

# REDACTED

This document may not be disclosed or reproduced in whole or in part without prior written permission from a representative of the Company with the authority to grant such permission.

Copyright © JnF Specialties, LLC. All rights reserved worldwide. [www.jnfspecialties.com/about-us/copyright](http://www.jnfspecialties.com/about-us/copyright)

## Add to Cart

(Template User Guide: replace demo content as required - delete this comment prior to release)

### EDGE JOINT CORNER-FLANGE WELD

Mo/Yr

| Revisions    |                           | Rev:                     |                            |                |        |
|--------------|---------------------------|--------------------------|----------------------------|----------------|--------|
| Letter       | E.O. Number - Description | Date                     |                            |                |        |
|              |                           |                          |                            |                |        |
| Used On      | Contract#:                | <b>Your Co</b>           |                            |                |        |
| Prepared By: |                           |                          |                            |                |        |
| Your Dept:   |                           |                          |                            |                |        |
| Your Dept:   |                           | <b>WELDING PROCEDURE</b> |                            |                |        |
| Your Dept:   |                           | Your #                   |                            |                |        |
| Your Dept:   |                           | Size: <b>A</b>           | CAGE: <input type="text"/> | Form Rev: Orig | 1 of 1 |

Your Logo

## TABLE OF CONTENTS

**1.0 APPLICATION ..... 3**

**2.0 REFERENCED DOCUMENTS (to the extent specified herein)..... 3**

**3.0 SUPPORTING DOCUMENT ..... 3**

**4.0 APPLICABLE DOCUMENTS (incorporated herein) ..... 3**

**WELDING PROCEDURE QUALIFICATION TEST RECORD ..... 4**

**VISUAL INSPECTION (Class B inspector)..... 4**

**WELDING PROCEDURE..... 4**

**WELDING PROCEDURE SPECIFICATION ..... 5**

*Figure 2..... 5*

**WELDING PARAMETERS ..... 6**

*Figure 1..... 6*

*Figure 3..... 6*

Copyright © JnF Specialties, LLC. All rights reserved worldwide. [www.jnfspecialties.com/about-us/copyright](http://www.jnfspecialties.com/about-us/copyright)

Copyright © JnF Specialties, LLC. All rights reserved worldwide.

|         |     |      |       |                  |
|---------|-----|------|-------|------------------|
| Your Co | REV | CAGE | DOC#: | 2 of 2<br>Your # |
|---------|-----|------|-------|------------------|

**1.0 APPLICATION**

This welding procedure is valid using conditions and variables outside the ranges listed in SAE-AMS-STD-2219 at paragraph 5.3.2 for Class B welds. The following paragraphs of SAE-AMS-STD-2219 have been tailored to fit the application stated herein:

5.2.3 Fit-up; 5.3.5.3 tack-welds; 5.4.2.1 penetrant test; and 5.4.3.2 weld penetration.

**MODIFICATIONS:**

5.2.3

5.3.5.3

5.4.2.1

5.4.3.2

SAE-AMS-STD-1595 identifies minimum and maximum metal thickness range for application of this weld procedure. Metal thickness ranges outside the qualified limits require

This procedure does not address all of the safety problems associated with its use. It is the responsibility of Your Co to establish appropriate safety and health practices. The user needs a significant knowledge of welding, and must be certified IAW

**2.0 REFERENCED DOCUMENTS (to the extent specified herein)**

- 2.1 SAE-AMS-STD-2219, Fusion Welding for Aerospace Applications, Modified
- 2.2 AWS A2.4, Standard Symbols for Welding, Brazing and Nondestructive Examination
- 2.3 SAE-AMS-STD-1595, Qualification of Aircraft, Missile and Aerospace Fusion Welders
- 2.4 Your #, Manufacturing Control Document,
- 2.5 AWS A5.9, Filler Metal Specification
- 2.6 ASTM A 480 A/480M, Steel Plate, Sheet and Strip Specification
- 2.7 ASTM A167, Stainless and Heat Resisting Chromium-Nickel Steel Plate, Sheet and Strip

**3.0 SUPPORTING DOCUMENT**

- 3.1 AWS A3.0, Standard Welding Terms and Definitions

**4.0 APPLICABLE DOCUMENTS (incorporated herein)**

- 4.1 Welding Procedure Qualification Test Record
- 4.2 Welding Procedure Specification

|         |     |      |        |        |
|---------|-----|------|--------|--------|
| Your Co | REV | CAGE | DOC#:  | 3 of 3 |
|         |     |      | Your # |        |

This document may not be disclosed or reproduced in whole or in part without prior written permission from a representative of the Company with the authority to grant such permission.

