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| **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. LAND  WIDTH | | 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) | | | | | | | | | | | | | | | | | | | | | | | |