

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

Add to Cart

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

SQUARE-GROOVE WELD 3 PIECE "T" JOINT

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: <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 C inspector) 4

WELDING PROCEDURE..... 4

WELDING PROCEDURE SPECIFICATION..... 5

Figure 2..... 5

WELDING PARAMETERS:..... 6

Figure 1..... 6

Copyright © JnF Specialties, LLC. All rights reserved worldwide. www.jnfspecialties.com/about-us/copyright

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

Your Co	REV	CAGE	DOC#:	2 of 2 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 C welds. The following paragraphs of SAE-AMS-STD-2219 have been tailored to fit the application stated herein:

5.2.3 fit-up; 5.4.1 visual inspection; 5.4.2.1 penetrant test; 5.4.3.2 weld penetration; 5.4.4.1 incomplete fusion; and Table 5-4 thinnest member.

MODIFICATIONS:

5.2.3

5.4.1

5.4.2.1

5.4.3.2

5.4.4.1

Table 5-4

SAE-AMS-STD-1595 identifies minimum and maximum metal thickness ranges 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 ASTM B 160, Nickel Sheet, Rod and Bar

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

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

WELDING PROCEDURE QUALIFICATION TEST RECORD

MATERIAL SPECIFICATION:

ASTM B 160, Group IIIA

WELDING PROCESS:

[REDACTED]

[REDACTED]

RADIOGRAPHIC EXAM NO:

FILLER METAL CLASS:

ERNi-1 Alloy 61

SHIELDING GAS:

Argon, 60 CFH

SINGLE OR MULTIPLE PASS:

[REDACTED]

[REDACTED]

WELDER'S NAME:

VISUAL INSPECTION (Class C inspector)

APPEARANCE:

UNDERCUT:

[REDACTED]

[REDACTED]

TEST DATE:

WITNESSED BY:

WELDING PROCEDURE

PASS NO:

1

ELECTRODE SIZE:

[REDACTED]

[REDACTED]

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

WELDING PROCEDURE SPECIFICATION

PROCESS:

GTAW, manual

BASE METAL:

BACKING:

N/A

BACKING MATERIAL:

N/A

ALLOWABLE JOINT DESIGN:

SINGLE OR MULTIPLE ELECTRODE:

Single

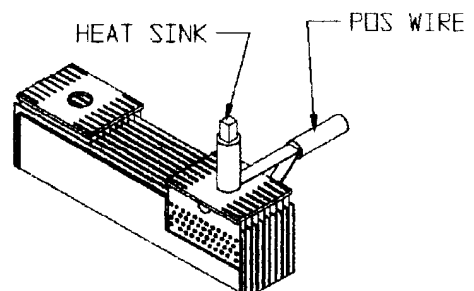
SINGLE OR MULTIPLE PASS:

Optional

FILLER METAL SPECIFICATION:

reserved worldwide.

FIGURE 2:

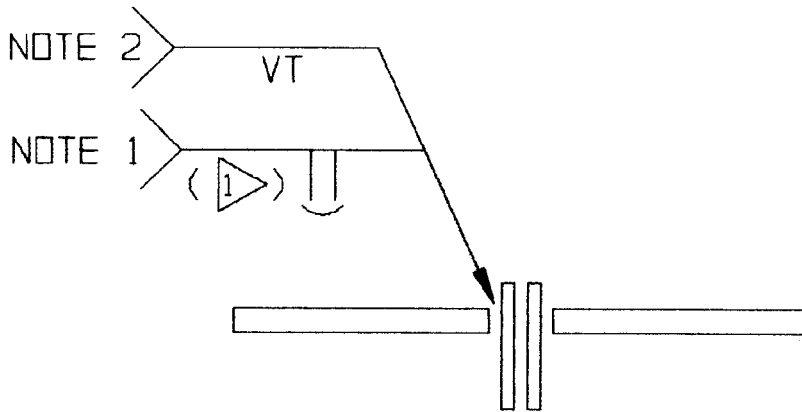


Your Co	REV	CAGE	DOC#:	Your #	5 of 5
---------	-----	------	-------	--------	--------

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 PARAMETERS:

Figure 1



NOTE 1)

[REDACTED]

NOTE 2)

[REDACTED]

NOTE:

[REDACTED]

Copyright © JnF Specialties, LLC. All rights reserved worldwide. www.jnfspecialties.com/about-us/copyright

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