

# **REPAIRER'S DATA REPORT**

**JOB NUMBER: 29044** 



Client: Minespec Parts Pty Ltd (Qld)

Description: Hitachi EX5600-6 Stick / Arm MSP-

0005217

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



# **Technical Document Report Index**

			ords /ided
	Section	Yes	No
Certificate of Conformance	1	✓	
QC Check Sheet	2	✓	
NDT Records	3	✓	
Welding Records / Heat sheets	4	✓	
Delivery Docket	5	✓	

Document Name	Document ID	Version	Issue Date	Page
Workshop MDR	F_QA-013	1	10.02.2019	Page 2 of 7



# Section 1

# **CERTIFICATE OF CONFORMANCE**

Document Name	Document ID	Version	Issue Date	Page
Workshop MDR	F_QA-013	1	10.02.2019	Page 3 of 7



# **CERTIFICATE OF CONFORMANCE**

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

Signature:	BhSideste	Date:	13/06/2024
Position:	Workshop Manager	_	

Document Name	Document ID	Version	Issue Date	Page
Certificate of Conformance	F_QA-015	1	28.02.2020	Page 1 of 1



# Section 2

# **QC CHECKLIST**

Document Name	Document ID	Version	Issue Date	Page
Workshop MDR	F_QA-013	1	10.02.2019	Page 4 of 7

		* .			
	Min Gro	ield			
		CLIENT:			
	С	ONTRACTOR:	CQFI		
		PE = Engi PM = Proje			
	Item No.		A		
	1.00	Bucket Repair	s		
	1	Scope Review			
	2	2 Initial N.D.T. Inspection			
	3	Drawing Verification			
١					

# INSPECTION & TEST PLAN

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

_	CLIENT: Minespec		PROJECT LOCATION:	Workshop		Approved by			DIA.
	CONTRACTOR: CQFMS Workshop		CONTRACT/PO#:	The state of the s					
	CHECKED BY:			Control of the Contro	5 5	VA/ITAIE	SSED/VERIFICA	TION BY	
PE = Engineer; SUP = Supervisor; NATA = Testing Authority;		INSPECTION TYPE:	H = Hold Point	R = Review		(Signed and date			
	PM = Project Manager; QA = Quality Manager; QC = Insp		M = Monitor	V = Verify	W = Witness	-		1)	
Item No.	Activity Description	Person Responsible	Reference Documents	Acceptance Criteria	Verifying Record	Sub- contractor	CQFMS Workshop Rep	Client	Comments - Yes Or No
.00	Bucket Repairs								
1	Scope Review	-EST	-SOW Docs	Complies to CQFMS Business     Model - Workshop Manager to     approve	-Signed ITP		Milmo		F <sub>2</sub>
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.	Monitor/Ward		8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8 8
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		Verily	>	
4	Materials receipt, identification, and correlation with certification.	-SUP	Scope Of Work	-Complies to Australian Standards -Complies to Purchase Order	-Material Certification -QC Sheet		26/3/1		8 65
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	v	Verily & Sign		
6	Receipt of Materials	-SUP	-Purchase Order -Delivery Dockets	-Complies to Australian Standards -Complies to Purchase Order - SOW	-Delivery Dockets -QC Sheet		Monitor/Record &		
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		Monitor/Record &		
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	×	Monitor/Record &		
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		Mankor/Record &	K.	
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	Monitor/Record &	At3	
12	Machining - Measure & Record Final Machining Of Bores & Faces	-L/SUP	Drawings	Specified Tolerance	-QC Sheet	Verify & Sign	Monitor/Record		
12	Weighing	-SUP	Suppliers Procedures	-Complies to Australian Standards	-NATA Report	Verify & Sign	Monitor/Record &		
13	Surface Treatment	-SUP	Scope Of Work	Manufacturers Specs & Recommendation	-QC Sheet		17/4/74	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		Monitor/Record &	Review & Sign	Hold Point

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 Name: Sign: CQ FIELD SIGN Sign: CLIENT SIGN OFF Position: W, S. Position: Date:



# Section 4

# **NDT RECORDS**

Document Name	Document ID	Version	Issue Date	Page
Workshop MDR	F_QA-013	1	10.02.2019	Page 6 of 8





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# N.D.T. TEST REPORT

ZT:sk 21MAR24

**REPORT No.:** R24-0947 Page 1 of 16

**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 Continuous Method MAGNETISATION: **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 □ 10° - 14° TEMPERATURE: ■ 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 100% Inspection of Prepared Welds	<ul> <li>Cracking Evident</li> <li>Refer to Figures 1 to 4 &amp; Table 1.0 for Results</li> </ul>

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:** 

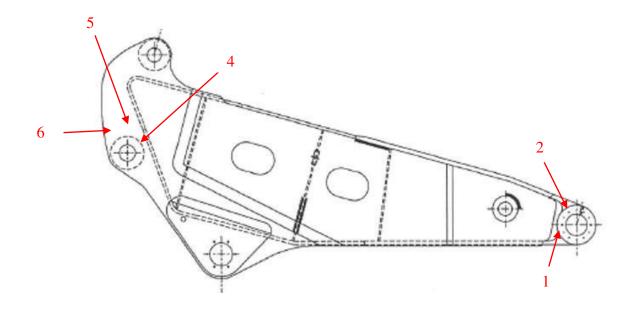
Zackary Tass Jayden Friese Brodie Bell

Z. Tass

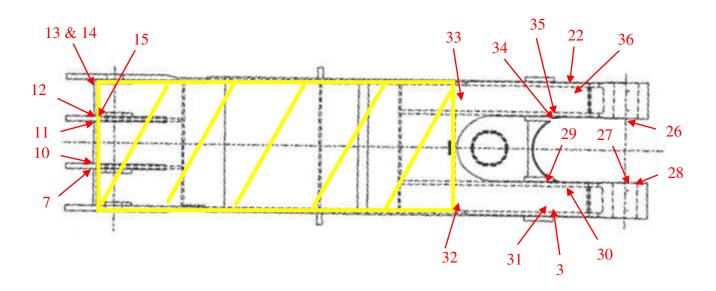
Approved Signatory



# FIGURE 1 – EXTERNAL BODY RIGHT SIDE WALL



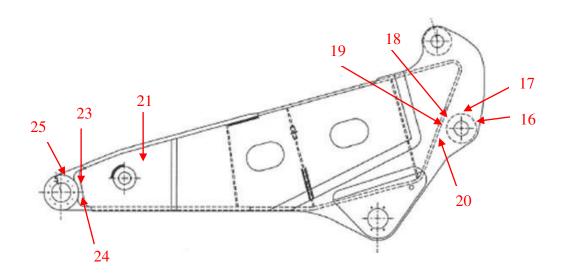
# FIGURE 2 – EXTERNAL BODY TOP



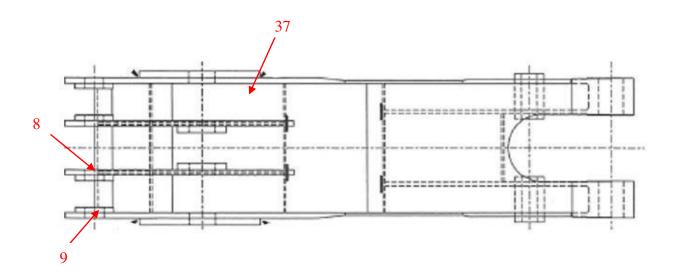
Note: Highlighted Area not Inspected



# FIGURE 3 – EXTERNAL BODY LEFT SIDE WALL



# FIGURE 4 – EXTERNAL BODY UNDERSIDE





# TABLE 1.0 – EXTERNAL BODY DEFECTS:

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



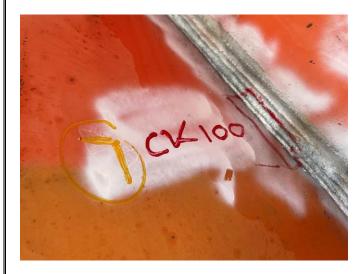
PHOTOGRAPH NO. 5 – EXTERNAL BODY TYPICAL VIEW OF DEFECT #5



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. 15 – EXTERNAL BODY TYPICAL VIEW OF DEFECT #15



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



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



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



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



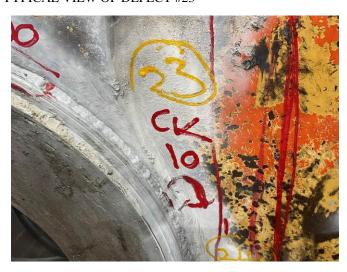
PHOTOGRAPH NO. 21 – EXTERNAL BODY TYPICAL VIEW OF DEFECT #21



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



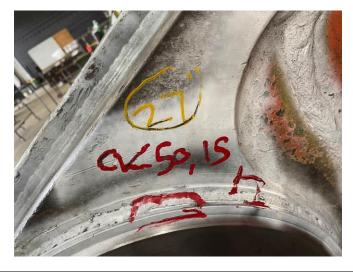
PHOTOGRAPH NO. 25 – EXTERNAL BODY TYPICAL VIEW OF DEFECT #25



