

Certificate Ref: 3000403864R
This certificate replaces 3000403864

Order Ref: PO-03179
Received: 09/11/2018
Issue Date: 28/11/2018
Re-issued: 07/01/2019

For the attention of: Leah Hatch
K & S Aerospace Components
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SOUTHAMPTON
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SO40 3SA



Ashley Payne
Metallurgical Technician

BUTT WELDED NICKEL ALLOY SHEET
Material Specification - Nimonic 75 (MSRR 7104)

Welded By : G Winter
Welder Identity : KS03
Welding Process : TIG
Filler Rod : MSRR 9500/3

Weld Test

Overall Result Acceptable

Visual Examination

Condition As Welded
Magnification Up to x25
Result Acceptable

Tensile Test

Laboratory Temperature		21 °C
Dimensions	a x b	25.0 x 1.21 mm
Area	So	30.3 mm ²
Maximum Force	Fm	24.53 kN
Tensile Strength	Rm	810 N/mm ²
Tensile Strength	Rm	117 ksi
Broke		Adjacent to weld
Result		Acceptable - providing tensile strength meets the design requirements



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Bend Test

Laboratory Temperature	21 °C
Bend Radius	2 x thickness
Face Bend	Bent 180° without cracking.
Result	Acceptable

Metallographic Examination

Magnification	x50 - x500
Etchant	B.O.S.
Section(s) assessed	1
Result	Acceptable

Note

Reason for re-issue: Additional Test Schedules added.

Test Schedule: C.A.A. - British Civil Airworthiness Requirements Chapter A8-10 as applicable.
Test Schedule: Rolls Royce Plc RPS 912 Iss 18 as applicable.
Test Schedule: British Standard BS ISO 24394:2008 + A1:2012 as applicable.

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