

AD/MS Fluids Group
In-Process Welding Examination Form

(As per In-Process Welding Examination Guidelines, AD/MS Fluids Group, May 11, 2012)

Date: May 15 2015
Pipe Section: LCW5+R
Welder: Math woods

Project: MC BEAMLINE ENCLOSURE
Weld Number: # 1
Examiner: Jed Urzich

Before Welding:

Type of weld: (butt) X (other) _____

(1) Pipe #1 Size, Schedule and material:

8" - SCH 10 - 316 SS

(2) Pipe #2 Size, Schedule and material:

(1) Joint Preparation and Cleanliness

Joint Preparation and Cleanliness acceptable? yes

(2) Welding Machine

(a) Remote foot pedal? no

(b) DC straight machine? yes

(3) Joint Fit-up, and Internal Alignment.

(a) Internal alignment acceptable? yes

(b) Joint Clearance acceptable? yes

(c) End Preparation acceptable? yes

(4) Filler Rod

(a) AWS A5.9 stainless steel filler rod? yes

(b) Filler rod: Class 316 Diameter 7/32 + 1/8

(5) Purge Gas.

(a) type of purge gas : Argon

(b) time length of purge: Full 30 min purge flow rate: 60 CFH

(b) (if done) O2 reading: _____ O2 Monitor manf/model : _____

(6) Inspection After Root Pass

(a) No visible cracks. no

(b) No suck holes, which are small holes in middle of weld. no

(c) No porosity or obvious imperfections. no

(d) Filler material fused along edges of weld. yes

(7) Reference/Drawing number: 6-10-22-C4+C5

(8) Repeat inspection after every pass: yes

(9) Final Examination: yes

RJ One:1 Mech

**AD/MS Fluids Group
In-Process Welding Examination Form**

(As per In-Process Welding Examination Guidelines, AD/MS Fluids Group, May 11, 2012)

Date: May 15 2015
Pipe Section: LOW STR
Welder: Matt Woods

Project: MC BEAMLINE ENCLOSURE
Weld Number: 1 2
Examiner: Jed Ulrich

Before Welding:

Type of weld: (butt) X (other) _____
(1) Pipe #1 Size, Schedule and material: 8" 30210 316
(2) Pipe #2 Size, Schedule and material: _____

(1) Joint Preparation and Cleanliness

Joint Preparation and Cleanliness acceptable? yes

(2) Welding Machine

(a) Remote foot pedal? no
(b) DC straight machine? yes

(3) Joint Fit-up, and Internal Alignment.

(a) Internal alignment acceptable? yes
(b) Joint Clearance acceptable? yes
(c) End Preparation acceptable? yes

(4) Filler Rod

(a) AWS A5.9 stainless steel filler rod? yes
(b) Filler rod: Class 316 Diameter 1/8 + 3/32

(5) Purge Gas.

(a) type of purge gas : Argon
(b) time length of purge: Full 30 min purge flow rate: 60 CFH
(b) (if done) O2 reading: — O2 Monitor manf/model : —

(6) Inspection After Root Pass

(a) No visible cracks. no
(b) No suck holes, which are small holes in middle of weld. no
(c) No porosity or obvious imperfections. no
(d) Filler material fused along edges of weld. yes

(7) Reference/Drawing number: 6-10-22-C4+C5

(8) Repeat inspection after every pass: yes

(9) Final Examination: yes

RT Oneil Mech

**AD/MS Fluids Group
In-Process Welding Examination Form**

(As per In-Process Welding Examination Guidelines, AD/MS Fluids Group, May 11, 2012)

Date: May 15, 2015
Pipe Section: LCWS+R
Welder: Matt Woods

Project: MC BEAMLINE ENCLOSURE
Weld Number: 3
Examiner: Jed Ulrich

Before Welding:

Type of weld: (butt) X (other) _____

(1) Pipe #1 Size, Schedule and material: 8" sch 10 316 SS

(2) Pipe #2 Size, Schedule and material: _____

(1) Joint Preparation and Cleanliness

Joint Preparation and Cleanliness acceptable? yes

(2) Welding Machine

(a) Remote foot pedal? no
(b) DC straight machine? yes

(3) Joint Fit-up, and Internal Alignment.

(a) Internal alignment acceptable? yes
(b) Joint Clearance acceptable? yes
(c) End Preparation acceptable? yes

(4) Filler Rod

(a) AWS A5.9 stainless steel filler rod? yes
(b) Filler rod: Class 316 Diameter 3/32 + 1/8

(5) Purge Gas.