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



Report No. R24-0947 dated 21MAR24

Page 13 of 16

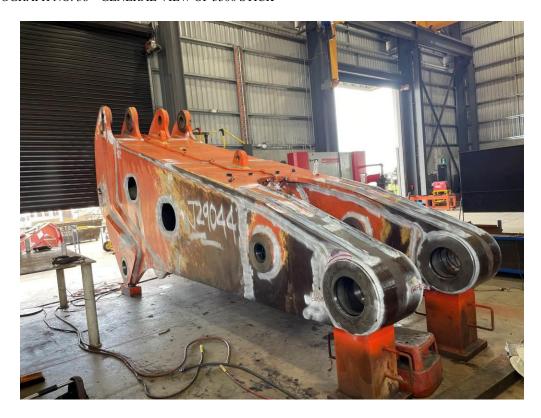
#### PHOTOGRAPH NO. 37 – EXTERNAL STICK TYPICAL VIEW OF DEFECT #37



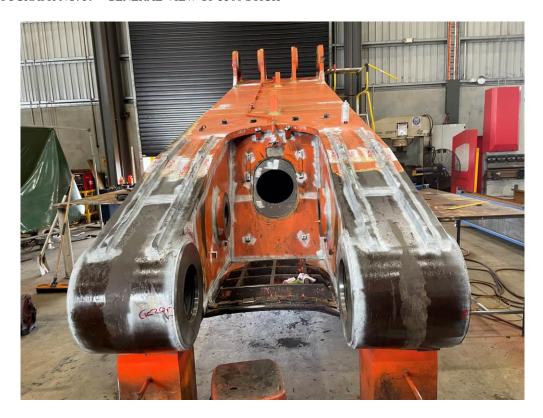
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#### PHOTOGRAPH NO. 38 – GENERAL VIEW OF 5500 STICK



#### PHOTOGRAPH NO. 39 – GENERAL VIEW OF 5500 STICK





#### PHOTOGRAPH NO. 40 – GENERAL VIEW OF 5500 STICK



#### PHOTOGRAPH NO. 41 – GENERAL VIEW OF 5500 STICK

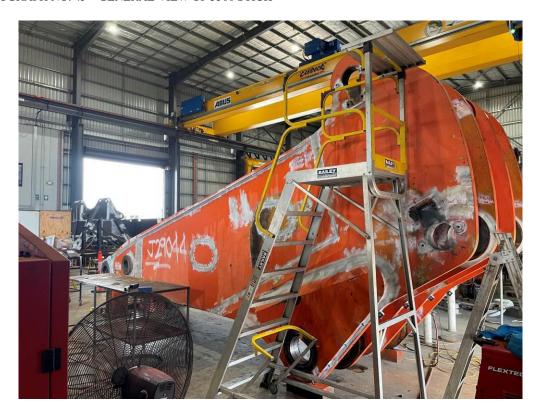




#### PHOTOGRAPH NO. 42 – GENERAL VIEW OF 5500 STICK



#### PHOTOGRAPH NO. 43 – GENERAL VIEW OF 5500 STICK







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# 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

# AXS

<b>INSPECTION DATA:</b>
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·			
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

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

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

Identification	Total No. of Defects	Total Length of Defects	Interpretation
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

<u>Technicians:</u> Joshua Bozier

Brodie Bell

J. Bozier - Technician

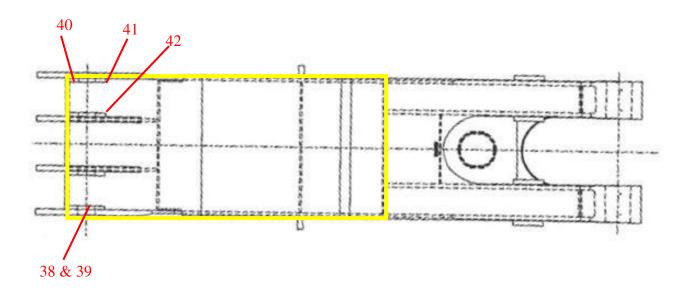
Approved NDT Signatory AS 3998 / ISO 9712 Level 2

MT, UT

(AINDT Registration No.6277)



# 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



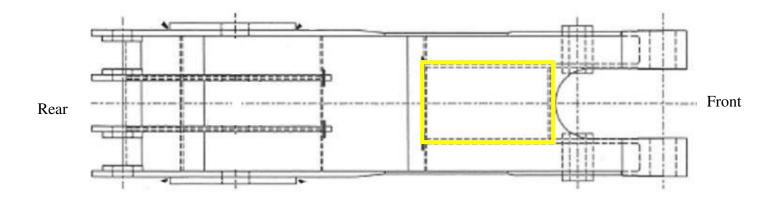
PHOTOGRAPH NO. 5 – EXTERNAL BODY TYPICAL VIEW OF DEFECT #42



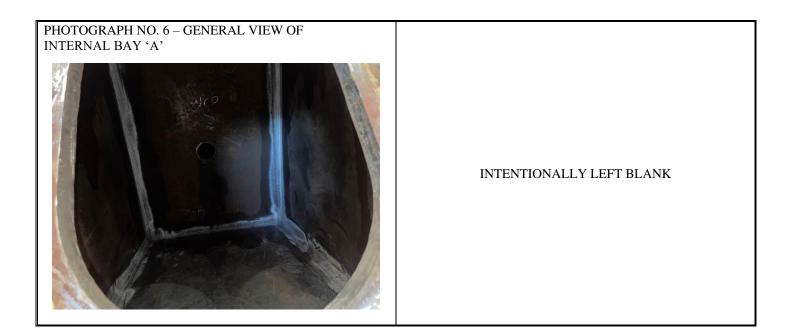
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# FIGURE 2 – INTERNAL BAY 'A'

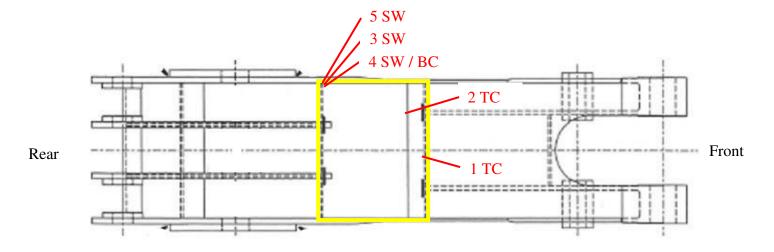


Note: Highlighted Area Inspected





#### 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



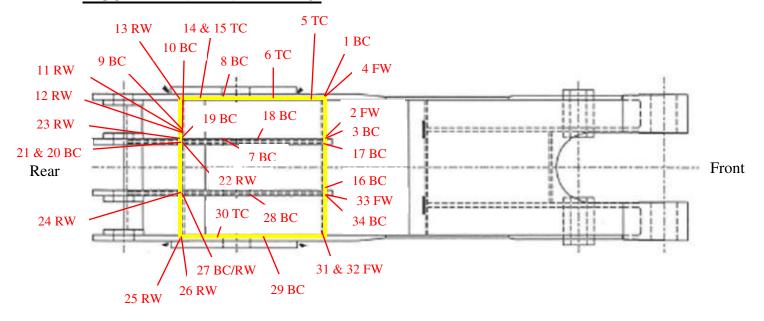
PHOTOGRAPH NO. 11 – INTERNAL BAY 'B' TYPICAL VIEW OF DEFECT #5



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### FIGURE 4 – INTERNAL BAY 'C'



Note: Highlighted Area Inspected

TC = Top Coad

BC = Bottom Cord

SW = Side Wall

FW = Front Wall

RW = Rear Wall



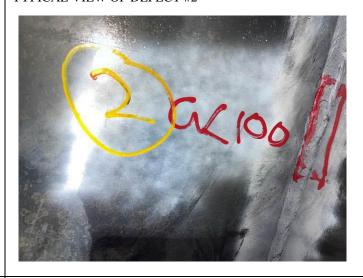
# TABLE 3.0 – INTERNAL BAY 'C' DEFECTS:

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

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



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



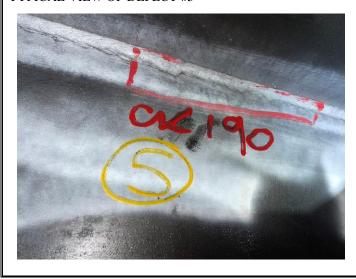
PHOTOGRAPH NO. 14 - INTERNAL BAY 'C' TYPICAL VIEW OF DEFECT #3



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. 27 – INTERNAL BAY 'C' TYPICAL VIEW OF DEFECT #16

PHOTOGRAPH NO. 25 – INTERNAL BAY 'C'

