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| **STRUCTURAL WELD HISTORY** QA FORM 20B (PART B) (FRONT)  **(Planning shall fill in blocks identified by a prior to issuing)** | | | | | | | | | | | | | | | 1. JOINT NO. | | | | | 2. LWC/SHOP: | | | | | | 3. SHEET OF | |
|  | | | | |  | | | | | |
| 4. SHIP HULL NO. | | | | | | | | | | 5. JCN | | | | | | | | | | 6. CWP/REC: | | | | | | | |
|  | | | | | | | | | |  | | | | | | | | | | YES  NO | | | | | | | |
| **7. REFERENCES** | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| A. |  | | | | | | | | | B. | |  | | | | | | | | C. |  | | | | | | |
| **JOINT IDENTIFICATION** | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 8. COMPONENT NUMBER 1 | | | | | | | | | | 9. COMPONENT NUMBER 2 | | | | | | | | | | 10. WELD INFO | | | | | | | |
| REF | | PC  NO. | | | MATL  TYPE | | MATL  THICK | | | REF | | | PC  NO. | MATL  TYPE | | | MATL  THICK | | | JOINT  DESIGN | | | WELD  SIZE | | REMARKS | | |
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| 11. REMARKS | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 12. NEW MATERIAL: MATL DOCUMENTATION REQUIRED Y N CRAFTSMAN/QAI: ENTER TRACEABLE MATERIAL MARKING (E.G., MIC NO., TCSM NO., HEAT NO., OR OTHER) FOR THE PIECE NUMBER (PC NO.) BELOW, UNLESS USE OF EXISTING MATERIAL IS SPECIFIED. | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| REF | | PC NO. | | | | | TRACEABLE MATL MARKING | | | | | | | | | | | | | CRAFTSMAN/QAI: MATERIAL VERIFICATION (SIGNATURE/BADGE/DATE) | | | | | | | |
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| **WELD HISTORY** | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 13. WELD PROCEDURE, REV.,  CH, AND TECHNIQUE SHEETS: | | | | | | | |  | | | | | | | | | | | | 14. MIN  PREHEAT: | | | |  | | 15. MAX  INTERPASS: |  |
| 16. WELD FILLER MATERIAL (WELDER) ENTER TRACEABLE FILLER MARKING (MIC NO.) | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| LETTER | | | GRADE/TYPE | | | | MIC NO. | | | | | | | | | LETTER | | GRADE/TYPE | | | | MIC NO. | | | | | |
| A | | |  | | | |  | | | | | | | | | C | |  | | | |  | | | | | |
| B | | |  | | | |  | | | | | | | | | D | |  | | | |  | | | | | |
| 17. FITUP SAT: CRAFTSMAN/QAI (SIGNATURE/DATE) | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 18. PHASE LETTER KEY: F=BUILDUP OF BASE MATERIAL FOR FIT-UP; W=TACKING OR WELDING JOINT; BG=BACKGOUGE WORKMANSHIP SAT. (VERIFY BG NDT PRIOR TO WELD IF REQD) | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 19. PHASE LETTER | | | | 20. FILLER LETTER | | 21. PREHEAT & INTERPASS TEMP | | | | | 22. WELDER & WELD WORKMANSHIP  (WELDER SIGNATURE/BADGE/DATE) | | | | | | | | | | | 23. REMARKS | | | | | |
|  | | | |  | | SAT | | | | |  | | | | | | | | | | |  | | | | | |
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| SEE STRUCTURAL WELD HISTORY CONTINUATION SHEET | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 24. WELDING COMPLETE | | | | | | | | | WELDER (SIGNATURE/DATE) | | | | | | | | | | | | | | | | | | |
| 25. JOINT IS AT AMBIENT TEMP | | | | | | | | | WELDER (SIGNATURE/BADGE/DATE) | | | | | | | | | | | | | MILITARY TIME  AT AMBIENT TEMP: | | | | | |
| 26. JOINT IS COMPLETE AND READY FOR FIN AL NDT | | | | | | | | | CRAFTSMAN/CRAFTSMAN SUPERVISOR (SIGNATURE/BADGE/DATE) | | | | | | | | | | | | | | | | | | |
| **REQUIRED NDT** | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 27. REQD NDT (TYPE, WAIT TIME, & PHASE) | | | | | 28. NDT & ACCEPTANCE PROCEDURE, REV, CH | | | | | | 29. NDT RPT/EQPT (FOR ET OR MT, RECORD SERIAL # OF MANF & MODEL NO.) (FOR MT BY YOKE, ENTER “YOKE”). FOR PT, ENTER TYPE OF LIQUID PENETRANT, FOR RT/UT, ENTER REPORT # | | | | | | | | 30. RESULTS  A OR R  (NOTE 1) | | | 31. INSPECTOR (SIGNATURE/DATE) | | | | | |
