

MicroBooNE
In-Process Weld Inspection Form

(as per In-Process Weld Inspection Guidelines, MicroBooNE Cryogenic System)

Date: 20/11/12 Project: MicroBooNE Cryogenics.

Pipe Section: 493136 Weld Number: #3

Weld Location:

Welder: R.M.#2 Inspector: A.L.

Before Welding:

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

(1) Pipe #1 Size, Schedule and Material: 2" SCH 10 S.S.

(2) Pipe #2 Size, Schedule and Material: 2" SCH 10 S.S.

(1) Joint Preparation and Cleanliness

Joint Preparation and Cleanliness acceptable? x

(2) Welding Machine

(a) Remote foot pedal? x

(b) DC straight machine? x

(3) Joint Fit-up, and Internal Alignment

(a) Internal alignment acceptable? x

(b) Joint clearance acceptable? x

(c) End preparation acceptable? x

(4) Filler Rod

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

(b) Filler rod: Class 308 Diameter 1/4"

(5) Purge Gas

(a) type of purge gas: AR

(b) time length of purge: — purge flow rate: <.5%

(6) Inspection After Root Pass

(a) No visible cracks. x

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

(c) No porosity or obvious imperfections: x

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

(7) Repeat inspection after every pass: x

(8) Final Inspection: x