	4	WMS_WPS-064	50°			6:22 AM		V	A	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°			7:36 AM		V	A	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°			8:41 AM		V	A	E71T-12M H4 - 1.6mm			
	u	WMS_WPS-064	50°			9:40 AM		V	A	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°			10:45 AM		V	A	E71T-12M H4 - 1.6mm			
	26	WMS_WPS-064	50°			11:52 AM		V	A	E71T-12M H4 - 1.6mm			
	4	WMS_WPS-064	50°			1:37 PM		V	A	E71T-12M H4 - 1.6mm			
	9	WMS_WPS-064	50°			2:26 PM		V	A	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°					V	A	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°					V	A	E71T-12M H4 - 1.6mm			

\* NOTE: Readings to be recorded first when the recommended temperature is reached & once every Hour during Welding.

### PRE-HEAT and CONSUMABLE GUIDE

Material	20mm & Under	20mm - 40mm	40mm - 60mm	60mm <	Process	Consumable
Q & T 80	100°C	100°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 400	150°C	150°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 450	150°C	150°C	150°C	150°C	FCAW	E81T1-N1-H4
GR250	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
GR350	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
Cruesabro	30°C	30°C	30°C	30°C	FCAW	E71T1-H8

Uncontrolled If Printed



## WELDING & PRE-HEAT RECORD SHEET

Client:		Mine spec		Job No: 29044		Date:		Weld Procedure:		WMS_WPS-064				
Scope#		1.02		Description: Crack Repairs - Fillet Weld		Weld Size & Finish		Fill & Blend Cracked Areas To Match Existing Contour						
Job Description:		EX 5600 Stick				Drawing No:								
Welder ID	Joint Type/ID	Weld Procedure No	Recommended Preheat Temp °C	Actual Preheat Temp °C	Date Taken	Time Taken	Volts	Amps	Plant ID	Consumable Used	Consumable Batch No:	Inspected By: Print Name	Inspected By: Initials	
CARLO	16	WMS_WPS-064	50°	52°C	12-4-24	6:15 AM	25	190	A	E71T-12M H4 - 1.6mm	2			
	4	WMS_WPS-064	50°	56°C		7:24 AM			A	E71T-12M H4 - 1.6mm	001508093			
		WMS_WPS-064	50°	58°C		8:36 AM			A	E71T-12M H4 - 1.6mm				
	4	WMS_WPS-064	50°	53°C		9:41 AM			A	E71T-12M H4 - 1.6mm				
		WMS_WPS-064	50°	57°C		11:02 AM			A	E71T-12M H4 - 1.6mm				
	26	WMS_WPS-064	50°	61°C		12:15 PM			A	E71T-12M H4 - 1.6mm			Bimal	B
	1	WMS_WPS-064	50°	55°C		1:35 PM			A	E71T-12M H4 - 1.6mm			Basel	
		WMS_WPS-064	50°	59°C		2:23 PM			A	E71T-12M H4 - 1.6mm				
	4	WMS_WPS-064	50°						A	E71T-12M H4 - 1.6mm				
		WMS_WPS-064	50°						A	E71T-12M H4 - 1.6mm				
		WMS_WPS-064	50°						A	E71T-12M H4 - 1.6mm				

\* NOTE: Readings to be recorded first when the recommended temperature is reached & once every Hour during Welding.

### PRE-HEAT and CONSUMABLE GUIDE

Material	20mm & Under	20mm - 40mm	40mm - 60mm	60mm <	Process	Consumable
Q & T 80	100°C	100°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 400	150°C	150°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 450	150°C	150°C	150°C	150°C	FCAW	E81T1-N1-H4
GR250	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
GR350	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
Cruesabro	30°C	30°C	30°C	30°C	FCAW	E71T1-H8

