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MILITARY STANDARD

WELDING AND BRAZING PROCEDURE  
AND PERFORMANCE QUALIFICATION

AMS N/A

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MIL-STD-248D  
10 March 1989

DEPARTMENT OF THE NAVY  
NAVAL SEA SYSTEMS COMMAND

Washington, DC 20362-5101

Welding and Brazing Procedure and Performance Qualification

1. This Military standard is approved for use by all Departments and Agencies of the Department of Defense. This revision adds new ASTM material and AWS welding electrodes.
2. Beneficial comments (recommendations, additions, deletions) and any pertinent data which may be of use in improving this document should be addressed to: Commander, Naval Sea Systems Command, SEA 55Z3, Department of the Navy, Washington, DC 20362-5101 b using the self-addressed Standardization Document Improvement Proposal (DD Form 1426) appearing at the end of this document or by letter.

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## 1. SCOPE

1.1 Scope. This standard contains the requirements for the of welding and brazing procedures, welders, brazers and brazing welding operators that must be met prior to any production fabrication. It includes manual, semi-automatic, automatic and machine welding and brazing of ferrous, nonferrous, and dissimilar metals. The qualification tests required by this standard are devised to demonstrate the adequacy of the welding or brazing procedures and to demonstrate the ability of welders, brazers, welding operators and brazing operators to produce sound welds or brazes.

1.2 Procedures and personnel previously qualified to earlier revisions of this standard, for which records are available and qualifications have been maintained, shall not in general require requalification to this revision. However, the authorized representative may require requalification to this revision on a case-by-case basis where he has specific concerns about the adequacy of procedures or ability of personnel to produce welds of intended integrity or which meet requirements of the applicable fabrication document. These requirements also apply to the visual inspection training of personnel implemented by this revision. It is not the purpose of this standard to require extensive requalification of previously qualified procedures or personnel. Qualification of new procedures and personnel performance shall be accomplished in accordance with the requirements of this standard. The requirements of this standard for requalification (that is, 4.7, 4.8, 5.6, and so forth) shall apply to all previously qualified procedures and personnel.

1.3 This standard contains both mandatory requirements (indicated by the word "shall") designed to serve as standards applicable to methods, materials, and inspection, and guidance information (indicated by either the word "should" or "may"). Guidance information is recommended but is not mandatory.

## 2. REFERENCED DOCUMENTS

### 2.1 Government documents.

2.1.1 Specifications and standards. Unless otherwise specified, the following specifications and standards of the issue listed in that issue of the Department of Defense Index of Specifications and Standards (DODISS) specified in the solicitation form a part of this standard to the extent specified herein.

## SPECIFICATIONS

### FEDERAL

- O-F-499 - Flux Brazing, (Silver Brazing Filler Metal, Low Melting Point).
- QQ-A-200 - Aluminum Alloy, Bar, Rod, Shapes, Structural Shapes,
- QQ-A-200/1 - Aluminum Alloy 3003, Bar, Rod, Shapes, Tube and Wire, Extruded.
- QQ-A-200/4 - Aluminum Alloy 5083, Bar, Rod, Shapes, Tube and Wire, Extruded.
- QQ-A-200/5 - Aluminum Alloy 5086, Bar, Rod, Shapes, Tube and Wire, Extruded.

FEDERAL (Continued)

