###### 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 \_\_\_

|  |  |  |  |  |
| --- | --- | --- | --- | --- |
| ◆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. |
|  |  |  |  |  |
|  |  |  |  |  |
|  |  |  |  |  |
| **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 |
|  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |
| 53. INSPECTION DATA CONTAINED ON REVERSE OF THIS PAGEREMARKS: |
| 94. FINAL DISPOSITION: [ ] ACCEPT [ ] REJECT | 95. NDT SUPERVISOR | DATE |

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

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

|  |
| --- |
| **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): |