Uncontrolled If Printed





Mining Services

### WELDING & PRE-HEAT RECORD SHEET

Client: Minespec		Job No: 29044		Date: 10-4-24		Weld Procedure: WMS_WPS-032							
Scope#	0	Description: Crack Repairs - Full penetration Joints				Weld Size & Finish		Fill & Blend Cracked Areas To Match Existing Contour					
Job Description: EX 5600 Stick		Drawing No:											
Welder ID	Joint Type/ ID	Weld Procedure No	Recommended Preheat Temp °C	Actual Preheat Temp °C	Date Taken	Time Taken	Volts	Amps	Plant ID	Consumable Used	Consumable Batch No:	Inspected By: Print Name	Inspected By: Initials
C287	167	WMS_WPS-032	50°	60	600	10-4-24	24.5 V	196 A	WB305	E71T1-1 H8 - 1.6mm			
	167	WMS_WPS-032	50°	63	700	10-4	24.5 V	196 A	WB305	E71T1-1 H8 - 1.6mm			
	11	WMS_WPS-032	50°	62	800	10-4	24.5 V	196 A	WB305	E71T1-1 H8 - 1.6mm			
		WMS_WPS-032	50°	70	900	10-4	24.5 V	196 A	WB305	E71T1-1 H8 - 1.6mm			
	4	WMS_WPS-032	50°	65	1000	10-4	24.5 V	196 A	WB305	E71T1-1 H8 - 1.6mm			
	26	WMS_WPS-032	50°	67	1100	10-4	24.5 V	196 A	WB305	E71T1-1 H8 - 1.6mm		Bimal	B
	11	WMS_WPS-032	50°	63	1200	10-4	24.5 V	196 A	WB305	E71T1-1 H8 - 1.6mm		Band	
	11	WMS_WPS-032	50°	56	1300	10-4	24.5 V	196 A	WB305	E71T1-1 H8 - 1.6mm			
	26	WMS_WPS-032	50°	68	1400	10-4	24.5 V	196 A	WB305	E71T1-1 H8 - 1.6mm			
	11	WMS_WPS-032	50°				V	A		E71T1-1 H8 - 1.6mm			
		WMS_WPS-032	50°				V	A		E71T1-1 H8 - 1.6mm			

\* NOTE: Readings to be recorded first when the recommended temperature is reached & once every Hour during Welding.

#### PRE-HEAT and CONSUMABLE GUIDE

Material	20mm & Under	20mm - 40mm	40mm - 60mm	60mm<	Process	Consumable
Q & T 80	100°C	100°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 400	150°C	150°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 450	150°C	150°C	150°C	150°C	FCAW	E81T1-N1-H4
GR250	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
GR350	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
Cruesabro	30°C	30°C	30°C	30°C	FCAW	E71T1-H8

Uncontrolled If Printed



## WELDING & PRE-HEAT RECORD SHEET

Client: Minespec		Job No: 29044		Date: 10.04.24		Weld Procedure: WMS_WPS-032							
Scope#	0	Description: Crack Repairs - Full penetration Joints				Weld Size & Finish: Fill & Blend Cracked Areas To Match Existing Contour							
Job Description: EX 5600 Stick		Drawing No:											
Welder ID	Joint Type/ ID	Weld Procedure No	Recommended Preheat Temp °C	Actual Preheat Temp °C	Date Taken	Time Taken	Volts	Amps	Plant ID	Consumable Used	Consumable Batch No:	Inspected By: Print Name	Inspected By: Initials
CR137	Filet 4-G	WMS_WPS-032	50°	75	10/4/24	5:30	24 V	195 A	WS719	E71T1-1 H8 - 1.6mm	3LP		
↓	↓	WMS_WPS-032	50°	80	↓	6:30	↓ V	↓ A	↓	E71T1-1 H8 - 1.6mm	↓		
↓	↓	WMS_WPS-032	50°	76	↓	7:30	↓ V	↓ A	↓	E71T1-1 H8 - 1.6mm	↓		
↓	↓	WMS_WPS-032	50°	81	↓	8:30	↓ V	↓ A	↓	E71T1-1 H8 - 1.6mm	↓		
↓	↓	WMS_WPS-032	50°	86	↓	9:30	↓ V	↓ A	↓	E71T1-1 H8 - 1.6mm	↓		
↓	↓	WMS_WPS-032	50°	77	↓	10:30	↓ V	↓ A	↓	E71T1-1 H8 - 1.6mm	↓		
↓	↓	WMS_WPS-032	50°	60	↓	11:30	↓ V	↓ A	↓	E71T1-1 H8 - 1.6mm	↓		
↓	↓	WMS_WPS-032	50°	22	↓	12:30	↓ V	↓ A	↓	E71T1-1 H8 - 1.6mm	↓		
↓	↓	WMS_WPS-032	50°	73	↓	13:30	↓ V	↓ A	↓	E71T1-1 H8 - 1.6mm	↓		
↓	↓	WMS_WPS-032	50°	78	↓	14:30	↓ V	↓ A	↓	E71T1-1 H8 - 1.6mm	↓		
↓	↓	WMS_WPS-032	50°	77	↓	15:30	↓ V	↓ A	↓	E71T1-1 H8 - 1.6mm	↓		

