

1.0 PURPOSE

This procedure describes the minimum requirements for welding of induction bends made from carbon steel, low intermediate alloy steel, and high alloy steel.

2.0 SCOPE

All welding shall be performed using welding procedure specifications and welders or welding operators qualified in accordance with ASME Section IX.

3.0 RESPONSIBILITY

The Shop Superintendent is responsible for the implementation, documentation and maintenance of Welding Control. Other designated individuals may be involved in these areas as required by the procedure.

4.0 PROCEDURE

4.1 All welding shall be performed using welding procedure specifications and welders or welding operators qualified in accordance with ASME Section IX.

4.2 Welding procedure specifications will be written by Shop Superintendent and the required test welds are made under his supervision. Preparation and testing of the required specimens is performed to ASME Section IX requirements by a qualified testing laboratory. The report of tests submitted by the laboratory is reviewed by the Q.C. Manager, and if acceptable, he prepares and signs the procedure qualification record.

4.3 Copies of the qualified welding procedure specifications are made available by the Shop Superintendent for use by the production welders. The shop Superintendent maintains the original welding procedure specifications, procedure qualification records and records to laboratory test results.

4.4 A new welding procedure specification is prepared and qualified whenever an essential or required supplementary variable is changed and revised when a non-essential variable is changed.

4.5 All welders and welding operators to be used in fabrication are qualified to ASME Section IX under the supervision of the welding foreman and/or quality control inspector. The preparation and testing of the required specimens are performed by the Shop Superintendent or an outside source (if required by the customer). If acceptable, the Shop Superintendent or outside source (if applicable) prepares and signs the manufacturer's record of welder or welding operator qualification test.

4.6 A welder's record will be provided to the welding foreman to inform him of a specific welder's qualifications.

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4.7 Welders and welding operators will be re-qualified in each process as described in Paragraph 5. They have not welded in the process for any six month period or There is specific reason to question their ability to make acceptable welds.

4.8 Each qualified welder or welding operator is listed on a welder or welding operator work history form maintained by the Shop Superintendent, from information provided by the welding foreman. The form indicates the date on which the welder or welding operator has welded in a specific process. The Shop Superintendent determines from the log when a welder's qualification is expiring.

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