

MicroBooNE

In-Process Weld Inspection Form

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

Date: 12/26/12

Project: MicroBooNE Cryogenics.

Pipe Section: 493181

Weld Number: #2

Weld Location:

Welder: R.M. #2

Inspector: A.L. 4795

Before Welding:

Type of weld: (butt) (other) _____

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

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

(1) Joint Preparation and Cleanliness

Joint Preparation and Cleanliness acceptable?

(2) Welding Machine

(a) Remote foot pedal?

(b) DC straight machine?

(3) Joint Fit-up, and Internal Alignment

(a) Internal alignment acceptable?

(b) Joint clearance acceptable?

(c) End preparation acceptable?

(4) Filler Rod

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

(b) Filler rod: Class 308 Diameter 1/16

(5) Purge Gas

(a) type of purge gas: A2

(b) time length of purge: 15 MIN. purge flow rate: 10 SCFH

(6) Inspection After Root Pass

(a) No visible cracks.

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

(c) No porosity or obvious imperfections:

(d) Filler material fused along edges of weld.

(7) Repeat inspection after every pass:

(8) Final Inspection: