|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| **SILVER BRAZE FABRICATION & INSPECTION RECORD**  QA FORM 18 (Work planning to fill in blocks/evaluate block options identified by a **♦** prior to release) | PAGE |  | OF |  |
| ♦1. SHIP | **♦**HULL NO. | **♦**2. JCN | **♦**3. LWC / SHOP | **♦**4. CWP / REC SER NO. | **♦**5. SYSTEM / COMPONENT |
| **♦**6. PURPOSE: | [ ]  PRODUCTION | [ ]  QUAL | **♦**7. INSTALLATION DWG. | **♦**8. JOINT ID/DESCRIPTION |
| [ ]  RE-QUAL | [ ]  MAINTENANCE OF QUAL |  |  |
| ♦9. JOB DESCRIPTION | **♦**10. MAP JOINT DWG | **♦**11. [ ]  P-3A SPECIAL  |
|  |  |  [ ]  P-3A [ ]  P-3B |
| **♦**12. BRAZE PROC. |  **♦**13. BRAZE PROCESS[ ]  H101 [ ]  H103[ ]  NA | 14. JOINT DESIGN | [ ]  SOCKET [ ]  SLEEVE[ ]  FACE FEED[ ]  SINGLE INSERT | [ ]  DOUBLE INSERT[ ]  EQUAL LAND[ ]  UNEQUAL LAND | 15. ACCESS[ ]  RESTRICTED (<4”)[ ]  UNRESTRICTED |  16. [ ]  ORIGINAL  [ ]  REPAIR (1) [ ]  REPAIR (2) |
| 17. FITTING, PIPE, AND TUBE MATERIALS |
| **♦**DWG PC NO. | **♦**SIZE | THICKNESS | **♦**MIL-SPEC | **♦**P-NUMBER | **♦**NEW OR EXIST | IDENT (E.G., MIC NO./NSN/TRACEABILITY NO.) |
|  |  |  |  |  | [ ]  NEW[ ]  EXISTING |  |
|  |  |  |  |  | [ ]  NEW[ ]  EXISTING |  |
| 18. LANDWIDTH | PIPE | FITTING  | CENTER | SOCKET DEPTH | 19. FLUX | ♦ [ ]  MINIMUM FLUX  |
| FED SPEC O-F-499: | [ ]  TYPE A | [ ]  TYPE B |
| 20. BRAZE ALLOY | MIL-SPEC  | F- NUMBER | GRADE | IDENT (E.G., MIC NO./NSN/TRACEABILITY NO.) |
| INSERT RING |  |  |  |  |
| ROD |  |  |  |  |
| **JOINT DATA IS CORRECT, JOINT AND MATERIAL MEETS SPECIFIED REQUIREMENTS**  | 21. CRAFTSMAN SIGNATURE/BADGE | DATE |
|  |  |
| 22. INSPECTION TYPE | 23. ACCEPT | 24. REJECT | 25. SIGNATURE (Inspector/Craftsman) | BADGE NO. | DATE |
| NDT EXISTING PPG[ ]  NOT REQD | [ ]  VT5X[ ]  PT  |  |  |  |  |  |
| NDT EXISTING FTG[ ]  NOT REQD | [ ]  VT5X[ ]  PT |  |  |  |  |  |
| DIAMETRICAL CLEARANCE |  |  |  |  |  |  |
| FIT UP INSPECTION |  |  |  |  |  |
| ALLOY DRAW |  |  |  |  |  |
| EVIDENCE OF ALLOY |  |  |  |  |  |
| BOTTOM CLEARANCE |  |  |  |  |  |
| 26. BRAZED POSITION[ ] VERT [ ] HORZ | **BRAZING REQUIREMENTS ARE SATISFACTORY** | 27. BRAZER SIGNATURE/BADGE NO. | DATE |
|  |  |
| ♦28. [ ]  **NO. UT INSPECTION REQUIRED** | NDT PROCEDURE NO. | ACCEPTANCE STANDARD: |
|  (NON P-3 A SPECIAL) |  | NAVSEA 0900-LP-001-7000 |
| 29. SCANNING METHOD  | 30. EQUIPMENT MFG. |  MODEL | SERIAL NO. |  CAL DUE DATE |
| [ ]  STATIC [ ]  CONTINUOUS |  |  |  |  |
| 31. TRANSDUCER MFG. |  SIZE TYPE |  SERIAL NO. |  FREQUENCY | 32. COUPLANT TYPE |
| 33. LAND | 1 | 2 | 3 | 4 | 5 | 6 | 7 | 8 | 9 | 10 | 11 | 12 | 13 | 14 | TOT. | AVG. |
| PPG |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| MID |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| FTG |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |  |
| 34. TOTAL % BOND | 35. DISPOSITION | 36. UT INSPECTOR/BADGE | DATE |
|  | [ ]  ACCEPT [ ]  REJECT |  |  |
| 37. REMARKS **(SHOP REMARKS ALSO)** |
| FINALDISPOSITION | 38. SUPERVISOR (Signature / Badge / Date) | 39. WCS (QAS For SUBSAFE/SOC Only) (Signature / Badge / Date) |