

Certificate Ref: 3000420626

Order Ref: PO-04009
Received: 28/10/2020
Issue Date: 14/11/2020

For the attention of: Paul Holmes
K & S Aerospace Components
Unit 14 Eddystone Road
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SO40 3SA



Matthew Mellor
Technical Services Director

BUTT WELDED STAINLESS STEEL SHEET
Material Specification - MSRR 6523

Welded By : S Kerr
Welder ID : KS08
Welding Process : TIG
Filler Rod : MSRR 9500/2
Job Number : 01849

Weld Test

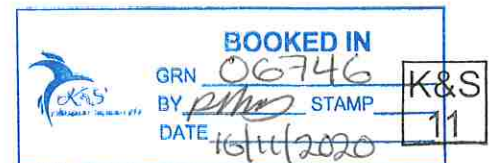
Overall Result Acceptable

Visual Examination

Condition As Welded
Magnification Up to x25
Result Acceptable

Tensile Test

Laboratory Temperature 20 °C
Dimensions a x b 25.06 x 1.22 mm
Area So 30.6 mm²
Maximum Force Fm 20.7 kN
Tensile Strength Rm 676 N/mm²
Tensile Strength Rm 98.0 ksi
Broke Adjacent to 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	21 °C
Bend Radius	3 x thickness
Face Bend	Bent 90° without cracking.
Result	Acceptable

Metallographic Examination

Magnification	x7 - x500
Etchant	Ferric Chloride
Section(s) assessed	1
Result	Acceptable

Note

* Although the welding is deemed to be acceptable to the criteria specified, the size of the test plate received did not comply with the minimum required by ISO 24394:2018.

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

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

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

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