

# Welding and Brazing Final Visual Inspection

(See [ES&H Manual Welding and Brazing Program Supplement](#) for more information.)

## FINAL VISUAL INSPECTION – INFORMATION

Group: SNS PPU		Component: Helium Vessel – Probe End Head Weldments		Date: 9/25/20
Drawing #: 1042211700-M8U-8200-A025		Rev#:	PQR #: On File	WPS/BPS #: On File
Welder/Brazer #: Vendors Welder (On File)		Process: GTAW		B31.3 Fluid Service: N/A
ACCEPTANCE CRITERIA	<input type="checkbox"/> ASME B31.3 Chapter VI [Table 341.3.2]	<input type="checkbox"/> AWS D1.1 Chapter VI [Table 6.1]	<input checked="" type="checkbox"/> Other Code(s): ASME Section VIII- Div. 1	
# of Welds or Brazes Examined: All welds on the Header - SN: AG, AJ, AM, AN, AQ, AS, AU		# of Mechanical Joints Examined: N/A		

## FINAL VISUAL INSPECTION – CHECKLIST

	Accept	Reject	N/A
1. Mechanical joints have been properly assembled	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
2. Mechanical joints have been properly erected including alignment supports and cold spring	<input type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>
3. Welds/Brazes were sufficiently cleaned as not to impair visual inspection and are uniquely identified	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
4. Geometry or profile conforms to WPS/BPS, drawing details or Code requirements	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
5. Weld joint was properly identified to welder/brazer	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
6. All flux/slag removed	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
<b>WELDING ONLY:</b>			
7. Weld has no visible cracks	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
8. Thorough fusion (weld and base metals) and complete penetration if required exist	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
9. Surface porosity or exposed slag inclusion	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
10. Surface finish	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
11. Concave root surface (suck up) or lack of weld joint break down	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
12. Internal and external reinforcement within allowable limits	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
13. Any fillet weld undersize (AWS only) within limits and undercutting depths	<input checked="" type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

REMARKS:

SIGNATURE

*Jenord Alston*  
EXAMINER / INSPECTOR

Jenord Alston  
CWI 09111931  
QC1 EXP. 11/1/2021

DATE 9/25/20

ISSUING AUTHORITY	TECHNICAL POINT-OF-CONTACT	APPROVAL DATE	REVIEW DATE	REV.	Page
ESH&Q Division	Jenord Alston	02/06/2017	02/06/2022	1.1	1 of 2