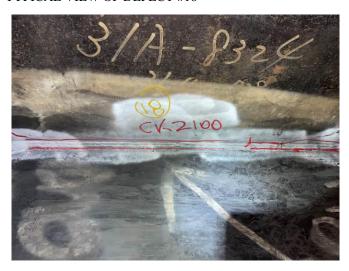
TYPICAL VIEW OF DEFECT #14



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



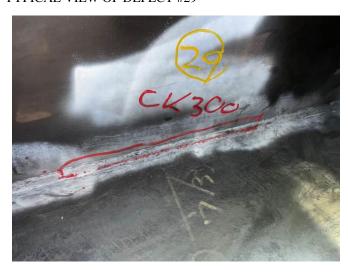
PHOTOGRAPH NO. 38 - INTERNAL BAY 'C' TYPICAL VIEW OF DEFECT #27



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



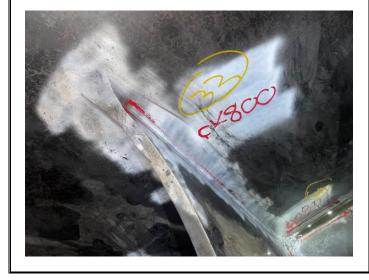
PHOTOGRAPH NO. 42 – INTERNAL BAY 'C' TYPICAL VIEW OF DEFECT #31



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



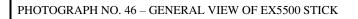
PHOTOGRAPH NO. 44 - INTERNAL BAY 'C' TYPICAL VIEW OF DEFECT #33



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













**MACKAY OFFICE** 

PO Box 6848 Mackay MC, QLD 4741 PHONE: (07) 4952 5500

FAX: (07) 4952 5500

AVIATION • INDUSTRIAL • HYDROSTATIC • MINING - INSPECTIONS AND TESTING SERVICES

A.B.N. 78 062 915 299 A.C.N. 062 915 299

# **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:  $0^{\circ}, 45^{\circ}, 60^{\circ} \& 70^{\circ}$  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: Ardrox, Black Magnetic Ink 800/3, Batch #4980857866

Ardrox, White Contrast Paint 8901W, Batch #4980129572

#### **INSPECTION DATA CONTINUED:**

LIGHTING: 1200 Lux

TEMPERATURE:  $\Box 10^{\circ} - 14^{\circ} = 15^{\circ} - 45^{\circ} = 46^{\circ} - 50^{\circ}$ 

RECORD: Photograph

% COMPLETION: 100%

ACCESS: 100%

MAGNIFICATION: Nil

#### **ULTRASONIC INSPECTION DATA:**

THICKNESS RANGE: 0 - 28mm

RANGE:  $0^{\circ}$  Scan: 0 - 60mm

45°, 60° & 70° Scan: 0 - 250mm

REF. SENSITIVITY:  $UT - 2^{nd}$  BWEFSH / 80% Reference

EVALUATION SENSITIVITY: Level 2

SCAN POSITION: UMB

SURFACE CONDITION: SP1

WELD PROCESS: Not Applicable

SIZING: 6dB / 20dB

TEST ACCURACY:  $\pm .5$ mm

COUPLANT: Kerosene

CURVATURE COMPENSATION: Not Applicable



#### **RESULTS OF EXAMINATION**

## **INSPECTION OF EX5500 STICK:**

## **Final Magnetic Particle Inspection:**

**Worksheet No. 24 - 45789** 

Identification	Result
External Stick Job No. 29044 100% Inspection of Weld Repairs 100% Inspection of (3x) New Man Hole Covers 100% Inspection of New Bash Plate Welds 100% Inspection of Bash Plate Mount Welds	<ul> <li>Nil Cracking / Defects Evident         <ul> <li>Refer to Figures 1 to 4 &amp; Table 1.0</li> </ul> </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 100% Inspection of Weld Repairs	<ul> <li>Nil Cracking / Defects Evident         <ul> <li>Refer to Figures 5 &amp; Table 2.0</li> </ul> </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 100% Inspection of Weld Repairs	<ul> <li>Nil Cracking / Defects Evident         <ul> <li>Refer to Figures 6 &amp; Table 3.0</li> </ul> </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 100% Inspection of (3x) New Man Hole Covers 100% Inspection of New Bash Plate Welds 100% Inspection of Bash Plate Mount Welds	<ul> <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



## **INSPECTION OF EX5500 STICK:**

## **Visual Inspection:**

#### **Worksheet No. 24 – 9385**

Identification	Result
External Stick Job No. 29044 100% Inspection of Weld Repairs 100% Inspection of (3x) New Man Hole Covers	<ul> <li>Nil Defects Evident         <ul> <li>Refer to Figures 1 to 4 &amp; Table 1.0</li> </ul> </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 100% Inspection of Weld Repairs	<ul> <li>Nil Defects Evident         <ul> <li>Refer to Figures 5 Table 2.0</li> </ul> </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 100% Inspection of Weld Repairs	<ul> <li>Nil Defects Evident         <ul> <li>Refer to Figures 6 &amp; Table 3.0</li> </ul> </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 100% Inspection of (3x) New Man Hole Covers	<ul> <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 20% Inspection of (3x) New Man Hole Covers	<ul> <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

Identification	Total No. of Repairs	Interpretation
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

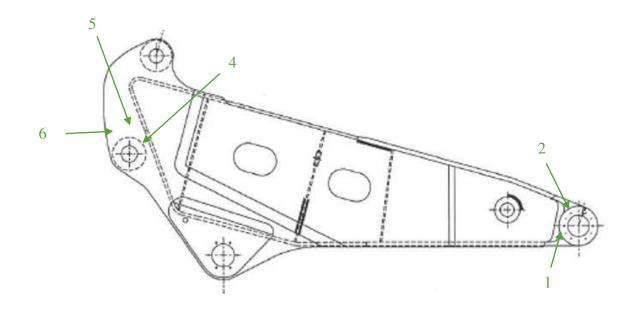
Approved NDT Signatory AS 3998 / ISO 9712 Level 2

MT, UT

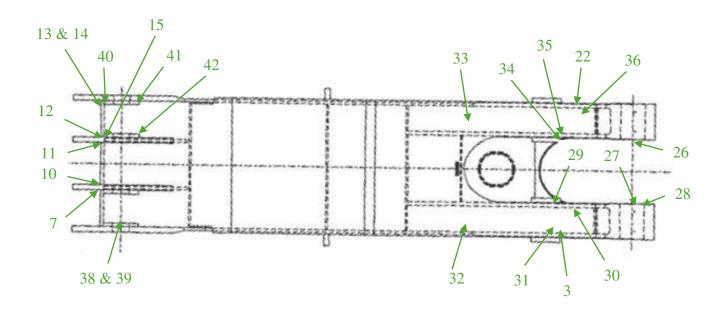
(AINDT Registration No.6277)



## FIGURE 1 – EXTERNAL STICK RIGHT SIDE WALL

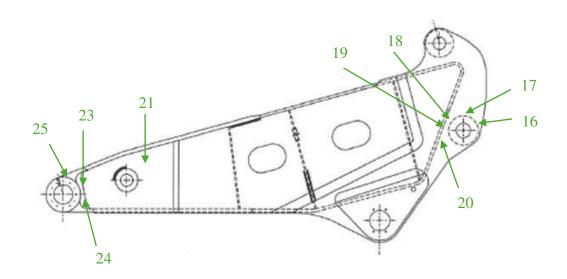


## FIGURE 2 – EXTERNAL STICK TOP

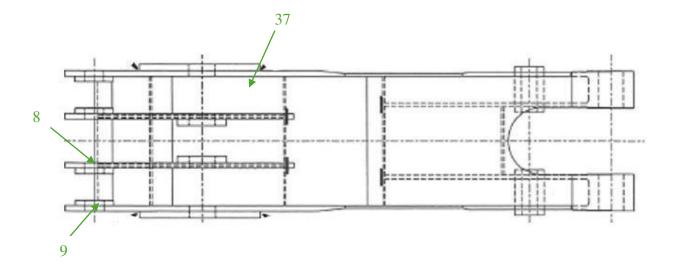




## FIGURE 3 – EXTERNAL STICK LEFT SIDE WALL



#### FIGURE 4 – EXTERNAL STICK UNDERSIDE





## TABLE 1.0 – EXTERNAL STICK REPAIRED DEFECTS:

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

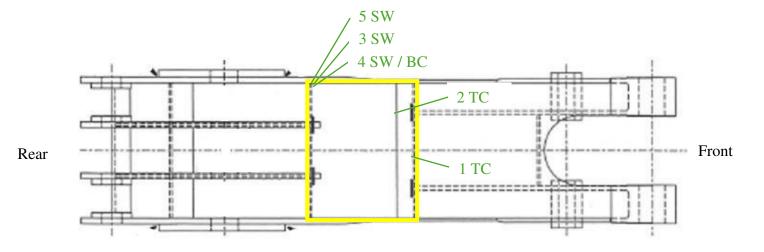


PHOTOGRAPH NO. 42 – EXTERNAL STICK TYPICAL VIEW OF REPAIRED DEFECT #42





#### FIGURE 5 – INTERNAL BAY 'B'



Note: Highlighted Area Inspected

TC = Top Coad

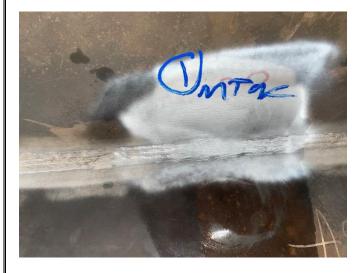
BC = Bottom Cord

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



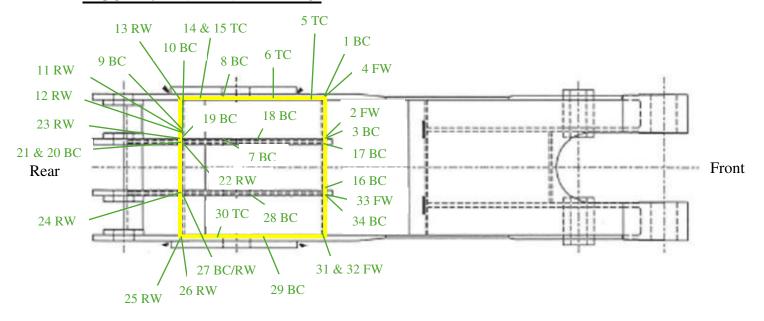
PHOTOGRAPH NO. 47 – INTERNAL BAY 'B' TYPICAL VIEW OF REPAIRED DEFECT #5