- QQ-A-200/6 - Aluminum Alloy 5454, Bar, Rod, Shapes, Tube and Wire, Extruded.
- QQ-A-200/7 - Aluminum Alloy 5456, Bar, Rod, Shapes, Tube and Wire, Extruded.
- QQ-A-225 - Aluminum and Aluminum Alloy Bar, Rod, Wire, or Special Shapes; Rolled, Drawn, or Cold Finished; General Specification for.
- QQ-A-225/1 - Aluminum Alloy Bar, Rod, and Wire; Rolled, Drawn, or Cold Finished, 1100.
- QQ-A-225/2 - Aluminum Alloy Bar, Rod, and Wire; Rolled, Drawn, or Cold Finished, 3003.
- QQ-A-225/7 - Aluminum Alloy 5052, Bar, Rod, and Wire; Rolled, Drawn, or Cold Finished.
- QQ-A-250 - Aluminum and Aluminum Alloy Plate and Sheet: General Specification for.
- QQ-A-250/1 - Aluminum 1100, Plate and Sheet.
- QQ-A-250/2 - Aluminum Alloy 3003, Plate and Sheet.
- QQ-A-250/6 - Aluminum Alloy 5083, Plate and Sheet.
- QQ-A-25019 - Aluminum Alloy 5052, Plate and Sheet.
- QQ-A-250/10 - Aluminum Alloy 5454, Plate and Sheet.
- QQ-A-601 - Aluminum Alloy Sand Castings.
- QQ-B-626 - Brass, Leaded and Nonleaded: Rod, Shapes, forgings, and Flat Products with Finished Edges (Bar and Strip).
- QQ-B-637 - Brass, Naval: Rod, Wire, Shapes, forgings, and Flat Products with Finished Edges (Bar, Flat Wire, and Strip).
- QQ-B-639 - Brass, Naval: Flat Products (Plate, Bar, Sheet, and Strip).
- QQ-B-650 - Brazing Alloys, Copper, Copper-Zinc, and Copper-Phosphorus.
- QQ-B-654 - Brazing Alloys, Silver.
- QQ-B-728 - Bronze Manganese; Rod, Shapes, forgings, and Flat Products (Flat Wire, Strip, Sheet, Bar, and Plate).
- QQ-B-750 - Bronze, Phosphor; Bar, Plate, Rod, Sheet, Strip, Flat Wire, and Structural and Special Shaped Sections.
- QQ-C-390 - Copper Alloy Castings (Including Cast Bar).
- QQ-C-450 - Copper-Aluminum Alloy (Aluminum Bronze) Plate, Sheet, Strip, and Bar (Copper Alloy Numbers 606, 610, 613, 614, and 630).
- QQ-C-465 - Copper-Aluminum Alloys (Aluminum Bronze) (Copper Alloy Numbers 606, 614, 630, 632M, and 642); Rod, Flat Products with Finished Edges (Flat Wire, Strip, and Bar), Shapes, and forgings.
- QQ-C-576 - Copper Flat Products with Slit, Slit and Edge-Rolled, Sheared, Sawed, or Machined Edges, (Plate, Bar, Sheet, and Strip).
- QQ-C-591 - Copper-Silicon, Copper-Zinc-Silicon, and Copper-Nickel-Silicon Alloys: Rod, Wire, Shapes, forgings, and Flat Products (Flat Wire, Strip, Sheet, Bar, and Plate).

FEDERAL (Continued)

- QQ-N-281 - Nickel-Copper Alloy Bar, Rod, Plate, Sheet, Wire, forgings, and Structural and Special Shaped Sections.
- QQ-N-288 - Nickel-Copper Alloy and Nickel-Copper-Silicon Alloy Castings.
- QQ-S-763 - Steel Bars, Wire, Shapes, and forgings, Corrosion Resisting.
- QQ-S-766 - Steel, Stainless and Heat Resisting, Alloys, Plate, Sheet and Strip.
- WW-P-404 - Pipe, Steel, (Seamless and Welded, Black and Zinc-Coated (Galvanized)).
- WW-T-700 - Tube, Aluminum and Aluminum Alloy, Drawn, Seamless, General Specification for.
- WW-T-700/1 - Tube, Aluminum, Drawn, Seamless, 1100.
- WW-T-700/2 - Tube, Aluminum, Alloy, Drawn, Seamless, 3003.
- WW-T-700/5 - Tube, Aluminum Alloy, Drawn, Seamless, 5086.
- WW-T-799 - Tube, Copper, Seamless, Water (For Use with Solder-Flared- or Compression-Type Fittings).

MILITARY

- MIL-E-278 - Electrodes, Welding, Covered, Aluminum Bronze.
- MIL-S-860 - Steel forgings for Steam Turbine Rotors.
- MIL-S-867 - Steel Castings, Corrosion Resisting Austenitic,
- MIL-S-870 - Steel Castings, Molybdenum Alloy.
- MIL-T-1368 - Tube and Pipe, Nickel-Copper Alloy, Seamless and Welded.
- MIL-T-3595 - Tubing, Phosphor Bronze: (Cda. No. 510) Round, Seamless.
- MIL-T-6736 - Tubing, Chrome-Molybdenum, 4130 Steel, Seamless and Welded, Aircraft Quality.
- MIL-W-6858 - Welding, Resistance: Spot and Seam.
- MIL-T-8504 - Tubing Steel, Corrosion-Resistant (304), Aerospace Vehicle Hydraulic Systems, Annealed, Seamless and Welded.
- MIL-E-8697 - Electrodes, Welding, Covered, Low-Hydrogen, Heat-Treatable Steel.
- MIL-S-8699 - Steel Bars and Forging Stock (4330) Vanadium Modified, Aircraft Quality.
- MIL-T-9046 - Titanium, and Titanium. Alloy, Sheet, Strip and Plate.
- MIL-T-9047 - Titanium and Titanium Alloy Bars (Rolled or Forged) and Reforging Stock, Aircraft Quality.
- MIL-T-15005 - Tubes, 70-30 and 90-10 Copper Nickel Alloy, Condenser and Heat Exchanger.
- MIL-S-15083 - Steel Castings.
- MIL-B-15382 - Bolt, Firebrick Anchor.
- MIL-S-15464 - Steel, Alloy, Chromium-Molybdenum; Castings.
- MIL-C-15726 - Copper-Nickel Alloy, Rod, Flat Products (Flat Wire, Strip, Sheet, Bar, and Plate) and forgings.