| MT EXCAV  (NOTE 2) | | | | |  | | | | | | ENTRY NOT REQUIRED | | | | | | | |  | | |  | | | | | |
| MT BACKGOUGE (NOTE 2) | | | | |  | | | | | | ENTRY NOT REQUIRED | | | | | | | |  | | |  | | | | | |
| MT EVERY LAYER (NOTE 2&3) | | | | |  | | | | | | ENTRY NOT REQUIRED | | | | | | | |  | | |  | | | | | |
| VT FINAL | | | | |  | | | | | | NA | | | | | | | |  | | |  | | | | | |
| RT 8 HR FINAL | | | | |  | | | | | |  | | | | | | | |  | | |  | | | | | |
| UT 8 HR FINAL | | | | |  | | | | | |  | | | | | | | |  | | |  | | | | | |
| MT AMBIENT FINAL | | | | |  | | | | | |  | | | | | | | |  | | |  | | | | | |

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| **QA FORM 20B (PART B) (BACK)** | | | | | |
| **REQUIRED NDT (CONT.)** | | | | | |
| 27. REQD NDT (TYPE, WAIT TIME, & PHASE) | 28. NDT & ACCEPTANCE PROCEDURE, REV, CH | 29. NDT RPT/EQPT (FOR ET OR MT, RECORD SERIAL # OF MANF & MODEL NO.) (FOR MT BY YOKE, ENTER “YOKE”). FOR PT, ENTER TYPE OF LIQUID PENETRANT, FOR RT/UT, ENTER REPORT # | | 30. RESULTS  A OR R  (NOTE 1) | 31. INSPECTOR (SIGNATURE/BADGE/DATE) |
| MT 24 HR FINAL |  |  | |  |  |
| MT 7 DAY FINAL |  |  | |  |  |
| PT FINAL |  |  | |  |  |
| MTAH FINAL |  |  | |  |  |
| ET FINAL |  |  | |  |  |
| ETAH FINAL |  |  | |  |  |
|  |  |  | |  |  |
| NOTE 1: ANY WORK & FINAL NDT INSPECTIONS TO RESOLVE DOCUMENTED REJECTS ON THIS RECORD MUST BE DOCUMENTED ON PART C RECORDS UNLESS NOTE 2 IS INVOKED IN BLOCK 27. DEFECTS REMOVED IN-PROCESS OF ANY VT, MT, OR PT DO NOT HAVE TO BE DOCUMENTED ON A PART C RECORD.  NOTE 2: DEFECTS DO NOT HAVE TO BE DOCUMENTED. A PART C RECORD IS NOT REQUIRED. CERTIFY AFTER ALL DEFECTS ARE REPAIRED AND THE NDT IS SATISFACTORY.  NOTE 3: MT EVERY LAYER SIGNIFIES MT INSPECTION AFTER DEPOSITION OF EACH LAYER, OR 3/8 INCH THICKNESS, WHICHEVER IS GREATER. | | | | | |
| 32. REMARKS | | | | | |
| FINAL  DISPOSITION | 33. WELD SUPERVISOR (SIGNATURE/BADGE/DATE) | | 34. (SUBSAFE/SOC) QAS: (SIGNATURE/BADGE/DATE) | | |

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| **STRUCTURAL WELD HISTORY CONTINUATION SHEET** QA FORM 20B (PART B) | | | | | | | | | 1. JOINT NO. | | | | | 3. SHEET OF | | |
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| 4. SHIP HULL NO. | | | | | | 5. JCN | | | 6. CWP/REC: | | | | | | | |
|  | | | | | |  | | | YES  NO | | | | | | | |
| **WELD HISTORY** | | | | | | | | | | | | | | | | |
| 13. WELD PROCEDURE, REV., CH, AND TECHNIQUE SHEETS:  SAME AS ORIGINAL | | | | |  | | | | | | 14. MIN  PREHEAT: | |  | | 15. MAX  INTERPASS: |  |
| 16. WELD FILLER MATERIAL (WELDER) ENTER TRACEABLE FILLER MARKING (MIC NO.) | | | | | | | | | | | | | | | | |
| LETTER | GRADE/TYPE | | | MIC NO. | | | | LETTER | | GRADE /TYPE | | MIC NO. | | | | |
| A |  | | |  | | | | C | |  | |  | | | | |
| B |  | | |  | | | | D | |  | |  | | | | |
| 18. PHASE LETTER KEY: F=BUILDUP OF BASE MATERIAL FOR FIT-UP; W=TACKING OR WELDING JOINT; BG=BACKGOUGE WORKMANSHIP SAT. (VERIFY BG NDT PRIOR TO WELD IF REQD) | | | | | | | | | | | | | | | | |
| 19. PHASE LETTER | | 20. FILLER LETTER | 21. PREHEAT & INTERPASS TEMP | | | | 22. WELDER & WELD WORKMANSHIP  (WELDER SIGNATURE/DATE) | | | | | 23. REMARKS | | | | |
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| SEE STRUCTURAL WELD HISTORY CONTINUATION SHEET | | | | | | | | | | | | | | | | |
| 32. REMARKS | | | | | | | | | | | | | | | | |