

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 – Shell Weldment | | Date: 9/25/20 |
| Drawing #: 1042211700-M8U-8200-A020 | | 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: SHELL WELD ONLY – 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"/> |
| WELDING ONLY: | | | |
| 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 type="checkbox"/> | <input type="checkbox"/> | <input checked="" type="checkbox"/> |

REMARKS:

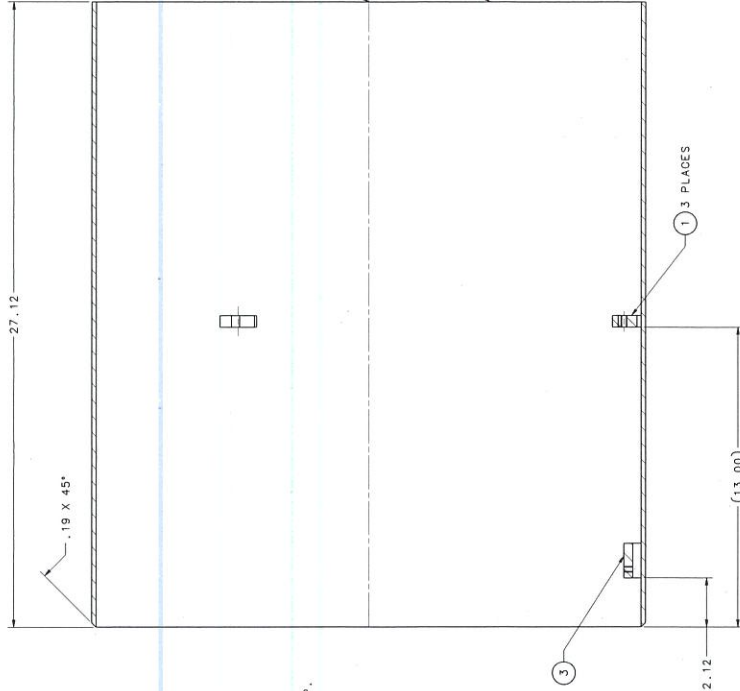
SIGNATURE

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 1 |



- NOTES:

[illegible]