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| Traveler Title | SNS PPU Cold Mass Assembly Corrugated Hose Weld Inspection Traveler |
| Traveler Abstract | Traveler describes JLab weld inspection of the welds on the Corrugated Hoses, aka Equalizers, that are used on SNS PPU cryomodule cold mass assembly  |
| Traveler ID | SNSPPU-INSP-EQFH-WELD |
| Traveler Revision  | R1 |
| Traveler Author | Gary Cheng |
| Traveler Date | 28-Sep-20 |
| NCR Informative Emails | Cheng, fischer, edaly |
| NCR Dispositioners | Cheng, fischer, edaly |
| D3 Emails | Cheng, fischer, edaly |
| Approval Names | G. Cheng | J. Fischer | J. Alston | E. Daly |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | Reviewer | JLab CWI | Project Manager |

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| References | List and Hyperlink all documents related to this traveler. This includes, but is not limited to: safety (THAs, SOPs, etc), drawings, procedures, and facility related documents. |
| [104211500-M8U-8200-A027 Corrugated Hose](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-223817/104211500-M8U-8200-A027%20CORRUGATED%20HOSE%20ASSEMBLY.pdf) | [Kit - Part Serial Numbers for SNSPPU-CWI-EQFH](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-226688/Kit%20-%20Part%20Serial%20Numbers%20for%20SNSPPU-CWI-EQFH.xlsx) |  |  |  |
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| Revision Note |  |
| R1 | Initial release of this Traveler. |

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| Step No. | Instructions | Data Input |
| 1 | A certified weld examiner/inspector is required.Inspector NameDate of Inspection | [[InspectorName]] <<SRF>>[[InspectionDate]] <<TIMESTAMP>> |
| 2 | The Corrugated Hoses are kitted. Each kit consists of 3 hoses. Refer to [Kit - Part Serial Numbers for SNSPPU-CWI-EQFH](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-226688/Kit%20-%20Part%20Serial%20Numbers%20for%20SNSPPU-CWI-EQFH.xlsx) for part SNs contained in kits. Pull one kit to inspect at a time. Enter kit serial number (EQFHSN):Note: after inspection, parts shall resume kitted as they were. | [[EQFHSN]] <<EQFHSN>> |
| 3 | Vendor documents are uploaded to SharePoint folder [CMASS\_Flex Hose (Equalizer](https://jeffersonlab.sharepoint.com/%3Af%3A/r/sites/SNSPPUCavity/Shared%20Documents/CMASS_Flex%20Hose%20%28Equalizer%29?csf=1&web=1&e=bL7nVB)). Review vendor weld inspection report and comment.  |  [[VendorRptComment]] <<COMMENT>> |
| 4 | All hoses are required to be built in accordance with ASME B31.3. Inspect accessible welds exterior and interior to make sure that:* Welds are good, i.e. weld interior and exterior should be smooth and flush, with no crevices, cracks or protrusions, weld oxidation/sugaring shall have been brushed off. Verify weld sizes and patterns meeting specification in drawings. Make notes of any nonconformances.
* There should be no unusual discoloration to the base material, especially around the welds.

Generate NCR per weld inspector’s judgement. | [[WeldsOk]] <<YESNO>>[[ColorationOk]] <<YESNO>>[[WeldsComments]] <<COMMENT>> |
| 5 | Upload weld inspection report and pictures of failed areas or areas of concern. | [[WeldSurfPics]] <<FILEUPLOAD>>[[Weld\_Insp\_Rpt]] <<FILEUPLOAD>> |