INTENTIONALLY LEFT BLANK



#### FIGURE 6 – INTERNAL BAY 'C'



Note: Highlighted Area Inspected

TC = Top Coad

BC = Bottom Cord

SW = Side Wall

FW = Front Wall

RW = Rear Wall



## TABLE 3.0 – INTERNAL BAY 'C' REPAIRED DEFECTS:

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

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



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



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



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



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



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. 56 - INTERNAL BAY 'C' TYPICAL VIEW OF REPAIRED DEFECT #9



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



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



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



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





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



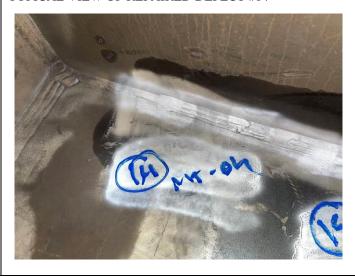
PHOTOGRAPH NO. 62 - INTERNAL BAY 'C'



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



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



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



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



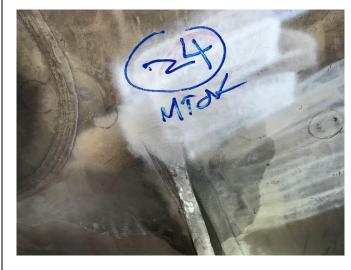
PHOTOGRAPH NO. 69 – INTERNAL BAY 'C' TYPICAL VIEW OF REPAIRED DEFECT #22



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. 74 - INTERNAL BAY 'C' TYPICAL VIEW OF REPAIRED DEFECT #27



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



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



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



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. 80 - INTERNAL BAY 'C' TYPICAL VIEW OF REPAIRED DEFECT #33



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



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

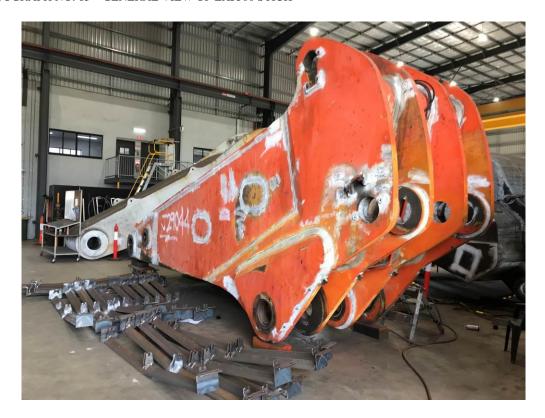




#### PHOTOGRAPH NO. 82 – GENERAL VIEW OF EX5500 STICK



#### PHOTOGRAPH NO. 83 – GENERAL VIEW OF EX5500 STICK









PHOTOGRAPH NO. 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

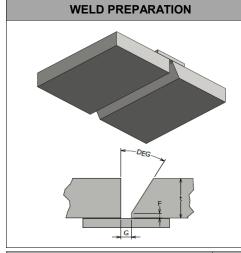
# WELDING PROCEDURE SPECIFICATION

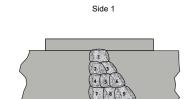


WELDING PRO	OCEDURE SPECIFICATION NUMBER	WMS_WPS-032				
Code / Standard:	AS/NZS 1554.1 SP	Edge Preparation:	Flame Cut & Grind or Machined			
Process:	FCAW	Power Source:	DC Constant Voltage Transformer or Inverter			
Joint Type:	Single Bevel Butt With Backing (BW,ss,mb)	Technique:	Stringer			
Joint Position: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

WELDING CONSUMABLE DETAIL								
Co	Shield Gas/Flux							
Classification/Grade:	B T 49 3 T12 1 C A U H10	Classification/Grade:	NA	Shield Gas:	Argoshield 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					

SEQUENCE/POSITION





Side 2

Number of weld passes are indicative to nominated weld procedure and may vary

MATERIAL SPECIFICATION           TYPE/GRADE         GROUP T Diameter           1         AS 1554 mm 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				
_	VDE/CDADE	GROUP	Т	Diameter
'	TPE/GRADE	AS 1554	mm	mm
1		5	12	N/A
2		5	12	N/A
RAN	IGE QUALIFIED	AS 155	54.1: 6mm to	25mm

THERMAL TREATMENT

PREHEAT:

MAX INTERPASS:

175°C

50°C

P.W.H.T.: NIL

	WEL	D PASS DET	TAILS ELECTRODE DESCRIPTION PREHEAT					WELDING PARAMETERS																																						
						ELECTRODE			AN	MPS	VO	LTS		TRAVEL SPE	EED (mm/min)	HEAT INPL	JT (KJ/mm)																													
PROCESS	PASS NO.	SIDE NO.	POS	DIR	TYPE	SIZE	SPEC	TEMP	Min	Max	Min	Max	POL	Min	Max	Min	Max																													
						mm		°C	Actual -10%	Actual +10%	Actual -7%	Actual +7%		Actual -15%	Actual +15%	Actual -10%	Actual +10%																													
FCAW	1	1	3G	Up	136	1.6mm	Verti-Cor 3XP E71T-1	50°C	214.2	261.8	22.5	25.9	DC+	332.4	449.7	0.8	1.0																													
Root		•	30	σp		1.0	H8	55 5	Actual	238	Actual 24.2		30	Actual	Actual 391		Actual 0.88																													
FCAW	2 - 3	1	3G	Up	136	1.6mm	Verti-Cor 3XP E71T-1	50°C	199.8	244.2	22.5	25.9	DC+	303.0	410.0	0.8	1.0																													
Hot Pass	2-3	,	36	Ορ	730	1.011111	H8			222	Actual 24.2		DC+	Actual 356.5		Actual 0.91																														
FCAW	4-6	1	3G	Up	136	1.6mm	Verti-Cor 3XP E71T-1	50°C	205.7	251.46	22.5	25.9	DC+	279.7	378.4	0.9	1.1																													
Fill	4-0	,	36	Ορ	730	1.011111	H8	30 0	Actual	Actual 228.6		Actual 228.6 Actual 24.2		-		Actual 329		Actual 1.01																												
FCAW	7 - 9	1	3G	Up	136	1.6mm	Verti-Cor 3XP E71T-1	50°C	192.9	235.73	22.5	25.9	DC+	261.0	353.1	0.9	1.2																													
Сар		,	36	Ορ	730	1.011111	H8	30 0	Actual	Actual 214.3		Actual 214.3		Actual 214.3		Actual 214.3		Actual 214.3		Actual 214.3 Ac		Actual 214.3 Actual 24.2		Actual 214.3		DC+	Actual	307	Actual	1.05																
										•							•																													

TESTII	NG REQUIRED & RESULTS	NOTES								
Refer to su	pporting PQR for the following testing reports:  IS4R-RPT-0087	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.		PREHEAT & TERPASS TE Gr. 350						
Mechanical:	IS4R-RPT-0085	Interpass temperature is limited due to CVN impact requirements and temper preservation for this material.  General  - Ensure joints are free from contaminants.	THICKNESS ≥26<50	PREHEAT	INTERPASS					
NDT:	M21-1118	,	≥50<100	75°C	200°C					
Chemical:	BE00027892/MC/PK/XII/19									
		I patitus of	≥100	140°C	220°C					

