|  |  |  |  |
| --- | --- | --- | --- |
| **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 | PCNO. | MATLTYPE | MATLTHICK | REF | PCNO. | MATLTYPE | MATLTHICK | JOINTDESIGN | WELDSIZE | REMARKS |
|  |  |  |  |  |  |  |  |  |  |  |
|  |  |  |  |  |  |  |  |  |  |  |
| 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) |
|  |  |  |  |
|  |  |  |  |
| **WELD HISTORY** |
| 13. WELD PROCEDURE, REV., CH, AND TECHNIQUE SHEETS: |  | 14. MINPREHEAT: |  | 15. MAXINTERPASS: |  |
| 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 |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
| [ ]  SEE STRUCTURAL WELD HISTORY CONTINUATION SHEET |
| 24. WELDING COMPLETE | WELDER (SIGNATURE/DATE) |
| 25. JOINT IS AT AMBIENT TEMP | WELDER (SIGNATURE/BADGE/DATE) | MILITARY TIMEAT 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. RESULTSA 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 |  |  |  |  |

|  |
| --- |
| **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. RESULTSA 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 |
| FINALDISPOSITION | 33. WELD SUPERVISOR (SIGNATURE/BADGE/DATE) | 34. (SUBSAFE/SOC) QAS: (SIGNATURE/BADGE/DATE) |

|  |  |  |
| --- | --- | --- |
| **STRUCTURAL WELD HISTORY CONTINUATION SHEET**QA FORM 20B (PART B)  | 1. JOINT NO. | 3. SHEET OF |
|  |
| 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. MINPREHEAT: |  | 15. MAXINTERPASS: |  |
| 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 |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
|  |  | [ ]  SAT |  |  |
| [ ]  SEE STRUCTURAL WELD HISTORY CONTINUATION SHEET |
| 32. REMARKS |