

# Welding and Brazing Final Visual Inspection

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

## FINAL VISUAL INSPECTION – INFORMATION

Group: <b>SNS PPU</b>		Component: <b>Helium Vessel – Shell Weldment</b>		Date: <b>9/25/20</b>
Drawing #: <b>1042211700-M8U-8200-A020</b>		Rev#:	PQR #: <b>On File</b>	WPS/BPS #: <b>On File</b>
Welder/Brazer #: <b>Vendors Welder (On File)</b>		Process: <b>GTAW</b>		B31.3 Fluid Service: <b>N/A</b>
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: <b>SHELL WELD ONLY – SN: AB, AC, AD, AE</b>		# of Mechanical Joints Examined: <b>N/A</b>		

## 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 type="checkbox"/>	<input type="checkbox"/>	<input checked="" type="checkbox"/>

### REMARKS:

SIGNATURE

*Jenord Alston*



Jenord Alston  
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QC1 EXP. 11/1/2021

EXAMINER / INSPECTOR

DATE **9/25/20**

ISSUING AUTHORITY	TECHNICAL POINT-OF-CONTACT	APPROVAL DATE	REVIEW DATE	REV.	Page
ESH&Q Division	<a href="#">Jenord Alston</a>	02/06/2017	02/06/2022	1.1	1 of 1