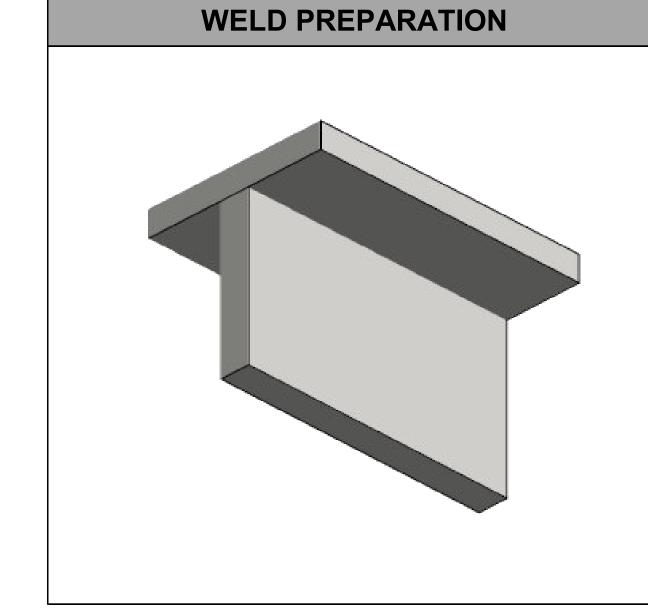
Complied By:	Clancy Crerar -iScope-	Reviewed By:	Craig Evans -iScope-	CIWS	TEE	Reviewed By:		
Signed:		Signed:		Craig Evan CIWS/AU/600 Expiry date: 07/04/	2/2 *	Signed:		
	AU/IWI B/0895	WTIA AU/IWS/	6082 / WTIA SS-2054 /	AU/IWI B/00746	1			
iscome cartify that the statements in this record are correct and that the test welds were prepared, welded, and tested in accordance with the requirements of the standard and category specifications								

# WELDING PROCEDURE SPECIFICATION

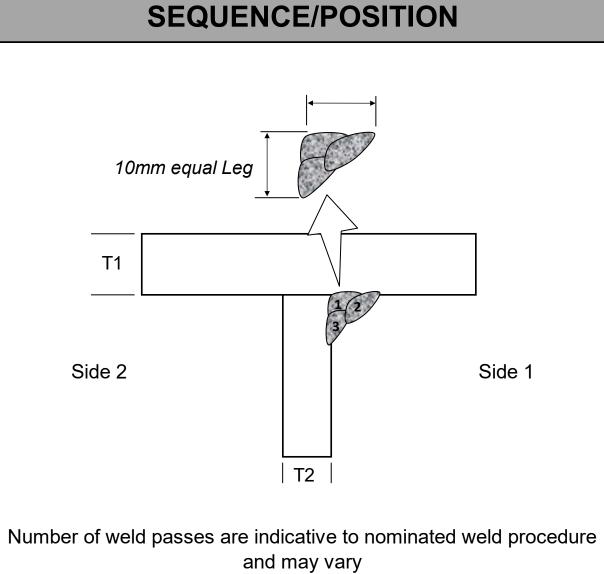


WELDING PRO	OCEDURE SPECIFICATION NUMBER	WMS_WPS-064			
Code / Standard:	AS/NZS 1554.5	Edge Preparation:	Flame Cut & Grind or Machined		
Process:	FCAW	Power Source:	DC Constant Voltage Transformer or Inverter		
Joint Type:	F1 Fillet	Technique:	Stringer		
Joint Position:	4F (PE)	Multi-run or Single:	Multi		
Positions Qualified:	1F (PA), 2F (PC) & 4F (PD & PE)	Torch Angle:	5° Drag		
PQR Number:	R-WPQR-FCAW4	Inter Pass Cleaning:	Grind & Brush		
Revision:	0	Root Opening:	0mm		
Date Issued:	19/07/22	Root Face:	0mm		
Welder:	Bradley Jenkins	Grove Angle:	90° Included (AS1554 +10° to -5°)		
Location:	Mackay Facility	Backing:	Nil		

WELDING CONSUMABLE DETAIL										
Con	Consumable No 1 Consumable No 2 Shield Gas/Flux									
Classification/Grade:	B T 49 3 T12 1 M A N2 U H5	Classification/Grade:	NA	Shield Gas:	Argoshield 52 - Ar+25% CO					
Diameter:	1.6mm	Diameter:	NA	Flow Rate:	20L/M +≥25%/-≥10%					
Trade Name:	Verti-Cor 3XP E71T-12M H4	Trade Name:	NA	Purge Rate:	N/A					
Batch #:	7486	Batch #:	NA	Flux:	N/A					
Stickout:	15-20mm	Stickout:	NA							



**TESTING REQUIRED & RESULTS** 



MATERIAL SPECIFICATION										
_	YPE/GRADE	GROUP	Т	Diameter						
•	TPE/GRADE	AS 1554	mm	mm						
1	AS/NZS 3678 Gr. 350	5	12	N/A						
2	AS/NZS 3678 Gr. 350	5	12	N/A						
RAN	IGE QUALIFIED	AS 1554	4: 3mm to U	Inlimited						

# THERMAL TREATMENT

PREHEAT:

NOTES

50°C

MAX INTERPASS:

150°C

P.W.H.T.: NIL

WELD PASS DETAILS					ELECTRODE DESCRIPTION			PREHEAT	WELDING PARAMETERS								
						ELECTRODE			AM	1PS	VO	LTS		TRAVEL SPE	ED (mm/min)	HEAT INPL	JT (KJ/mm)
PROCESS	PASS NO.	SIDE NO.	POS	DIR	TYPE	SIZE	SPEC	TEMP	Min	Max	Min	Max	POL	Min	Max	Min	Max
						mm		°C	Actual -10%	Actual +10%	Actual -7%	Actual +7%		Actual -15%	Actual +15%	Actual -10%	Actual +10%
FCAW	1	1	4F	Drag	136	1.6mm	Verti-Cor 3XP E71T-	50°C	243.0	297.0	23.9	27.5	DC+	212.5	287.5	1.5	1.8
Root	,	,	,,	Drug	700	7.0/////	12M H4	00 0	Actual	270	Actual	25.7		Actual	250	Actual	1.67
FCAW	2 - 3	1	4F	Drag	136	1.6mm	Verti-Cor 3XP E71T-	50°C	204.8	250.25	21.4	24.6	DC+	237.6	321.4	1.0	1.2
Сар	2 - 3	,	71	Drag	750	7.011111	12M H4	30 0	Actual	227.5	Actual	23	DC 1	Actual	279.5	Actual	1.13

Mechanical: M-20-0795-03  General  - Ensure joints are free from contaminants	THICKNESS	Gr. 350 PREHEAT	INTERPASS
Mechanical: M-20-0795-03  General  - Ensure joints are free from contaminants	THICKNESS	PREHEAT	INTERPASS
- Ensure joints are free from contaminants			
NDT: NA - Material, consumable & joint type are prequalified as per AS 1554.5	≥26<50	50°C	175°C
Chemical: BE00028082/MC/PK/XII/19 - WPS may be used on nominated CAT & Liebherr Castings as per Spectro & Hardness reports M22-1185-02 & M22-1185-03.	≥50<100	75°C	200°C
To Anstitute	≥100	140°C	220°C

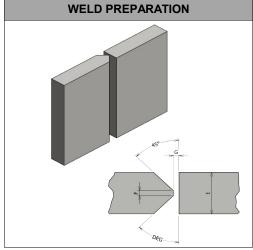
Complied By:	Clancy Crerar -iScope4Repair-	Reviewed By:	Craig Evans -iScope4Rer CIWS	Reviewed By:	
Signed:		Signed:	Craig Evans CIWS/AU/6082/2 Expiry date: 07/04/2023	Signed:	
AU	I/IWI B/0895 / CC184154-02	WTIA AU/IWS	/6082 / WTIA SS-2054 / AU/IWI B/00746		

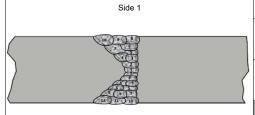
# Field Mining Services Group

EL	DING	PROCEDURE S	PECIFICA	TION
	WELDING	PROCEDURE SPECIFICATION NUMBER	V	VMS_WPS-070
Co	ode / Standard:	AS/NZS 1554.5:2014	Edge Preparation:	Flame Cut & Grind or Machined
Pro	ocess:	FCAW	Power Source:	DC Constant Voltage Transformer or Inverter
Joi	int Type:	Double Bevel Butt	Technique:	Stringer
Joi	int Position:	3G (PF)	Torch Angle:	5° Push
Po	sitions Qualified:	3G (PF)	Inter Pass Cleaning:	Grind & Brush
Mu	ılti-run or Single:	Multi	Root Opening:	0mm to 3mm
PQ	QR Number:	IS4R-WPQR-118	Root Face:	0mm to 2.5mm
Re	evision:	0	Grove Angle:	40° to 55° Included
Da	te Issued:	21/06/2023	Backing:	Nil

		WELDING CON	ISUMABLE 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		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				

SEQUENCE/POSITION





Side 2

Number of weld passes are indicative to nominated weld procedure and may vary

TYPE/GRADE AS 1554 Steel Type: 1, 2, 4, 5 Weldability Group: AS3678 40 NA Gr350 ≤6 Steel Type: 1, 2, 4, 5 Weldability Group: AS3678 NA Gr350 **RANGE QUALIFIED** 

