

PPD Mechanical In-Process Weld Inspection Form

(as per In-Process Weld Inspection Guidelines, AD Cryogenics, Nov 3, 2006)

Date 8/14-25/09 Project: DECam 20 ft hose with electrical isolation
Pipe Section: 436836 RevA Weld Number: _____
Weld location: MAB
Welder: Bill Gatfield Inspector: [Signature]

Before Welding:

Type of weld: (butt) 20 (other) _____
(1) Pipe #1 Size, Schedule and material: 3/4" tube .049 wall SS304
(2) Pipe #2 Size, Schedule and material: _____

(1) Joint Preparation and Cleanliness

Joint Preparation and Cleanliness acceptable? Yes

(2) Welding Machine

(a) Remote foot pedal? Yes
(b) DC straight machine? _____

(3) Joint Fit-up, and Internal Alignment.

(a) Internal alignment acceptable? Yes
(b) Joint Clearance acceptable? Yes
(c) End Preparation acceptable? Yes

(4) Filler Rod

(a) AWS A5.9 stainless steel filler rod? Yes
(b) Filler rod: Class _____ Diameter _____

(5) Purge Gas.

(a) type of purge gas : Ar₂
(b) time length of purge: Duration of weld until cool purge flow rate: 25 scFH
SCFH _____
(b) (if done) O₂ reading: 0.8% O₂ Monitor manf/model : _____

(6) Inspection After Root Pass

(a) No visible cracks. Yes
(b) No suck holes, which are small holes in middle of weld. Yes
(c) No porosity or obvious imperfections. Yes
(d) Filler material fused along edges of weld. Yes

(8) Repeat inspection after every pass: Yes

(9) Final Inspection: Yes

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Date 8/14-25/09 Project: DECAM 20 ft hose with electrical isolation
Pipe Section: 436836 Rev A Weld Number: _____
Weld location: MAB
Welder: Bill Gutfeld Inspector: Cheryl Blum

Before Welding:

Type of weld: (butt) _____ (other) Socket (G)
(1) Pipe #1 Size, Schedule and material: 3/4" tube to flange SS304
(2) Pipe #2 Size, Schedule and material: _____

(1) Joint Preparation and Cleanliness

Joint Preparation and Cleanliness acceptable? ✓

(2) Welding Machine

(a) Remote foot pedal? ✓
(b) DC straight machine? _____

(3) Joint Fit-up, and Internal Alignment.

(a) Internal alignment acceptable? ✓
(b) Joint Clearance acceptable? ✓
(c) End Preparation acceptable? ✓

(4) Filler Rod

(a) AWS A5.9 stainless steel filler rod? ✓
(b) Filler rod: Class _____ Diameter _____

(5) Purge Gas.

(a) type of purge gas : Ar₂
(b) time length of purge: Duration of weld purge flow rate: 25 scfh
SCFH Until cool
(b) (if done) O₂ reading: 0.8% O₂ Monitor manf/model : _____

(6) Inspection After Root Pass

(a) No visible cracks. ✓
(b) No suck holes, which are small holes in middle of weld. ✓
(c) No porosity or obvious imperfections. ✓
(d) Filler material fused along edges of weld. ✓

(8) Repeat inspection after every pass: ✓

(9) Final Inspection: ✓