## WELDING PROCEDURE QUALIFICATION TEST RECORD

MATERIAL SPECIFICATION:

[REDACTED]

WELDING PROCESS:

GTAW

MANUAL or MACHINE:

[REDACTED]

[REDACTED]

RADIOGRAPHIC EXAM NO:

FILLER METAL CLASS:

ER 308L

SHIELDING GAS:

[REDACTED]

[REDACTED]

WELDER'S NAME:

### VISUAL INSPECTION (Class B inspector)

APPEARANCE:

[REDACTED]

UNDERCUT:

[REDACTED]

TEST DATE:

WITNESSED BY:

### WELDING PROCEDURE

PASS NO:

[REDACTED]

[REDACTED]

Copyright © JnF Specialties, LLC. All rights reserved worldwide. [www.jnfspecialties.com/about-us/copyright](http://www.jnfspecialties.com/about-us/copyright)

|         |     |      |       |        |        |
|---------|-----|------|-------|--------|--------|
| Your Co | REV | CAGE | DOC#: | Your # | 4 of 4 |
|---------|-----|------|-------|--------|--------|

## WELDING PROCEDURE SPECIFICATION

PROCESS:

[REDACTED]

BASE METAL:

Type 304L, Group IIA  
0.015"/0.018" nominal

BASE METAL THICKNESS RANGE:

WELD METAL THICKNESS RANGE:

BACKING:

[REDACTED]

[REDACTED]

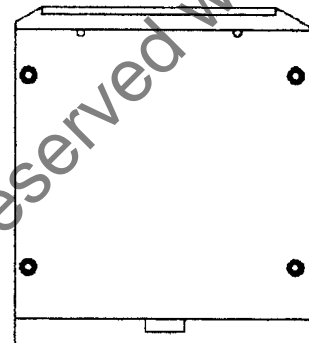


FIGURE 2

SINGLE OR MULTIPLE ELECTRODE:

Single

SINGLE OR MULTIPLE PASS:

[REDACTED]

[REDACTED]

[REDACTED]

TARGET AMPERES:

[REDACTED]

7

|         |     |      |       |        |        |
|---------|-----|------|-------|--------|--------|
| Your Co | REV | CAGE | DOC#: | Your # | 5 of 5 |
|---------|-----|------|-------|--------|--------|

### WELDING PARAMETERS:

Figure 1

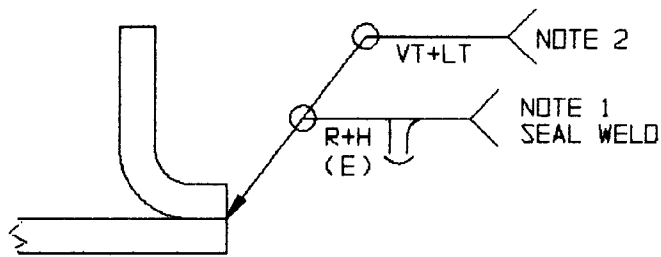
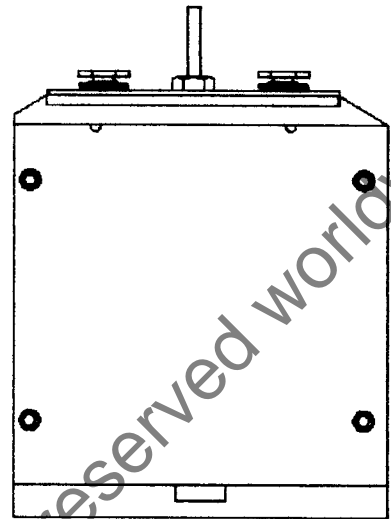


FIGURE 3



NOTE 1)

[REDACTED]

NOTE 2)

[REDACTED]

NOTE:

[REDACTED]

|         |     |      |       |        |        |
|---------|-----|------|-------|--------|--------|
| Your Co | REV | CAGE | DOC#: | Your # | 6 of 6 |
|---------|-----|------|-------|--------|--------|