

Certificate Ref: 3000403866R
This certificate replaces 3000403866

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

For the attention of: Leah Hatch
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SOUTHAMPTON
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Ashley Payne
Metallurgical Technician

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

Welded By : S Marsh
Welder Identity : KS10
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 1.19 mm
Area	So	29.8 mm ²
Maximum Force	Fm	24.67 kN
Tensile Strength	Rm	828 N/mm ²
Tensile Strength	Rm	120 ksi
Broke		Adjacent to weld
Result		Acceptable - providing tensile strength meets the design requirements

Specification



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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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