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

EDGE JOINT-2

Mo/Yr

Revisions		Rev:	
Letter	E.O. Number - Description		Date

Used On	Contract#:		**Your Co**					
Prepared By:								
Your Dept:								
Your Dept:			**WELDING PROCEDURE**					
Your Dept:			Your #					
Your Dept:			Size:	**A**	CAGE:		Form Rev: Orig	1 of 1

Your Logo

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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; 5.4.2.1 penetrant test; and 5.4.3.2 weld penetration.

MODIFICATION:
5.2.3 Fit-up tolerance is controlled by tooling
5.4.2.1 Penetrant testing is not performed
5.4.3.2 Penetration is not complete

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 [redacted] This procedure does not address [redacted] The user needs a significant knowledge of welding, and must be certified IAW [redacted]

2.0 REFERENCED DOCUMENTS (to the extent specified herein)

2.1 SAE-AMS-STD-2219, Fusion Welding for Aerospace Applications, Modified
2.2 AWS A 2.4, Standard Symbols for Welding, Brazing and Nondestructive Exam.
2.3 SAE-AMS-STD-1595, Qualification of Aircraft, Missile and Aerospace Fusion Welders
2.4 Your #, Manufacturing Control Document
2.5 MIL-T-8606, Tubing Specification
2.6 AWS A 5.9, Filler Metal Specification

3.0 SUPPORTING DOCUMENT

3.1 AWS A 3.0, Standard Welding Terms and Definitions

4.0 APPLICABLE DOCUMENTS (incorporated herein)

4.1 Welding Procedure Qualification Test Record
4.2 Welding Procedure Specification

WELDING PROCEDURE QUALIFICATION TEST RECORD

MATERIAL SPECIFICATION: SS 304L, MIL-T-8606, Group IIA

WELDING PROCESS: [redacted]

RADIOGRAPHIC EXAM NO:

FILLER METAL CLASS: ER308L

SHIELDING GAS: Argon, 25 CFH

SINGLE or MULTIPLE PASS: [redacted]

WELDER'S NAME:

POSTHEAT TREATMENT: N/A

VISUAL INSPECTION (Class B Inspector)

APPEARANCE: [redacted]

UNDERCUT: [redacted]

TEST DATE:

WITNESSED BY:

WELDING PROCEDURE

PASS NO: [redacted]

WELDING PROCEDURE SPECIFICATION

PROCESS:	[redacted]
BASE METAL:	[redacted]
BASE METAL THICKNESS RANGE:	0.020"/0.120"
WELD METAL THICKNESS RANGE:	[redacted]
INTERPASS TEMPERATURE:	N/A
POSTWELD HEAT-TREATMENT:	N/A
TECHNIQUE:	[redacted]
GAS:	Argon, industrial grade; Gas nozzle size: #7 with lens; Flow rate: 25-30 CFH

WELDING PARAMETERS

CURRENT:	[redacted]

WELDING PARAMETERS:

Figure 1

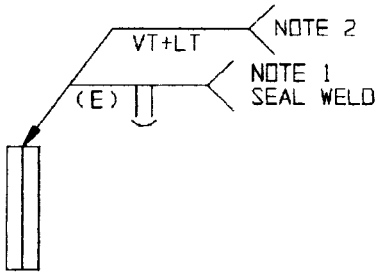
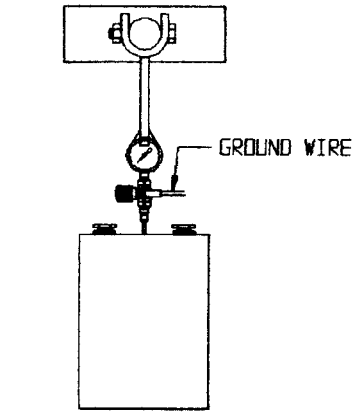
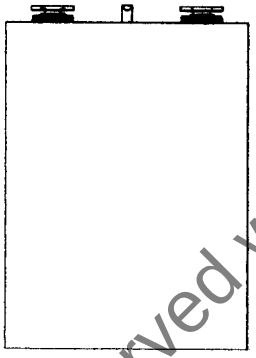


FIGURE 2:



NOTE: ISOLATE CELL CASE FROM TABLE

FIGURE 3:



NOTE 1) [redacted]

NOTE 2) [redacted]

LT IAW Your #

NOTE 3) [redacted]

NOTE: [redacted]