(a) type of purge gas : Argon
(b) time length of purge: 30 min Full purge flow rate: 60 CFH
(c) (if done) O2 reading: _____ O2 Monitor manf/model : _____

(6) Inspection After Root Pass

(a) No visible cracks. no
(b) No suck holes, which are small holes in middle of weld. no
(c) No porosity or obvious imperfections. no
(d) Filler material fused along edges of weld. yes

(7) Reference/Drawing number: 6-10-22 - C4 + C5

(8) Repeat inspection after every pass: yes

(9) Final Examination: yes

RJ Oneil mech

**AD/MS Fluids Group
In-Process Welding Examination Form**

(As per In-Process Welding Examination Guidelines, AD/MS Fluids Group, May 11, 2012)

Date: May 15, 2015

Project: MC BEAMLINE ENCLOSURE

Pipe Section: LCW STR

Weld Number: 4

Welder: Matthew Woods

Examiner: Jed Urzich

Before Welding:

Type of weld: (butt) X (other) _____

(1) Pipe #1 Size, Schedule and material:

8" Sch 10 316 SS

(2) Pipe #2 Size, Schedule and material:

(1) Joint Preparation and Cleanliness

Joint Preparation and Cleanliness acceptable? Yes

(2) Welding Machine

(a) Remote foot pedal? No

(b) DC straight machine? Yes

(3) Joint Fit-up, and Internal Alignment.

(a) Internal alignment acceptable? Yes

(b) Joint Clearance acceptable? Yes

(c) End Preparation acceptable? Yes

(4) Filler Rod

(a) AWS A5.9 stainless steel filler rod? Yes

(b) Filler rod: Class 316 Diameter 3/32 + 1/8

(5) Purge Gas.

(a) type of purge gas : Argon

(b) time length of purge: Full 30 min purge flow rate: 60 CFH

(b) (if done) O2 reading: _____ O2 Monitor manf/model : _____

(6) Inspection After Root Pass

(a) No visible cracks. No

(b) No suck holes, which are small holes in middle of weld. No

(c) No porosity or obvious imperfections. No

(d) Filler material fused along edges of weld. Yes

(7) Reference/Drawing number: 6-10-22 C4+C5

(8) Repeat inspection after every pass: Yes

(9) Final Examination: Yes

RJ Oneil Mech

**AD/MS Fluids Group
In-Process Welding Examination Form**

(As per In-Process Welding Examination Guidelines, AD/MS Fluids Group, May 11, 2012)

Date: May 13, 2015
Pipe Section: LCW. S+R
Welder: Matt Woods

Project: MC BEAMLINE ENCLOSURE
Weld Number: 5
Examiner: Jed Urzich

Before Welding:

Type of weld: (butt) X (other) _____

(1) Pipe #1 Size, Schedule and material: _____

8" - Sch # 10 - 316 SS

(2) Pipe #2 Size, Schedule and material: _____

8" - Sch # 10 - 316 SS

(1) Joint Preparation and Cleanliness

Joint Preparation and Cleanliness acceptable? yes

(2) Welding Machine

(a) Remote foot pedal? no

(b) DC straight machine? yes

(3) Joint Fit-up, and Internal Alignment

(a) Internal alignment acceptable? yes

(b) Joint Clearance acceptable? yes

(c) End Preparation acceptable? yes

(4) Filler Rod

(a) AWS A5.9 stainless steel filler rod? yes

(b) Filler rod: 316 Class 316-316L Diameter 1/8"

(5) Purge Gas

(a) type of purge gas : Argon

(b) time length of purge: Full 30 min purge flow rate: 60 CFH

(b) (if done) O2 reading: — O2 Monitor manf/model : —

(6) Inspection After Root Pass

(a) No visible cracks. no

(b) No suck holes, which are small holes in middle of weld. no

(c) No porosity or obvious imperfections. no

(d) Filler material fused along edges of weld. yes

(7) Reference/Drawing number: 6-10-22-C4+C5

(8) Repeat inspection after every pass: yes

(9) Final Examination: yes

RS one:1 mech.

**AD/MS Fluids Group
In-Process Welding Examination Form**

(As per In-Process Welding Examination Guidelines, AD/MS Fluids Group, May 11, 2012)

Date: May 14, 2015

Project: MC BEAMLINE ENCLOSURE

Pipe Section:

Weld Number: Q 6

Welder: Math Woods

Examiner: Jed Urlich

Before Welding:

Type of weld: (butt) X (other) _____

(1) Pipe #1 Size, Schedule and material:

8" SCH 40 - 316SS

(2) Pipe #2 Size, Schedule and material:

8" SCH 40 - 316SS

(1) Joint Preparation and Cleanliness

Joint Preparation and Cleanliness acceptable? yes

(2) Welding Machine

(a) Remote foot pedal? no

(b) DC straight machine? yes

(3) Joint Fit-up, and Internal Alignment.