\* NOTE: Readings to be recorded first when the recommended temperature is reached & once every Hour during Welding.

### PRE-HEAT and CONSUMABLE GUIDE

Material	20mm & Under	20mm - 40mm	40mm - 60mm	60mm<	Process	Consumable
Q & T 80	100°C	100°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 400	150°C	150°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 450	150°C	150°C	150°C	150°C	FCAW	E81T1-N1-H4
GR250	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
GR350	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
Cruesabro	30°C	30°C	30°C	30°C	FCAW	E71T1-H8

Uncontrolled If Printed



Mining Services

### WELDING & PRE-HEAT RECORD SHEET

Client: <b>BMA Peakdowns</b>		Job No: <b>29044</b>		Date: <b>17-04-24</b>	Weld Procedure: <b>WMS_WPS-070</b>								
Scope# <b>0</b>	Description: <b>Weld closing windows</b>			Weld Size & Finish	<b>0</b>								
Job Description: <b>EX5600 Boom &amp; Stick</b>				Drawing No:									
Welder ID	Joint Type/ ID	Weld Procedure No	Recommended Preheat Temp °c	Actual Preheat Temp °c	Date Taken	Time Taken	Volts	Amps	Plant ID	Consumable Used	Consumable Batch No:	Inspected By: Print Name	Inspected By: Initials
JMD	2G	WMS_WPS-070	75°	76°		5:45PM	24.8 v	185 A		E71T-12M H4 - 1.6mm			
	"	WMS_WPS-070	75°	78°		18:00	24.8 v			E71T-12M H4 - 1.6mm			
	"	WMS_WPS-070	75°	75°	24	18:20	24.8 v			E71T-12M H4 - 1.6mm			
	2G	WMS_WPS-070	75°	78°		18:32	24.5 v			E71T-12M H4 - 1.6mm			
	"	WMS_WPS-070	75°	79°	4	19:31	24.5 v			E71T-12M H4 - 1.6mm			
	"	WMS_WPS-070	75°	77°	0	20:03	24.9 v			E71T-12M H4 - 1.6mm			
	"	WMS_WPS-070	75°	78	18	22:40	23.9 v			E71T-12M H4 - 1.6mm			
	"	WMS_WPS-070	75°	76°		23:30	23.9 v			E71T-12M H4 - 1.6mm			
	"	WMS_WPS-070	75°	79°		01:30AM	24.9 v			E71T-12M H4 - 1.6mm			
	"	WMS_WPS-070	75°	78°		02:20AM	24.9 v			E71T-12M H4 - 1.6mm			
	"	WMS_WPS-070	75°	76°		03:40AM	24.9 v			E71T-12M H4 - 1.6mm			

\* NOTE: Readings to be recorded first when the recommended temperature is reached & once every Hour during Welding.