**MATERIAL SPECIFICATION** 

GROUP

Diameter

Thickness: 20mm to Unlimited

TUEDMAI TOEATMENT

ITERWALI	REALIVIENT
PREHEAT:	Refer to Table in Notes
MAX INTERPASS:	220°C

	WFI	D PASS DET	All S		FLECTI	RODE DESC	RIPTION	PREHEAT				WELD	ING PARAN	IFTERS			
	1122		720			ELECTRODE		FREHEAT	ΔΛ	MPS	VO	LTS			EED (mm/min)	HEAT IND	UT (KJ/mm)
PROCESS	PASS NO.	SIDE NO.	POS	DIR	TYPE	SIZE	SPEC	TEMP	Min	Max	Min	Max	POL	Min	Max	HEATING	T (KJ/IIIII)
FROCESS	FASSING.	SIDE NO.	103	DIIX	11172	mm	SFEC	°C		Actual +10%	Actual -7%	Actual +7%	FOL	Actual -15%	Actual +15%	Min	Max
FCAW	1	1	3G (PF)	Up	136	1.6mm	A5.20 E71T-	75°C	228	278	23.4	27.0	DC+	173	233	1.37	2.61
Root	,	,	30 (F1)	Ор	130	7.0/////	12M H4	75 0	Actual	253	Actual	25.2	DC+	Actual	203	Actual	1.99
FCAW	2	1	3G (PF)	Up	136	1.6mm	A5.20 E71T-	75°C	221	270	23.4	27.0	DC+	277	374	0.83	1.58
Hot Pass	2	,	30 (F1)	Ор	130	7.0/////	12M H4	75 0	Actual	245	Actual	25.2	DC+	Actual	325	Actual	1.20
FCAW	3 - 10	1	3G (PF)	Up	136	1.6mm	A5.20 E71T-	75°C	229	280	23.0	26.4	DC+	235	318	0.99	1.89
Fill & Cap	3 - 10	,	30 (F1)	Ор	130	7.0/////	12M H4	75 0	Actual	254	Actual	24.7	DC+	Actual	276	Actual	1.44
FCAW	1	2	3G (PF)	Up	136	1.6mm	A5.20 E71T-	75°C	236	288	22.9	26.3	DC+	184	248	1.30	2.48
Root	,	2	30 (11)	Oρ	750	7.01111	12M H4	700	Actual	262	Actual	24.6		Actual	216	Actual	1.89
FCAW	2	2	3G (PF)	Up	136	1.6mm	A5.20 E71T-	75°C	231	283	22.9	26.3	DC+	249	338	0.94	1.79
Hot Pass	2	2	55 (F1)	Эр	750	7.5/////	12M H4	,,,,	Actual	257	Actual	24.6	DOF	Actual	294	Actual	1.37
FCAW	3 - 12	2	3G (PF)	Up	136	1.6mm	A5.20 E71T-	75°C	223	273	22.9	26.3	DC+	222	300	1.02	1.94
Fill & Cap	3-12	2	3G (FF)	Ор	730	7.011111	12M H4	73 C	Actual	248	Actual	24.6	DC+	Actual	261	Actual	1.48

#### **NOTES**

- 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
- Interpass temperature is limited due to CVN impact requirements and temper preservation for this material.

- Ensure joints are free from contaminants.
  Grind all layers to clean material eliminating all surface indications.

	TERPASS TEN Gr350	
CJT	PREHEAT	INTERPASS
<50	50°C	180°C
≥50<100	75°C	220°C
≥100	140°C	220°C

Complied By: Clancy Crerar -iScop	e- Reviewed By:	Craig Evans -iScope-	Reviewed By:	
Signed:	Signed:	Crius Craig Evans  * CRUS/AU/6082/2 *  \$ Lepiny onto: 07/04/2023 f	Signed:	
AU/IWI B/0895 / CC1841	54-02 WTIA AU/IWS	6/6082 / WTIA SS-2054 / AU/IWI STATES		

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 & PRE-HEAT RECORD SHEET**

Client:	Mine spec			Job No:	29044		Date:	29/2/20	24	Weld Procedure:		WMS_WPS-064	
Scope#	0	Description:		Crack Repair	s - Fillet Weld		Weld Size & Finish	/ / /		Fill & Blend Cracked Areas To	Match Existing Conto	ur	
Job Descript	ion:	EX 5600 Stick					(2)	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
63/2	16	WMS_WPS-064	50°	520	28/3/24	b-woan	23.2 V	160 A		E71T-12M H4 - 1.6mm	20138193	- 77	
2352	W	WMS_WPS-064	50°	Sic	/ - /	72 WO OWN	222 V	160 A		E71T-12M H4 - 1.6mm			
0352		WMS_WPS-064	50°	540		Simour	27.2 V	160 A		E71T-12M H4 - 1.6mm			
6352	G	WMS_WPS-064	50°	53°C		9:00 OM	232 V	160 A	K	E71T-12M H4 - 1.6mm			
06512	4	WMS_WPS-064	50°	555		ivivocun	222 V	160 A	ï	E71T-12M H4 - 1.6mm	zwoll0883	Dina	100
20352	и	WMS_WPS-064	50°	T2°C		(1200 CM)	25.2 V	160 A		E71T-12M H4 - 1.6mm		7-1	1
2021-2	26	WMS_WPS-064	50°	57C		12:PM	25.2 V	160 A		E71T-12M H4 - 1.6mm	200 1508093	Bouro	/
	И	WMS_WPS-064	50°	1-52		1:00 /m	72-2 V	160 A		E71T-12M H4 - 1.6mm	200150887	)	
CO3(2	4	WMS_WPS-064	50°	54		2: 10PM		160 A		E71T-12M H4 - 1.6mm	2 vol 50889	>	
		WMS_WPS-064	50°				V	A		E71T-12M H4 - 1.6mm	1		
		WMS_WPS-064	50°		-		٧	A		E71T-12M H4 - 1.6mm	-		-

<sup>\*</sup> NOTE: Readings to be recorded first when the recommended temperature is reached & once every Hour during Welding,

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 Repair	rs - Fillet Weld	1	Weld Size & Finish	- a	F	ill & Blend Cracked Areas To N	Natch Existing Cont	our	
Job Descript	tion:	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	Fillel	WMS_WPS-064	50°	520	8-4-24	6:11 RM	25 V	190 A		E71T-12M H4 - 1.6mm			
	1 ( 000)	WMS_WPS-064	50°	5500	1	7:24 M	) V	, A		E71T-12M H4 - 1.6mm	0		
	UF	WMS_WPS-064	50°	68°2		8:36 KM	v	A		E71T-12M H4 - 1.6mm	9		
	11	WMS_WPS-064	50°	548		9:41 AM	V	A		E71T-12M H4 - 1.6mm	7	0	
		WMS_WPS-064	50°	592		10158 A	g v	А		E71T-12M H4 - 1.6mm	53	D	12
	(1	WMS_WPS-064	50°	600		12:02 19	7 \	A		E71T-12M H4 - 1.6mm	8	Dresto	1//
	25	WMS_WPS-064	50°	530		1:87 1		- A		E71T-12M H4 - 1.6mm	0	San	1
	Ŋ	WMS_WPS-064	50°	572		2:15 pl	e l v	V A		E71T-12M H4 - 1.6mm	-0		
		WMS_WPS-064	50°			1 1/19	V	A		E71T-12M H4 - 1.6mm	(n)		
	Ŋ	WMS_WPS-064	50°				V	А		E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°		5		V	А		E71T-12M H4 - 1.6mm			

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

# CQ Field Mining Services

## **WELDING & PRE-HEAT RECORD SHEET**

Client:	Mine spec			Job No:	29044		Date:	8/4/	24	Weld Procedure:		WMS_WPS-064	
cope#	0	Description:		Crack Repai	rs - Fillet Weld		. Weld Size & Finish	/ //	/	ill & Blend Cracked Areas To N	Match Existing Con	tour	
lob Descript	ion:	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	201	WMS_WPS-064	50°	85	8/4/24	8:00	24 V	100 F	\ \	E71T-12M H4 - 1.6mm	3XR		
350	20	WMS_WPS-064	50°	86		9:00	24 V	190	<b>A</b>	E71T-12M H4 - 1.6mm			
350	401	WMS_WPS-064	50°	87		10:00	24 V	100	A	E71T-12M H4 - 1.6mm		$\wedge$	
350	401	WMS_WPS-064	50°	89		11:00	24 V	190 1	1	E71T-12M H4 - 1.6mm			0.
550	301	WMS_WPS-064	50°	90		12:00	24 V	190 1	\ \	E71T-12M H4 - 1.6mm		Bimal	13/
350	307	WMS_WPS-064	50°	91	111	01:00	24 V	190 1	Α .	E71T-12M H4 - 1.6mm		Food	//
350	39	WMS_WPS-064	50°	92	4	02:00	24 V	190 1	4	E71T-12M H4 - 1.6mm	3XP	2	
- ) -		WMS_WPS-064	50°			1	V	P	1	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°				V	μ μ	4	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°				V	P	1	E71T-12M H4 - 1.6mm	Newson and the second		
		WMS_WPS-064	50°	Tê.	20 1 3	/	V	Α.	A	E71T-12M H4 - 1.6mm		. 30	•

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	(A)		

