

MicroBooNE
In-Process Weld Inspection Form

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

Date: 11/16/12

Project: MicroBooNE Cryogenics

Pipe Section: 493111

Weld Number: 2. (ITEM 5)
711

Weld Location: LAB E

Welder: #2

Inspector: A.L. 4795

Before Welding:

Type of weld: (butt) X (other) _____
(1) Pipe #1 Size, Schedule and Material: 3" SCH.10 / S.S.
(2) Pipe #2 Size, Schedule and Material: 3" 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 1/16

(5) Purge Gas

(a) type of purge gas: AR
(b) time length of purge: 15 purge flow rate: 13 SLH

(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