MILITARY (Continued)

- MIL-S-16216 - Steel Plate, Alloy, Structural, High Yield Strength (HY-80 and HY-100).
- MIL-T-16286 - Tube, Steel, Seamless, Marine Boiler Application.
- MIL-T-16420 - Tube, Copper-Nickel Alloy, Seamless and Welded (Copper Alloy Numbers 715 and 706).
- MIL-B-16541 - Bronze, Valve: Castings.
- MIL-S-16993 - Steel Castings (12-Percent Chromium).
- MIL-R-17131 - Rods and Powders, Welding, Surfacing.
- MIL-N-17163 - Nickel-Copper Alloy, Wrought; (55-60 Percent Nickel) Low Permeability.
- MIL-S-17509 - Steel Castings, Austenitic, Chromium-Nickel, Low Magnetic Permeability.
- MIL-E-18193 - Electrodes, Welding, Carbon Steel and Alloy Steel, Bare, Coiled.
- MIL-F-18251 - Fluxes, Welding, Submerged Arc Process Carbon and Low-Alloy Steel Application.
- MIL-S-18728 - Steel Plate, Sheet and Strip, Alloy 8630, Aircraft Quality.
- MIL-S-18729 - Steel Plate, Sheet, and Strip, Alloy 4130, Aircraft Quality.
- MIL-F-19922 - Fluxes, Welding (Compositions), Submerged Arc Process with Type "B" Electrodes, Carbon and Low-Alloy Steel Application.
- MIL-E-19933 - Electrodes and Rods - Welding, Bare, Chromium and Chromium-Nickel Steels.
- MIL-C-20159 - Copper-Nickel Alloy Castings (UNS No. C96200 and C96400).
- MIL-T-20168 - Tubes, Brass, Seamless.
- MIL-T-20219 - Tube, Brass, Voice and Pneumatic.
- MIL-F-20236 - Fittings, Tube and Pipe, Butt-Welding, 300 P.S.I and 775 deg. F. Maximum.
- MIL-F-20670 - Flanges, Pipe, Carbon Steel, 150 P.S.I, W.S.P (For Naval Shipboard Use).
- MIL-A-21180 - Aluminum-Alloy Castings, High Strength.
- MIL-E-21562 - Electrodes and Rods Welding, Bare, Nickel Alloy.
- MIL-S-21952 - Steel (HY-80 and HY-100) Bars, Alloy.
- MIL-E-22200 - Electrodes, Welding, Covered; General Specification for.
- MIL-E-22200/1 - Electrodes, Welding, Mineral Covered, Iron-Powder, Low-Hydrogen Medium and High Tensile Steel, As Welded or Stress-Relieved Weld Application.
- MIL-E-22200/2 - Electrodes, Welding, Covered (Austenitic Chromium-Nickel Steel).

MILITARY (Continued)