Field
Mining Services

# WELDING & PRE-HEAT RECORD SHEET

Client:	Mine spec			Job No:	29044		Date:			Weld Procedure:		WMS WPS-064	
Scope#	1.02	Description:		Crack Repair	s - Fillet Weld	15.15	Weld Size & Finish		F	ill & Blend Cracked Areas To N	Natch Existing Cont		
Job Descripti	on:	EX 5600 Stick	(			A Value	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°	572	9-4-24	5186 K	3 25 V	190 A		E71T-12M H4 - 1.6mm			
	15	WMS_WPS-064	50°	549	h	6:24 K	4 V	į A	T.	E71T-12M H4 - 1.6mm	5		
		WMS_WPS-064	50°	572		9137A	24 V	A		E71T-12M H4 - 1.6mm	9		
	4	WMS_WPS-064	50°	549		8:41 A	3 V	A		E71T-12M H4 - 1.6mm	3	^	
*		WMS_WPS-064	50°	680		9:39 K	<b>*</b>	A		E71T-12M H4 - 1.6mm	8		20
	24	WMS_WPS-064	50°	6200		10:40 A	24 V	А		E71T-12M H4 - 1.6mm	4	Bird	2/
		WMS_WPS-064	50°	642		11:80	N V	А		E71T-12M H4 - 1.6mm	0	2	110
	ч	WMS_WPS-064	50°	572		1234 8	V	А		E71T-12M H4 - 1.6mm	W	Dan	
		WMS_WPS-064	50°	079	,	28 29 10	n v	L A	9 4	E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°			1.00	V	А		E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°				V	А		E71T-12M H4 - 1.6mm			

			and controlling	COIDE		
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		, 5/100	2/111-118

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## **WELDING & PRE-HEAT RECORD SHEET**

lient:	Mine spec			Job No:	29044		Date:			Weld Procedure:		WMS_WPS-064		
Scope#	1.02	Description:		Crack Repair	rs - Fillet Weld		Weld Size & Finish					Match Existing Contour		
ob Descripti	ion:	EX 5600 Stick	(			117	1	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	
CANDO	16	WMS_WPS-064	50°	5390	10-4-96	5:31 10	n 25 V	190 A		E71T-12M H4 - 1.6mm				
		WMS_WPS-064	50°	56%	1	6:24 pt	2 ) V	) A		E71T-12M H4 - 1.6mm	2			
	h	WMS_WPS-064	50°	602		7:33/	73 V	А		E71T-12M H4 - 1.6mm	00			
	90	WMS_WPS-064	50°	640		8740x	y V	A		E71T-12M H4 - 1.6mm	-			
iver in the second		WMS_WPS-064	50°	549		9:37 R	•• V	) A		E71T-12M H4 - 1.6mm	53			
		WMS_WPS-064	50°	58 €		200 424	n v	А		E71T-12M H4 - 1.6mm	<b>8</b>	Bush	Br	
	26	WMS_WPS-064	50°	622		11:50	V	А	,	E71T-12M H4 - 1.6mm	Ô	Bank	10.	
		WMS_WPS-064	50°	55°C		1,39 8	<i>R</i> ∨	A		E71T-12M H4 - 1.6mm	9	5000		
	4	WMS_WPS-064	50°	592	l	2022	ge l v	l A		E71T-12M H4 - 1.6mm	S			
		WMS_WPS-064	50°		ă.		V	А		E71T-12M H4 - 1.6mm				
		WMS_WPS-064	50°				V	А		E71T-12M H4 - 1.6mm				

100°C 150°C	100°C 150°C	150°C	200°C	FCAW FCAW	E81T1-N1-H4
	150°C	150°C	200°C	ECAW	F04T4 N4 114
			200 C	rcavv	E81T1-N1-H4
150°C	150°C	150°C	150°C	FCAW	E81T1-N1-H4
75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
75°C	75°C	75°C	108°C	FCAW/GMAW	E71T1-H8
30°C	30°C	30°C	30°C	FCAW	E71T1-H8
_	75°C 75°C	75°C 75°C 75°C	75°C 75°C 75°C 75°C 75°C	75°C     75°C     75°C     108°C       75°C     75°C     75°C     108°C       30°C     30°C     30°C     30°C	75°C         75°C         75°C         108°C         FCAW/GMAW           75°C         75°C         75°C         108°C         FCAW/GMAW           30°C         30°C         30°C         50°C         FCAW

<b>Field</b>
Mining Services

## **WELDING & PRE-HEAT RECORD SHEET**

Client:	Mine spec			Job No:	29044	1	Date:			Weld Procedure:		WMS_WPS-064	
Scope#	1.02	Description:		Crack Repai	rs - Fillet Weld		Weld Size & Finish		F	Fill & Blend Cracked Areas To N	Natch Existing Con	tour	
Job Descripti	on:	EX 5600 Stick	(	i i				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
CANDO	16	WMS_WPS-064	50°		11-4-24	5:18 AM	25 V	190 A		E71T-12M H4 - 1.6mm			
	V	WMS_WPS-064	50°			6:22 x1	v v	A		E71T-12M H4 - 1.6mm	2		
		WMS_WPS-064	50°			753CA	9 4	А	70	E71T-12M H4 - 1.6mm	8		
		WMS_WPS-064	50°			874110		А		E71T-12M H4 - 1.6mm			
	И	WMS_WPS-064	50°			9:401	<b>7</b> V	А		E71T-12M H4 - 1.6mm	8	D	n
		WMS_WPS-064	50°			10:4570	7 v	А		E71T-12M H4 - 1.6mm	8	that a	300
	267	WMS_WPS-064	50°			11:62K	7 v	А		E71T-12M H4 - 1.6mm	Ö	Bon!	,
W/r	9	WMS_WPS-064	50°			1037pm	V	А		E71T-12M H4 - 1.6mm	W W	P	
	٩	WMS_WPS-064	50°	*	9	2126 PM	v	А		E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°		×		V	. A		E71T-12M H4 - 1.6mm			
		WMS_WPS-064	50°			t.	v	А		E71T-12M H4 - 1.6mm			×

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	

### **WELDING & PRE-HEAT RECORD SHEET**

Client:	Mine spec			Job No:	29044		Date:			Weld Procedure:	i	WMS_WPS-064	
Scope#	1.02	Description:		Crack Repai	rs - Fillet Weld	le le	Weld Size & Finish		Fill & Blend Cracked Areas To Match Existing Contour				
Job Description	on:	EX 5600 Stick	C					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°	520	12-4-24	6:18 A	28 V	190 A	4,	E71T-12M H4 - 1.6mm	2		
3	u	WMS_WPS-064	50°	572		7:24 A	0 1 V	1 A		E71T-12M H4 - 1.6mm	0		
7.4.		WMS_WPS-064	50°	5800		8336		А	-	E71T-12M H4 - 1.6mm	0		
	h	WMS_WPS-064	50°	537		9:4/1	7 v	А		E71T-12M H4 - 1.6mm	5		
		WMS_WPS-064	50°	57,0		11:02 /1	5 V	А		E71T-12M H4 - 1.6mm	0		
	261	WMS_WPS-064	50°	61 0	3	17:154	<b>7</b> V	A		E71T-12M H4 - 1.6mm	33	Bimal	BA
	11	WMS_WPS-064	50°	850		1:35 7	1 1	A	). 	E71T-12M H4 - 1.6mm	$\circ$	1	0.
		WMS_WPS-064	50°	590		2:230	2   v	A		E71T-12M H4 - 1.6mm	W.	Boul	
	4	WMS_WPS-064	50°	-			V	Α Α		E71T-12M H4 - 1.6mm	1.6		
1/2		WMS_WPS-064	50°				v	А		E71T-12M H4 - 1.6mm		*	
		WMS_WPS-064	50°				V	А		E71T-12M H4 - 1.6mm			

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

# CQ Field Mining Services

## **WELDING & PRE-HEAT RECORD SHEET**

Client:	Minespec			Job No:	29044		Date:	10-4.	26	Weld Procedure:		WMS WPS-032	
Scope#	0	Description:	Cra	ck Repairs - Full per	netration Joints	- 1	Weld Size & Finish		Fill & Blend Cracked Areas To Match Existing Contour				
Job Descripti	on:	EX 5600 Stick						Drawing No	o:				
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
CO287	16	WMS_WPS-032	50°	60	600	10-4-24	24.5 V	196	A W5305	E71T1-1 H8 - 1.6mm			
p .	161	WMS_WPS-032	50°	63	100	10-6	24.5 V		A 66305	E71T1-1 H8 - 1.6mm			
	N	WMS_WPS-032	50°	62	800	10-6	26.15 V		A 45305	E71T1-1 H8 - 1.6mm			
		WMS_WPS-032	50°	70	200	10-6	24.5 V	The second secon	A 48 305	E71T1-1 H8 - 1.6mm		$\cap$	
	4.	WMS_WPS-032	50°	65	1000 .	10-4	24.5 V	196	A 23305	E71T1-1 H8 - 1.6mm		0	20
	26	WMS_WPS-032	50°	67	1100	10-6	24.5 V		A 48305	E71T1-1 H8 - 1.6mm		Bino	\\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\ \\
	(t.	WMS_WPS-032	50°	63	1200		26.5 V		A 48305	E71T1-1 H8 - 1.6mm		O AM	/
	h	WMS_WPS-032	50°	56	1300		26-5 V		A 48305	E71T1-1 H8 - 1.6mm		0	
	36	WMS_WPS-032	50°	68	1600		26.5 V		A LB 305	E71T1-1 H8 - 1.6mm			
	M	WMS_WPS-032	50°		Yes .		V	N. 143	A	E71T1-1 H8 - 1.6mm			
i.		WMS_WPS-032	50°		1		V		A	E71T1-1 H8 - 1.6mm			2 5

