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| Traveler Title | LCLS-II HE MC 50K Intercept Receiving Weld Inspection  |
| Traveler Abstract | This traveler is to be used for the receiving weld inspection of the LCLS-II HE MC 50K intercept assembly. |
| Traveler ID | L2HE-CWI-MCSHLD |
| Traveler Revision  | R1 |
| Traveler Author | Gary Cheng |
| Traveler Date | 14-Jun-22 |
| NCR Informative Emails | Hogan,mbevins |
| NCR Dispositioners | Cheng,fischer |
| D3 Emails | Cheng,fischer |
| Approval Names | Gary Cheng | Jenord Alston | John Hogan |  |
| Approval Signatures |  |  |  |  |
| Approval Dates |  |  |  |  |
| Approval Title | Author | Reviewer | 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. |
| [LCLS-II HE MC 50K Intercept Drawings](https://jlabdoc.jlab.org/docushare/dsweb/Get/Document-256566/LCLS-II%20HE%20MC%2050K%20Intercept%20Drawings.pdf) |  |  |  |  |
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| Revision Note |  |
| R1 | Initial release of this Traveler. |

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| Step No. | Instructions | Data Input |
| 1 | Enter inspector name and inspection time | [[WeldInspector]] <<SRF>>[[WeldInspDate]] <<TIMESTAMP>> |
| 2 | The F10054168 MC 50K Intercepts are kitted and stored in one box per kit. Each kit/box is marked with an identification number. This inspection focuses on the weld specified on drawing F10044654, section A-A. Enter the quantity of kits inspected. In the comment field, please report the number of kits failed to pass.Inspection criteria:1. The weld is expected to be a non-ground, beaded weld for good thermal transfer and ensures integrity of the joint.
2. The effective weld throat shall be no less than the thickness of Item 2 of F10044654.

For F10054168 kits not meeting the above criteria, please generate a NCR consisting a list of non-conforming kits and example photos. Accepted kits shall be marked/labeled differently from the non-conforming ones to avoid confusion.Upload example photos of acceptable shields. Photos of shields failed to pass weld inspection may be uploaded here or in the NCR report. | [[Qty\_Kits\_Insp]] <<FLOAT>>[[Insp\_Remarks]] <<COMMENT>>[[InspPhotos]] <<FILEUPLOAD>> |
| 3 | Repackage all kits after inspection. |  |