###### WELDING IN PROCESS CONTROL/NONDESTRUCTIVE TEST RECORD

QA FORM 20 (FRONT)

When the form is used for production welding, the blocks marked with a

◆ must be completed by the planner. ◆1. PAGE 1 OF \_\_\_

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| ◆2. SHIP  HULL NO. | | | | ◆3. JCN | | | | ◆4. CWP/REC SER. NO. | | | | | | | | | ◆5. LWC | | | | ◆6. DATE |
| ◆7. SYSTEM | | | | ◆8. COMPONENT | | | | ◆9. DWG NO. | | | | | | | | | ◆10. CWP STEP NO. | | | | |
| ◆11. JOINT ID | | | | | ◆12. JOINT DESIGN | | | | | | | | 13. INST LOCATION: [ ] STBD  COMPT: [ ] C/L  FR: [ ] PORT | | | | | 14. WELDED LOCATION:  [ ] SHOP  [ ] FIELD | | | |
| **BASE MATERIAL DATA** | | | | | | | | | | | | | | | | | | | | | |
| 15. COMP DATA | | 16. MATERIAL | | | | | 17. SIZE | | | | 18. THICKNESS | | | | | 19. MATL SPEC | | 20. MIC NO. | | | |
| COMPONENT A: | |  | | | | |  | | | |  | | | | |  | |  | | | |
| COMPONENT B: | |  | | | | |  | | | |  | | | | |  | |  | | | |
| 21. [ ] SEAL RING  [ ] BACK RING/STRIP | | 22. MATERIAL | | | | | 23. SIZE | | | | 24. THICKNESS | | | | | 25. MATL SPEC | | 26. MIC NO. | | | |
| **WELDING MATERIAL SPECIFICATIONS AND DATA** | | | | | | | | | | | | | | | | | | | | | |
| 27. TYPE OF FILLER(S) | | | | 28. SIZE | | | | | | 29. MATL | | | | | | 30. MIL-SPEC | | | 31. MIC NO. | | |
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| **WELD HISTORY** | | | | | | | | | | | | | | | | | | | | | |
| ◆32. WELDING  STANDARD: | | 33. WELDING  PROCEDURE: | | | 34. DATA SHEET | | | 35. POSITION: [ ] VERT [ ] FLAT [ ] FIXED [ ] 45 DEG  [ ] HORZ [ ] OVHD [ ] ROLLED | | | | | | | | | | | | | |
| 36. ACCESSIBILITY:  [ ] 12”OR LESS  [ ] UNRESTRICTED | | 37. PREHEAT TEMP | | | | | 38. PREHEAT METHOD | | | | | | | 39. POST HEAT. START TIME:  TEMP REQD: STOP TIME: | | | | | | | |
| 40. PURGE GAS: | 41. FLOW RATE | | | 42. SHIELD GAS | | | | 43. FLOW RATE | | | | | 44. CUP SIZE | | | | 45. TUNGSTEN SIZE | | | | |
| 46. WELD LAYER | | | 47. PROCESS | | | 48. QUAL EXP DATE | | | 49. AMPS | | | 50. INTERPASS TEMP | | | 51. WELDER SIGNATURE | | | | | 52. DATE | |
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| 53. INSPECTION DATA CONTAINED ON REVERSE OF THIS PAGE  REMARKS: | | | | | | | | | | | | | | | | | | | | | |
| 94. FINAL DISPOSITION:  [ ] ACCEPT  [ ] REJECT | | | | | | 95. NDT SUPERVISOR | | | | | | DATE | | | | | | | | | |

**WELDING IN PROCESS CONTROL/NONDESTRUCTIVE TEST RECORD**

QA FORM 20 (BACK) PAGE \_\_OF\_\_\_

|  |  |  |  |  |  |  |  |  |
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| **NDT INSPECTION DATA** | | | | | | | | |
| 54. INSPECTION STANDARD | | 55. WELD CLASS | | 56. ACCEPTANCE STANDARD | | | 57. ACCEPT CLASS | |
| 58. WELD PREP | 59. INSP METHOD | 60. ACCEPT/REJECT | | 61. NDT INSPECTOR SIGNATURE | | | | 62. DATE |
| COMPONENT A |  | [ ] ACCEPT [ ] REJECT | |  | | | |  |
| COMPONENT B |  | [ ] ACCEPT [ ] REJECT | |  | | | |  |
| 63. JOINT FITUP |  | [ ] ACCEPT [ ] REJECT | |  | | | |  |
| 64. INSP LAYER | 65. INSP METHOD | 66. INSP PROC NO | | 67. ACCEPT/REJECT | | 68. NDT INSPECTOR SIGNATURE | | 69. DATE |
|  |  |  | | [ ] ACCEPT [ ] REJECT | |  | |  |
|  |  |  | | [ ] ACCEPT [ ] REJECT | |  | |  |
|  |  |  | | [ ] ACCEPT [ ] REJECT | |  | |  |
|  |  |  | | [ ] ACCEPT [ ] REJECT | |  | |  |
|  |  |  | | [ ] ACCEPT [ ] REJECT | |  | |  |
| 70. NDT INSPECTION DATA REPAIR NO.\_\_\_\_\_ Defect: L W D | | | | | | | | |
| 71. Repair Method: Excavation: L W D | | | | | | | | |
| 72. INSP LAYER | 73. INSP METHOD | 74. INSP PROC NO. | 75. ACCEPT/REJECT | | 76. NDT INSPECTOR SIGNATURE | | | 77. DATE |
|  |  |  | [ ] ACCEPT [ ] REJECT | |  | | |  |
|  |  |  | [ ] ACCEPT [ ] REJECT | |  | | |  |
| 78. NDT INSPECTION DATA REPAIR NO.\_\_\_\_\_ Defect: L W D | | | | | | | | |
| 79. Repair Method: Excavation: L W D | | | | | | | | |
| 80. INSP LAYER | 81. INSP METHOD | 82. INSP PROC NO. | 83. ACCEPT/REJECT | | 84. NDT INSPECTOR SIGNATURE | | | 85. DATE |
|  |  |  | [ ] ACCEPT [ ] REJECT | |  | | |  |
|  |  |  | [ ] ACCEPT [ ] REJECT | |  | | |  |
| 86. NDT INSPECTION DATA REPAIR NO.\_\_\_\_\_ Defect: L W D | | | | | | | | |
| 87. Repair Method: Excavation: L W D | | | | | | | | |
| 88. INSP LAYER | 89. INSP METHOD | 90. INSP PROC NO. | 91. ACCEPT/REJECT | | 92. NDT INSPECTOR SIGNATURE | | | 93. DATE |
|  |  |  | [ ] ACCEPT [ ] REJECT | |  | | |  |
|  |  |  | [ ] ACCEPT [ ] REJECT | |  | | |  |
| 53. REMARKS (Continued): | | | | | | | | |