(a) Internal alignment acceptable? yes

(b) Joint Clearance acceptable? yes

(c) End Preparation acceptable? yes

(4) Filler Rod

(a) AWS A5.9 stainless steel filler rod? yes

(b) Filler rod: Class 316 Diameter 1/8"

(5) Purge Gas.

(a) type of purge gas : Argon

(b) time length of purge: Full 30 min purge flow rate: 60 CFH

(b) (if done) O2 reading: — O2 Monitor manf/model : —

(6) Inspection After Root Pass

(a) No visible cracks. no

(b) No suck holes, which are small holes in middle of weld. no

(c) No porosity or obvious imperfections. no

(d) Filler material fused along edges of weld. yes

(7) Reference/Drawing number: 6-10-22-C4+C5

(8) Repeat inspection after every pass: yes

(9) Final Examination: yes

RS oneil mech

**AD/MS Fluids Group
In-Process Welding Examination Form**

(As per In-Process Welding Examination Guidelines, AD/MS Fluids Group, May 11, 2012)

Date: May 14 2015
Pipe Section: LCW5+R
Welder: Math Woods

Project: MC BEAMLINE ENCLOSURE
Weld Number: 7
Examiner: Jed Urwith

Before Welding:

Type of weld: (butt) X (other) _____

(1) Pipe #1 Size, Schedule and material: 8" Sch 10 - 316 SS

(2) Pipe #2 Size, Schedule and material: 8 Sch 10 - 316 SS

(1) Joint Preparation and Cleanliness

Joint Preparation and Cleanliness acceptable? yes

(2) Welding Machine

(a) Remote foot pedal? no

(b) DC straight machine? yes

(3) Joint Fit-up, and Internal Alignment.

(a) Internal alignment acceptable? yes

(b) Joint Clearance acceptable? yes

(c) End Preparation acceptable? yes

(4) Filler Rod

(a) AWS A5.9 stainless steel filler rod? yes

(b) Filler rod: Class 316 Diameter 1/8"

(5) Purge Gas.

(a) type of purge gas : Argon

(b) time length of purge: Full 30 min purge flow rate: 60 CFH

(b) (if done) O2 reading: — O2 Monitor manf/model : —

(6) Inspection After Root Pass

(a) No visible cracks. no

(b) No suck holes, which are small holes in middle of weld. no

(c) No porosity or obvious imperfections. no

(d) Filler material fused along edges of weld. yes

(7) Reference/Drawing number: 6-10-22 - C4 + C5

(8) Repeat inspection after every pass: yes

(9) Final Examination: yes

RS oneil mech

AD/MS Fluids Group
In-Process Welding Examination Form

(As per In-Process Welding Examination Guidelines, AD/MS Fluids Group, May 11, 2012)

Date: May 14 2015
Pipe Section: LWC S+R
Welder: Matt Woods

Project: MC BEAMLINE ENCLOSURE
Weld Number: 8
Examiner: Jed Urish

Before Welding:

Type of weld: (butt) X (other) _____
(1) Pipe #1 Size, Schedule and material: Ø 2 SCH 10 316 SS
(2) Pipe #2 Size, Schedule and material: _____

(1) Joint Preparation and Cleanliness

Joint Preparation and Cleanliness acceptable? yes

(2) Welding Machine

(a) Remote foot pedal? NO
(b) DC straight machine? yes

(3) Joint Fit-up, and Internal Alignment.

(a) Internal alignment acceptable? yes
(b) Joint Clearance acceptable? yes
(c) End Preparation acceptable? yes

(4) Filler Rod

(a) AWS A5.9 stainless steel filler rod? yes
(b) Filler rod: Class 316 Diameter 1/8 + 3/32

(5) Purge Gas.

(a) type of purge gas : Argon
(b) time length of purge: 11-30 min purge flow rate: 60 CFH
(b) (if done) O2 reading: — O2 Monitor manf/model : —

(6) Inspection After Root Pass

(a) No visible cracks. NO
(b) No suck holes, which are small holes in middle of weld. NO
(c) No porosity or obvious imperfections. NO
(d) Filler material fused along edges of weld. yes

(7) Reference/Drawing number: 6-10-22-C4+L5

(8) Repeat inspection after every pass: yes

(9) Final Examination: yes