

**MicroBooNE**  
**In-Process Weld Inspection Form**

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

Date: 11/8/12

Project: MicroBooNE Cryogenics.

Pipe Section: NE489995

Weld Number: #6

Weld Location:

Welder: Ryan Mahoney WA

Inspector: A. Barger 2316

Before Welding:

Type of weld: (butt)  (other) \_\_\_\_\_

(1) Pipe #1 Size, Schedule and Material: 1 1/2 Sch 10 304SS

(2) Pipe #2 Size, Schedule and Material: 1 1/2 x 3 Reducer Sch 10 304SS

(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 308L Diameter 1/16

(5) Purge Gas

(a) type of purge gas: Argon

(b) time length of purge: 15 min purge flow rate: 15 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: [Signature]