

SPECIFICATION SPT-0000000-S-0015
General Fabrication Specification for Weldments

PAGE 1 OF 4

Jefferson Lab

● Thomas Jefferson National Accelerator Facility

12,000 Jefferson Avenue
Newport News, VA 23606

SPECIFICATION NO:
SPT-0000000-S-0015 Rev. C

TITLE: General Fabrication Specification for
Weldments


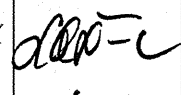
DATE: 2-3-09

BY: HyeKyoung Park

APP: L.A. Dillon-Townes

CHK: Katherine Wilson

APP: Katherine Wilson

C	Revised: Revised: 2.2 – re-write Deleted: the second sentence of “All inspections shall be done...Non Destructive Testing” from the paragraph.	S. Yang  4/18/11	HK Park 4/18/11	 4/18/11	4-18-11
B	Revised: 1.1.1 – switched order of 1.1.1.1 and 1.1.1.4 1.1.1.3 to state drawing in lieu of “Section 2.0” Revised: 2.1 – re-write Deleted: reference to GD&T from 2.3.3 Revised: 2.4.1 – re-write	JRB	LADT	M. Bevins	1-15-10
A	Change title: support stand to weldment. Change AWS D1.1 to AWS code called out on the weldment drawing. These changes allow this specification to apply to all AWS specified weldments.	HK Park	KMW	LADT	10-6-09
REV.	DESCRIPTION	BY	CHK.	APP.	DATE

APR 18 2011

1.0 General

1.1 Deliverables to Jefferson Lab (JLab)

1.1.1 The **Vendor's BID** shall include the following submissions:

- 1.1.1.1 Statement verifying understanding of and intent to comply with drawing(s), this specification, and any additional requirements as stated in JLab Request for Quote (RFQ).
- 1.1.1.2 Cost to fabricate weldment(s) in accordance with drawing(s), this specification, and JLab RFQ.
- 1.1.1.3 Statement accepting delivery schedule as specified in JLab RFQ. Vendor may request alternate delivery schedule at the time of BID.
- 1.1.1.4 Certification of Vendor's Quality Assurance Program (QAP) in accordance with ISO 9001 or MIL-1-45208. QAP's not certified in accordance with these programs may be considered pending review and approval by JLAB.
- 1.1.1.5 JLAB will consider alternative welding call-outs or techniques submitted at the time of BID which will be reviewed for acceptance.

1.1.2 **After award of the contract and prior to commencement of fabrication** the vendor shall submit to Jefferson Lab all welder certifications, Inspector certifications, etc. required by paragraph 2.1 and 2.2.

1.1.3 **At time of delivery**, the vendor shall submit the following documentation along with the weldment(s):

- 1.1.3.1 Material certifications for all material including weld filler material
- 1.1.3.2 Welding inspection and acceptance records
- 1.1.3.3 Certification of compliance with the AWS code called out on the weldment drawing (AWS D1.1, AWS D1.2, AWS D14.1, etc.)
- 1.1.3.4 Statement of conformance with all dimensions and tolerances on weldment drawing(s)

2.0 Fabrication and Welding

- 2.1 Welding shall be performed in accordance with the latest edition of the code specified on the drawing(s). Code qualified welding procedures (WPS's) and welder qualifications (WPQ's) shall be submitted to Jefferson Lab prior to commencement of fabrication.

- 2.2 Weld inspection will be performed by the vendor before painting. . The inspection and subsequent acceptance will be conducted and documented by an AWS Certified Weld Inspector.

2.3 Quality Control

- 2.3.1 Before painting, all welds shall be inspected, accepted and documented for compliance with the code called out on the weldment drawing(s). JLab quality control personnel may request to observe the inspection process at the vendor's site. JLAB must be notified, a minimum of 7 calendar days, prior to impending inspections.
- 2.3.2 The vendor shall perform and document all weld and dimensional inspections to ensure that the weldment is structurally sound, free of defects and meets the requirements of this specification and applicable drawing(s) prior to shipment.
- 2.3.3 Jefferson Lab reserves the right to visit Vendor's site to examine fabrication of weldment(s).

2.4 JLab Acceptance

- 2.4.1 Jefferson Lab may examine the weldment(s) prior to delivery and will examine the weldment(s) after delivery, prior to formal acceptance. Acceptance will be contingent on a successful examination of the assembly, any components and associated documentation. Welding documentation will be reviewed for conformity to the code called out on the weldment drawing(s). Written notification of acceptance or rejection will be provided.
- 2.4.2 Jefferson Lab may perform detailed first article inspections as necessary and sampling plans may be utilized for large procurements. Additional information will be provided in the JLab RFQ.

2.5 Conflicts

Any and all conflicts among the drawing(s) or requirements of this specification or RFQ are to be brought to the attention of the JLab Technical Representative for resolution prior to the commencement or continuation of work. Under no circumstances is the vendor to take any initiative without resolution through JLab and written approval from JLab procurement department.

3.0 **Preparation for Delivery**

3.1 Shipping Notice

The vendor shall provide notice to JLab prior to shipment of the weldment(s). The notification shall include identification of parts and assemblies to be shipped, quantity, and expected shipping date.

3.2 Packaging/ Shipping

The vendor shall properly package and transport, in accordance with transportation industry standards, the weldment(s) to ensure that damage to assemblies and/ or parts will not occur. Care shall be taken to protect the machined surfaces from damage. When packaging the weldment(s) assembly for shipment, the weights of the individual components are to be visible, in plain sight, so that proper handling equipment can be selected.

3.3 Marking: Part number and Total weights shall be annotated as specified on drawing(s) or JLab RFQ.