- MIL-E-22200/3 - Electrodes, Welding, Covered: Nickel Base Alloy; and Cobalt Base Alloy.
- MIL-E-22200/4 - Electrodes, Welding, Covered, Copper-Nickel Alloy.
- MIL-E-22200/5 - Electrodes, Welding, Mineral Covered, Iron-Powder, Low-Hydrogen, Low-Alloy Steel for Hardening and Tempering Heat Treatment Applications Only.
- MIL-E-22200/6 - Electrodes, Welding, Mineral Covered, Low-Hydrogen, Medium and High Tensile Steel.
- MIL-E-22200/7 - Electrodes, Welding, Covered, Molybdenum Alloy Steel Application.
- MIL-E-22200/8 - Electrodes, Welding, Covered, Low-Hydrogen, and Iron-Powder Low-Hydrogen, Chromium-Molybdenum Alloy Steel and Corrosion Resisting Steel.
- MIL-E-22200/9 - Electrodes, Welding, Mineral Covered Low-Hydrogen or Iron-Powder, Low-Hydrogen, Nickel Manganese-Chromium-Molybdenum Alloy Steel for Producing HY-130 Weldments for As-Welded Applications.
- MIL-E-22200/10 - Electrodes, Welding, Mineral Covered, Iron-Powder, Low-Hydrogen Medium, High Tensile and Higher-Strength Low Alloy Steels.
- MIL-S-22698 - Steel Plate and Shapes, Weldable Ordinary Strength and Higher Strength: Hull Structural.
- MIL-S-23008 - Steel Castings, Alloy, High Yield Strength (HY-80 and HY-100).
- MIL-S-23009 - Steel forgings, Alloy, High Yield Strength (HY-80 and HY-100).
- MIL-S-23193 - Steel, Corrosion Resistant; Castings.
- MIL-S-23194 - Steel forgings Carbon and Alloy.
- MIL-S-23195 - Steel Bars and forgings Corrosion Resistant.
- MIL-S-23196 - Steel Plate, Sheet and Strip, Corrosion Resistant.
- MIL-T-23226 - Tube and Pipe, Corrosion-Resistant Steel, Seamless.
- MIL-T-23227 - Tube and Pipe, Nickel-Chromium-Iron Alloy.
- MIL-N-23228 - Nickel Chromium Iron Alloy Plate, Sheet and Strip.
- MIL-N-23229 - Nickel-Chromium-Iron Alloy Bars and forgings.
- MIL-S-03284 - Steel forgings, Carbon and Alloy, for Shafts, Sleeves, Couplings, and Stocks (Rudders and Diving Planes).
- MIL-I-23413 - Inserts, Welding, Filler Material, Coiled and Solid Rings.
- MIL-F-23467 - Fittings and Flanges, Wrought, Seamless, Butt and Socket Welding, Austenitic Corrosion-Resistant Steel.
- MIL-F-23508 - Fittings and Flanges, Wrought Seamless, Butt and Socket Welding, Nickel Chromium Iron Alloy.

MILITARY (Continued)

- MIL-F-23509 - Fittings and Flanges, Wrought Seamless Butt and Socket Welding, Nickel Copper Alloy.
- MIL-T-23520 - Tube and Pipe, Nickel-Copper Alloy, Seamless Air Melted.
- MIL-E-23765 - Electrodes and Rods - Welding, Bare, Solid and Alloyed Cored, General Specification for.
- MIL-E-23765/1 - Electrodes and Rods - Welding, Bare, Solid and Alloyed Cored, Ordinary Strength and Low Alloy Steel.
- MIL-E-23765/2 - Electrodes and Rods - Welding, Bare, Solid, or Alloyed Cored, Low Alloy Steel.
- MIL-E-23765/3 - Electrodes and Rods - Welding, Bare, Solid Copper Alloy.
- MIL-S-24093 - Steel forgings, Carbon and Alloy Heat Treated.
- MIL-N-24106 - Nickel Copper Alloy Bars, Rods, and forgings.
- MIL-T-24107 - Tube, Copper (Seamless) (Copper Alloy Numbers C10100, C10200, C10300, C10800, C12000, C12200, and C14200).
- MIL-N-24114 - Nickel Chromium Iron Age Hardenable Alloy Bars, Rods, and forgings.
- MIL-L-24128 - Low Carbon Chromium Steel Bars, Rods and forgings.
- MIL-S-24149 - Studs, Arc welding, and Arc Shields (Ferrules), General Specification for.
- MIL-S-24149/1 - Studs, Arc welding, and Arc Shields (Ferrules); Type I, Class 1, 2, 3, and Type II, Class 1, 4, 5, 5A, 6, Carbon Steel, for Direct Energy Arc Welding.
- MIL-S-24149/2 - Studs, Arc welding, and Arc Shields (Ferrules); Type III, Class 1, 2, 3, and Type IV, Class 1, 2, 3, 4, 5, 6, Aluminum Alloy, for Direct Energy Arc Welding.
- MIL-S-24149/3 - Studs, Arc welding, and Arc Shields (Ferrules); Type V, Class 1, 4, 5, 5A, Corrosion-Resistant Steel, for Direct Energy Arc Welding.
- MIL-S-24149/4 - Studs, Arc welding, Type VI, Class 1, 2, 3, Carbon Steel, for Stored Energy (Capacitor Discharge) Arc Welding.
- MIL-S-24149/5 - Studs, Arc welding; Type VII, Class 1, 2, 3, Aluminum Alloy, for Stored Energy (Capacitor Discharge) Arc Welding.
- MIL-S-24149/6 - Studs, Arc welding; Type VIII, Class 1, 2, 3, Corrosion-Resistant, for Stored Energy (Capacitor Discharge) Arc Welding.
- MIL-S-24238 - Steel Plate Carbon and Low Alloy.
- MIL-N-24271 - Nickel-Chromium-Iron Alloy Castings.
- MIL-P-243118 - Pipe, Carbon Steel, Seamless.
- MIL-F-24339 - Fittings and Flanges, Wrought, Seamless, Butt and Socket Welding Carbon Steel.
- MIL-F-24342 - Fitting and Flange, Wrought Seamless, Butt and Socket Welding 70-30 Copper Nickel Alloy.

