

Certificate Ref: 3000424642

Order Ref: PO-04232

Received: 25/05/2021

Issue Date: 09/06/2021

For the attention of: Leah Hatch
K & S Aerospace Components
Unit 14 Eddystone Road
South Hants Industrial Park
SOUTHAMPTON
Hampshire
SO40 3SA



KEIGHLEY LABORATORIES LIMITED

Ashley Payne
Metallurgical Technician

BUTT WELDED STAINLESS STEEL SHEET**Material Advised - 6523 (S527)******Full specification not advised**

Welded By : K Hatch

Welder ID : KS01

Welding Process : TIG ISO 24394-141-S-PA1-B-T1.2

Filler Rod : 9500/2

DPI Examination Certificate: : N149099LIQ1.

Carried out by another UKAS laboratory prior to arrival at Keighley Laboratories.

Radiographic Examination Certificate: : N149099RAD1

Carried out by another UKAS laboratory prior to arrival at Keighley Laboratories.

Visual Examination Certificate: : N149099VIS1

Carried out by another UKAS laboratory prior to arrival at Keighley Laboratories.

Weld Test

Overall Result Acceptable

Visual Examination

Condition	As Welded
Magnification	Up to x25
Result	Acceptable

Tensile Test

Laboratory Temperature		19 °C
Dimensions	a x b	25.0 x 1.23 mm
Area	So	30.8 mm ²
Maximum Force	Fm	18.66 kN
Tensile Strength	Rm	606 N/mm ²
Tensile Strength	Rm	88.0 ksi
Broke		Clear of weld
Result		Acceptable - providing tensile strength meets the design requirements

When a certificate of conformity is required, and where guidance from the material/testing specification is not available, the Simple Acceptance Rule (ILAC - G8:09/2019) will be applied for borderline results that are within the uncertainty budgets for the test carried out as detailed within KLL procedure QP006 Appendix 1 (Guard band zero: Risk less than 50 % Probability of False Accept).

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Results relate only to the item(s) tested.

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Bend Test

**Test Piece Pickled in accordance with
BS EN ISO 3651:1998 Method 'A'**

Laboratory Temperature	20 °C
Bend Radius	3 x thickness
Face Bend	Bent 90° without cracking.
Result	Acceptable

Metallographic Examination

Magnification	x7 - x500
Etchant	Super Kallings Reagent
Section(s) assessed	1
Result	Acceptable

Test Schedule: C.A.A. - British Civil Airworthiness Requirements Chapter A8-10 as applicable.

Test Schedule: British Standard BS ISO 24394:2018 as applicable.

Test Schedule: Rolls Royce plc. - RPS 912 Issue 18 as applicable.

*** END OF DOCUMENT ***

When a certificate of conformity is required, and where guidance from the material/testing specification is not available, the Simple Acceptance Rule (ILAC - G8:09/2019) will be applied for borderline results that are within the uncertainty budgets for the test carried out as detailed within KLL procedure QP006 Appendix 1 (Guard band zero: Risk less than 50 % Probability of False Accept).

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