THE TIEAT WING CONSONIABLE GOIDE							
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				

# CQ Field Mining Services

### **WELDING & PRE-HEAT RECORD SHEET**

Client:	Minespec			Job No:	29044		Date:	10.	och	24. V	Veld Procedure:		WMS_WPS-032	
cope#	0	Description:	Cra	ck Repairs - Full per	Weld Size & Fill penetration Joints Finish Fill & Blend Cracked Areas To Match Existing Cont				latch Existing Contou	ır				
ob Descripti	ion:	EX 5600 Stick						Drawin	ng No:					
Welder ID	Joint Type/ID	Weld Procedure No	Recommended Preheat Temp °C	Actual Preheat Temp °c	Date Taken	Time Taken	Volts	Am	1	Plant ID	Consumable Used	Consumable Batch No:	Inspected By: Print Name	Inspected By Initials
20137	Filet	WMS_WPS-032	50°	75	10/4/29	5.20	24 1	19	<b>5</b> A	W5719	E71T1-1 H8 - 1.6mm	BRP.		
1	4.G.	WMS_WPS-032	50°	80	1	630	1	1	Α	1	E71T1-1 H8 - 1.6mm			- Let
	1	WMS_WPS-032	50°	76		730			А		E71T1-1 H8 - 1.6mm			
in the		WMS_WPS-032	50°	81		830			А		E71T1-1 H8 - 1.6mm		0	
		WMS_WPS-032	50°	8-6		930	\ \ \ \		А		E71T1-1 H8 - 1.6mm			0.0
		WMS_WPS-032	50°	77		1030	1		А		E71T1-1 H8 - 1.6mm		Shing	10/
<u> </u>	1	WMS_WPS-032	50°	BOL		1130	V		Α Α		E71T1-1 H8 - 1.6mm		2000	1
4		WMS_WPS-032	50°	22		1230	1		А		E71T1-1 H8 - 1.6mm		V	
		WMS_WPS-032	50°	7-3	-,	1320			А		E71T1-1 H8 - 1.6mm			
	1	WMS_WPS-032	50°	28		10430	1, 1		A	1	E71T1-1 H8 - 1.6mm			
6		WMS_WPS-032	50°	77	V	15.30	V	V	А	4	E71T1-1 H8 - 1.6mm	N N		

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

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

# WELDING & PRE-HEAT RECORD SHEET

lient:	BMA Peakdowi	ns		Job No:	29044	•	Date:	17-04	1-24	Weld Procedure:		WMS_WPS-070	
cope#	0	Description:		Weld closi	ng windows		Weld Size & Finish			0	3	x = 2	
ob Description	on:	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
	16	WMS_WPS-070	75°	76°		5:45PM	24.8 V	185 1	4	E71T-12M H4 - 1.6mm			
TWD	3(1)	WMS_WPS-070	75°	78°		1800	24.8 v	1 1	A	E71T-12M H4 - 1.6mm	7		
#	11	WMS_WPS-070	75°	750	1/2	18:20	24.8 v	At 1	A	E71T-12M H4 - 1.6mm			×
	25	WMS_WPS-070	75°	780	1	18:32	24.5 V	V	Α	E71T-12M H4 - 1.6mm			
۸ ۷	2	WMS_WPS-070	75°	790	77	19:31	24.5 v	Į.	A	E71T-12M H4 - 1.6mm	۸_		
11/10	à	WMS_WPS-070	75°	770	0	20:03	2\$.9 v	,	Α .	E71T-12M H4 -'1.6mm	0		
10		WMS_WPS-070	75°	78	O'	22:40	239 V	1	A	E71T-12M H4 - 1.6mm	80		
1) R		WMS_WPS-070	75°	76°	10	23:30	23.9 V	1	4	E71T-12M H4 - 1.6mm	20		
11	И	WMS_WPS-070	75°	790		01:30AM	24.9 V	1	A	E71T-12M H4 - 1.6mm	0	4	
11.		WMS_WPS-070	75°	78	-	02:20Am	24.9 V	, , , ,	A	E71T-12M H4 - 1.6mm	0		
		WMS_WPS-070	75°	76°		03:40 Am	24.9 v	1	A	E71T-12M H4 - 1.6mm	•		
	72 G		* NOTE:	Readings to be r	ecorded first w	hen the recomme	nded temperatur	e is reached & c	once every Hou	r during Welding.			
					PF	RE-HEAT and (	CONSUMABL	E GUIDE					
Mat	erial	20mm 8	& Under	20mm	- 40mm	40mm	- 60mm	601	mm<	Proces	s	Consu	mable
Q&T80.	4	100	0°C	10	0°C	15	0°C	20	00°C	FCAW		E81T1	-N1-H4

Material	20mm & Under	20mm - 40mm	40mm - 60mm	60mm<	Process	Consumable
Q&T80	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°€	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			

	-	
AM		

GR350

Cruesabro

75°C

30°C

75°C

30°C

### **WELDING & PRE-HEAT RECORD SHEET**

108°C

30°C

FCAW/GMAW

**FCAW** 

E71T1-H8

E71T1-H8

Client:	<b>BMA Peakdow</b>	ns		Job No:	29044		Date:	17-9-	29	Weld Procedure:	. 60	WMS WPS-070	
Scope#	0	Description:		Weld closin	ng windows		Weld Size & Finish			0			
Job Descript	tion:	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
CANDO	262	WMS_WPS-070	75°	78 00	17-4-24	5137A	12 V	185 A		E71T-12M H4 - 1.6mm			
	- W	WMS_WPS-070	75°	812		C: 19A	3   V	1 A	· ·	E71T-12M H4 - 1.6mm	000	4	
	1	WMS_WPS-070	75°	8400		7:23 A	V	А		E71T-12M H4 - 1.6mm		^	4
		WMS_WPS-070	75°	87°0		Q:31A	7 V	А		E71T-12M H4 - 1.6mm	15	1)	
	n	WMS_WPS-070	75°	7700	8 0	9:40 1	V	A		E71T-12M H4 - 1.6mm	30	2.0	01
- N	26	WMS_WPS-070	75°	80%	10	10:50	// V	А		E71T-12M H4 - 1.6mm	99	Bion	0//
	N	WMS_WPS-070	75°	8300		17:08/	y v	А		E71T-12M H4 - 1.6mm	2	2000	//
	,	WMS_WPS-070	75°	792		1:39 P		А	⊗	E71T-12M H4 - 1.6mm	3	7	
4	11	WMS_WPS-070	75°	82%	1	アファド	m v	A		E71T-12M H4 - 1.6mm		-	
*		WMS_WPS-070	75°				V	А		E71T-12M H4 - 1.6mm			
		WMS_WPS-070	75°	14.			V	А		E71T-12M H4 - 1.6mm			
			* NOTE:	Readings to be re					nce every Hou	r during Welding.			
		20mm 8	Lindor	20mm -			CONSUMABL				1		
	aterial					40mm	- 60mm	6Un	nm<	Proces	SS	Consu	mable
Q & T 80		100	)°C	100	O°C	15	0°C	20	0°C	FCAW		E81T1	-N1-H4
Q & T 400		150	)°C	150	O°C	15	0°C	20	0°C	FCAW		E81T1	-N1-H4
Q & T 450	*****	150	)°C	150	)°C	15	0°C	15	0°C	FCAW		E81T1	-N1-H4
GR250		75	°C	75	°C	75	5°C	10	8°C	FCAW/GN	1AW	E717	1-H8
		1											

75°C

30°C

Uncontrolled If Printed



# Section 6

# **DELIVERY DOCKET**

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



40 Production Drive, Paget QLD 4740 PO BOX 973, Mackay QLD 4740

## CI

PH: 07 4952 6557

SENDER Details
CQ Field Mining Services
40 Production Drive, Paget
Mackay, QLD 4740

ining Services	Phone: (07) 4952 6557
oup	ABN: 32 621 415 709
Q WA PNG	

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

**DELIVERY DOCKET** 

<b>RECEIVER Detail</b>	S	
Minespec		

ITEM#		DESCRIPTION	QTY
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		10	
· Common(			
Comments o	r Special Instructions		

Senders Name: Leon Else	Receivers Name:
Senders Signature:	Receivers Signature:
Date: 27 5 20 21/05/2024	21/05/2024