

PREPARED BY. L. LUNDSTROM

APPROVED BY: H. HINKLEY

11/5/79

SEABROOK PROJECT PROCEDURE

TO BE USED
ONLY ON JOB #

7035

PAGE NO. 1 OF 3

LATEST REV. DATE
8/26/80

WELD MONITORING PROCEDURE

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PULLMAN POWER PRODUCTS

DIVISION OF ROLLMAN INCORPORATED

HEADQUARTERS AT

TRANSPORT, PENN' SVLVANIA

UE&C
CODE

04

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Pullman Power Products

Division of Pullman Incorporated

X-10

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1.0 SCOPE

- 1.1 The requirements of this document are applicable to all field welding activities performed by the Company (Pullman Power Products).

2.0 PURPOSE

- 2.1 This document establishes the method by which the parameters and techniques required by a Weld Procedure Specification (WPS) will be monitored and documented during production welding.
- 2.2 The monitoring program is intended to ensure that the parameters and techniques proven by Procedure and Welder Qualification are carried over into production work.

3.0 RESPONSIBILITY

- 3.1 The QA Manager shall be responsible for implementing the requirements of this document through QC inspection personnel.

4.0 CALIBRATED EQUIPMENT

- 4.1 Voltmeters, ammeters, tong testers, In-Line Volt/AMP Meter, and pyrometers used during weld monitoring shall be calibrated in accordance with Project Procedure XII-2.

5.0 MONITORING

- 5.1 Surveillance activities, on items covered in paragraph 2.0 of this document shall be performed on production welding daily by the responsible Q.C. Welding Inspector. This surveillance need not be documented, except when discrepancies are found in the parameters and techniques used. Then the Weld Monitoring Record in Appendix "A" shall be used to document the discrepancy. Disposition of the discrepancy shall be handled in accordance with paragraphs 5.3.1 and 5.3.2 of this document.
- 5.2 A documented monitoring activity shall be performed on each welder who has welded at anytime during a calendar month. Monitoring shall be documented using the "Weld Monitoring Record" which shall be completed by the responsible Q.C. Welding Inspector and forwarded to the Q.C. Supervisor for review.



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5.0 Monitoring (Cont'd)

5.3 If a parameter or technique is found to be outside the limits prescribed by the WPS, the discrepancy shall be resolved by the QC Supervisor in the following manner.

5.3.1 If it is determined by the QA Welding Engineer that the discrepancy may have had a detrimental effect on the quality of the weld, Procedure XV-2 shall be utilized.

A. A review of the welds made by the welder for whom the discrepancy was found shall be made on welding performed subsequent to the last Weld Monitor Record on file for him. The welds shall be evaluated by any records available or by the appropriate N.D.E. method. Disposition of these welds shall be made by the QA Welding Engineer and a report placed on file of his findings.

5.3.2 If it is determined that the discrepancy had little or no effect upon the quality of the weld, it shall be brought to the attention of the responsible foreman and welder.

A. Corrective action shall be noted in the "Comments" section of the Weld Monitoring Record.

B. The Welding Activity shall be monitored more frequently as required by the QC Supervisor.

C. If a particular welder or piece of equipment is repeatedly found to be out of compliance with the applicable requirements, the QA Manager may, at his option, require that the welder be retested or the equipment be removed from service.

6.0 REVIEW

6.1 Each month the QC Supervisor shall review with the QA Manager the Weld Monitoring Records submitted during the previous month.

7.0 RECORDS

7.1 Completed Weld Monitoring Records shall be retained by the QA Engineer - Records. At the end of the project these documents shall be destroyed.



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Revised 3/5/80

WELD MONITORING RECORD

SF 10.5
Pullman Power Products
Seabrook Station
Job 7035

Welder: _____ Symbol: _____ Date _____
ISO Dwg. No. _____ Field Weld No. _____ WPS _____
Base Metal: _____ Process: _____ Polarity: _____
Welding Machine Type: _____ Serial No.: _____
Filler Metal Type: _____ Size _____
Preheat: _____ °F. Interpass Temp _____ °F.
Method of Interpass Verification: _____
Shield Gas: _____ PH Purge Gas: _____ CFH
Voltage: _____ Amperage: _____
Volt/Amp Meter ID # and Calibration Due Date: _____
Pyrometer ID # and Calibration Due Date: _____
Travel Speed _____ IMP
* Heat Input _____
Bead width: _____
Other (Specify): _____

Comments:

*Volt x Amp. x 60 ÷ Travel Speed = Joules per in
MONITORING PERFORMED BY:

REVIEWED BY:

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