

HT# F119081-981054401

EDMONTON EXCHANGER & MANUFACTURING LTD.

5545 - 89 STREET, EDMONTON, ALBERTA T6E 5W9
 TELEPHONE (780) 468-6722 FAX (780) 466-5155

QCC-004
 REV. 3
 DATE: APR. 12/00
 APPROVED BY: S.Z.

CERTIFICATE OF COMPLIANCE

CUSTOMER FERROTECH LTD	PURCHASE ORDER CHEQUE REQUIRED	WORK ORDER C55472	DATE 2005/01/26	PAGE 1 OF 1
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ITEM #	QTY	DESCRIPTION	HEAT #	TAG CODE	BRINELL HARDN	WELD PROCEDURE	FORMING PROC
P55472-1	1	DISC(S) - 1.5000" NOM X 13.25" OD (12.75" OD Finished) (MATERIAL SPEC: SA 240-316L)	F119081-981054401				

Forming Procedure:
 1. Hot Formed @ 1650F/899C and Air Cooled
 2. Hot Formed @ 1975F/1080C and Air Cooled
 3. Normalized @ 1650F/899C for 25 min/inch and Air Cooled
 4. Cold Formed
 5. Renormalized @ 1650F/899C for 25 min/inch and Air Cooled After Forming
 6. Renormalized @ 1750F/954C for 25 min/inch and Air Cooled After Forming
 7. Re-Solution Annealed @ 1975F/1080C and Air Cooled After Forming
 8. Stress Relieved @ 1150F/621C PER UCS-56 OR PW-39(wherè applicable)

NOTE: ALL ITEMS WHICH WERE HEAT TREATED DURING OR AFTER FORMING SHALL BE INCLUDED ON THE FORMING PROCEDURE LISTED ABOVE AS PER UCS-79(e).

SUPPLEMENTARY EXAMINATION - ITEMS

BRINELL EQUIPMENT: NEWAGE CALIBRATION PIN
 BRINELL HARDNESS TESTER

SUPPLEMENTARY REQUIREMENTS:

THE ITEMS LISTED ABOVE COMPLY WITH THE REQUIREMENTS OF ASME CODE SECTION I (PG-80) AND SECTION VIII, DIV. 1, UCS-79(d), UG-79 & UG-80. ALL WELDERS AND PROCEDURES ARE QUALIFIED TO ASME CODE SECTION IX. FOR TACKING CARBON STEEL ITEMS, ROUND BAR USED IS 1018 COLD ROLLED. MATERIAL BEING SUPPLIED CONFORMS TO THE LATEST ASME CODE SECTION II, PART A, 2001 EDITION, JULY 1, 2003 ADDENDA.
 STEVE ZUBRYCKYJ (QAM)
 EDMONTON EXCHANGER & MANUFACTURING LTD.

