

Welding Material Control Log (Edit)

Let's discuss adding a list: N, T, U, CE, etc?



Job Info:

Welder Clock Num	10005998
Size	6
Fig Num	
WO	123459
IMC	012351
MAP/Sales Order	
Line Item	
Reject Ticket Num	123455
Department	Small Cast

Weld Process Report Info:

Customer	ASME Section II
Customer PO	NB-2400
Qty	1
D-Order #	
PS #	
Per Drawing	D-166540
Per Drawing	A-645745
Per Drawing	
Peer Check	
Welding Foreman	M. Leathers
Traceability Stamp	Weld Process S

Log Info:

MS #	P1 241N
Rev	0
Mach No.	781
Qualification #	A2090
Qualification Exp Date	6/12/2021

Part Info:

Part Name	Body
Part Number	090000
Part Heat	P9001
Part Serial	1
Part Name	Seat Ring
Part Number	SR243
Part Heat	T17890
Part Serial	2-1
Part Name	Seat
Part Number	SR243
Part Heat	T17890
Part Serial	2-2

Weld Process Report:

Min Temp	
Max Temp	
Type of Weld	Repair
Stamp	MS# Stamp
Weld #	
Date	2/26/2021

Metal:

Metal	STELLITE 21
Heat	N/A
Lot	5200821-3
Num_Out	10
Num_In	8
Stubs	
Time_Out	6:45 PM
Time_In	6:55 PM

1 of 5

How much trouble/effort would it take to put "Stamp" there traceability stamp? and autopopulate from Weld Table?

This is on the Weld Process Report

Please change to "more" (my suggestion is not politically correct)

Can't see the number of records anymore.

not needed

Is this an RCC-M job?  
☐ Yes  
☒ No

See Weld Process Report  
I couldn't tell/see if the record was duplicating or not

Regards,  
Gib Gratti  
Mfg. Welding Engineer  
Flowserve Corporation  
1900 South Saunders Street  
Raleigh, NC 27603  
(919) 792-6403



1900 S. Saunders St. Raleigh, N.C. 27603

## WELD PROCESS REPORT

Sales Order - Line Item

REPORT NO. 74

Customer: ASME Section III  
Work Order No. 123459  
D-ORDER No.  
Size 6

Customer P.O. NB-2400  
Reject Ticket No. 123455  
QTY. 1  
Figure No.

### PARTS BEING WELDED:

Part Name Body  
Part Name Seat Ring  
Part Name Seat Ring

HEAT / SRL. P9001 1  
HEAT / SRL. Tt7890 2-1  
HEAT / SRL. Tt7890 2-2

WELDING MS No. P1-241N Rev 0

TYPE OF WELDMENT Repair

Weld Num

MACHINE #

781

ELECTRODE SIZE	N/A	FILLER METAL	STELLITE 21	HEAT No.	N/A	LOT No.	5200821-3
ELECTRODE SIZE	N/A	FILLER METAL	STELLITE 21	HEAT No.	N/A	LOT No.	5200821-3
ELECTRODE SIZE	N/A	FILLER METAL	STELLITE 21	HEAT No.	N/A	LOT No.	5200821-3
ELECTRODE SIZE	N/A	FILLER METAL	STELLITE 21	HEAT No.	N/A	LOT No.	5200821-3
ELECTRODE SIZE	N/A	FILLER METAL	STELLITE 21	HEAT No.	N/A	LOT No.	5200821-3

only want to see 1

QUALIFIED WELDER R Mull CLOCK # 10005990 Stamp MS# S Date 2/26/2021

R. Mull

Signature Line  
Name

WELDING FOREMAN

M. Leathers

Signature Line  
Name

DATE 2/26/2021 6:40:52 PM

delete

Note: The recording of false, fictitious or fraudulent statements or entries on this document may be punished as a felony under federal statute.

Form #36-Q-3 (12/2006)

## Gratti, Gilbert

Sort & Filter		Records		Find		Text Formatting		Filter		
Filter Usage		Log_ID	Heat	Lot	Num_Out	Num_In	Stubs	Time_Out	Time_In	Timestamp
		82	N/A	4F909Z03	3	1	2	8:15 AM	10:30 AM	2/26/2021 1:46:31 PM
		82	N/A	5200821-3	10	8		6:45 PM	6:55 PM	2/26/2021 6:49:02 PM
		82	N/A	5200821-3	10	8		6:45 PM	6:55 PM	2/26/2021 6:51:05 PM
		82	N/A	5200821-3	10	8		6:45 PM	6:55 PM	2/26/2021 6:51:18 PM
		82	N/A	5200821-3	10	8		6:45 PM	6:55 PM	2/26/2021 6:51:45 PM
		82	N/A	5200821-3	10	8		6:45 PM	6:55 PM	2/26/2021 6:53:02 PM
										3/1/2021 7:27:32 AM

When copying for more metal  
zero out these fields

Regards,  
Gib Gratti  
Mfg. Welding Engineer  
Flowserve Corporation  
1900 South Saunders Street  
Raleigh, NC 27603  
(919) 792-6403