#### PRE-HEAT and CONSUMABLE GUIDE

Material	20mm & Under	20mm - 40mm	40mm - 60mm	60mm <	Process	Consumable
Q & T 80	100°C	100°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 400	150°C	150°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 450	150°C	150°C	150°C	150°C	FCAW	E81T1-N1-H4
GR250	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
GR350	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
Cruesabro	30°C	30°C	30°C	30°C	FCAW	E71T1-H8

Uncontrolled If Printed



Mining Services

## WELDING & PRE-HEAT RECORD SHEET

Client: BMA Peakdowns		Job No: 29044		Date: 17-4-24		Weld Procedure: WMS_WPS-070							
Scope#	0	Description: Weld closing windows				Weld Size & Finish		0					
Job Description: EX5600 Boom & Stick		Drawing No:											
Welder ID	Joint Type/ ID	Weld Procedure No	Recommended Preheat Temp °c	Actual Preheat Temp °c	Date Taken	Time Taken	Volts	Amps	Plant ID	Consumable Used	Consumable Batch No:	Inspected By: Print Name	Inspected By: Initials
CARRO	262	WMS_WPS-070	75°	78°C	17-4-24	5:37 AM	25	185	A	E71T-12M H4 - 1.6mm	2001506017	Bimal	Ba
	u	WMS_WPS-070	75°	81°C		6:19 AM			A	E71T-12M H4 - 1.6mm			
		WMS_WPS-070	75°	84°C		7:23 AM			A	E71T-12M H4 - 1.6mm			
		WMS_WPS-070	75°	87°C		8:31 AM			A	E71T-12M H4 - 1.6mm			
	n	WMS_WPS-070	75°	77°C		9:40 AM			A	E71T-12M H4 - 1.6mm			
	36	WMS_WPS-070	75°	80°C		10:5 AM			A	E71T-12M H4 - 1.6mm			
	u	WMS_WPS-070	75°	83°C		12:05 PM			A	E71T-12M H4 - 1.6mm			
		WMS_WPS-070	75°	79°C		1:39 PM			A	E71T-12M H4 - 1.6mm			
	n	WMS_WPS-070	75°	82°C		2:27 PM			A	E71T-12M H4 - 1.6mm			
		WMS_WPS-070	75°						A	E71T-12M H4 - 1.6mm			
		WMS_WPS-070	75°						A	E71T-12M H4 - 1.6mm			

\* NOTE: Readings to be recorded first when the recommended temperature is reached & once every Hour during Welding.

### PRE-HEAT and CONSUMABLE GUIDE

Material	20mm & Under	20mm - 40mm	40mm - 60mm	60mm <	Process	Consumable
Q & T 80	100°C	100°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 400	150°C	150°C	150°C	200°C	FCAW	E81T1-N1-H4
Q & T 450	150°C	150°C	150°C	150°C	FCAW	E81T1-N1-H4
GR250	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
GR350	75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
Cruesabro	30°C	30°C	30°C	30°C	FCAW	E71T1-H8

Uncontrolled If Printed

*Section 6*

**DELIVERY DOCKET**

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Mining Services Group

CQ WA PNG

40 Production Drive, Paget QLD 4740  
PO BOX 973, Mackay QLD 4740  
Phone: (07) 4952 6557  
ABN: 32 621 415 709

# DELIVERY DOCKET

DOCKET #	2678
P.O. #	2454
JOB #	29044
DATE:	21/05/2024

<b>SENDER Details</b>
CQ Field Mining Services 40 Production Drive, Paget Mackay, QLD 4740 PH: 07 4952 6557

<b>RECEIVER Details</b>
Minespec

ITEM #	DESCRIPTION	QTY
1	Repair 5500 Stick	1
<p><i>INVOICE IN 3 BOND AMOUNTS COMMENCED THIS MONTH.</i></p>		
<b>Other Comments or Special Instructions</b>		

Senders Name: Leon Else

Senders Signature: 

Date: 21/05/2024 21/05/2024

Receivers Name: \_\_\_\_\_

Receivers Signature: \_\_\_\_\_

21/05/2024