MILITARY (Continued)

- MIL-E-24355 - Electrodes, Welding, Bare, Solid, Nickel-Manganese-Chromium-Molybdenum Alloy Steel for Producing HY-130 Weldments for As-Welded Applications.
- MIL-S-24371 - Steel Plate, Alloy, Structural, High Yield Strength (HY-130).
- MIL-E-24403 - Electrodes - Welding, Flux Cored General Specification for.
- MIL-E-24403/1 - Electrodes - Welding, Flux Cored, Ordinary Strength and Low Alloy Steel.
- MIL-E-274403/2 - Electrodes - Welding, Flux Cored, Low-Alloy Steel.
- MIL-S-24412 - Steel, Special Structural Shape, Weldable, High Tensile (HT); for Submarine Hulls.
- MIL-S-24451 - Steel Heat Treated Heads, Alloy Structural, High Yield Strength (HY-80 and HY-100).
- MIL-B-24480 - Bronze, Nickel Aluminum (UNS No. C95800) Castings for Seawater Service.
- MIL-S-24645 - Steel Plate, Sheet or Coil, Age-Hardening Alloy, Structural, High Yield Strength (HSLA-80).
- DOD-F-24669 - forgings and Forging Stock, Steel Bars, Billets and Blooms, General Specification for. (Metric)
- DOD-F-24669/1 - forgings and Forging Stock, Steel (Carbon and Alloy) Blooms, Bars, Billets and Slabs. (Metric)
- DOD-F-24669/2 - forgings and Forging Stock, Steel Bars and Billets - Chromium-Molybdenum Alloy. (Metric)
- DOD-F-24669/6 - forgings and Forging Stock, Steel Bars and Billets, Corrosion Resisting; for Reforging. (Metric)
- DOD-F-24669/7 - forgings and Forging Stock, Steel Bars and Billets, Corrosion Resisting; Naval Steam Turbine Parts Use. (Metric)
- MIL-P-24691 - Pipe and Tube, Carbon, Alloy and Stainless Steel, Seamless and Welded, General Specification for.
- MIL-P-24691/1 - Pipe and Tube, Carbon Steel, Stainless.
- MIL-P-24691/2 - Pipe and Tube, Chromium-Molybdenum Steel, Seamless.
- MIL-P-24691//3 - Pipe and Tube, Corrosion-Resistant, Stainless Steel, Seamless or Welded.

STANDARDS

MILITARY

- MIL-STD-22 - Welded Joint Designs.
- MIL-STD-271 - Requirements for Nondestructive Testing Methods.
- MIL-STD-1628 - Fillet Weld Size, Strength, and Efficiency Determination.
- MIL-STD-1681 - Fabrication, Welding, and Inspection of HY-130 Submarine Hull.
- MIL-STD-1688 - Fabrication, Welding, and Inspection of HY-80/100 Submarine Applications.
- MIL-STD-1689 - Fabrication, Welding, and Inspection of Ships Structure.

2.1.2 Other Government publications. The following other Government publications form a part of this standard to the extent specified herein. Unless otherwise specified, the issues shall be those in effect on the date of the solicitation.

PUBLICATIONS

NAVAL SEA SYSTEMS COMMAND (NAVSEA)

- 0900-LP-001-7000 - Fabrication and Inspection of Brazed Piping Systems.
- 0900-LP-003-8000 - Surface Inspection Acceptance Standards for Metals.
- 0900-LP-003-9000 - Radiographic Standards for Production and Repair Welds.
- 0900-LP-006-3010 - Ultrasonic Inspection Procedures and Acceptance Standards for Hull Structure Production and Repair Welds.
- 0951-LP-031-8010 - Propulsion Plant Main Boiler PSI Steam, TM (Repair and Overhaul).

(Copies of specifications, standards, and publications required by contractors in connection with specific acquisition functions should be obtained from the contracting activity or as directed by the contracting officer.)

2.2 Other publications. The following documents form a part of this standard to the extent specified herein. Unless otherwise specified, the issues of the documents which are DoD adopted shall be those listed in the issue of DODISS specified in the solicitation. The issues of documents which have not been adopted shall be those in effect on the date of the cited DODISS.

AEROSPACE MATERIALS SPECIFICATION (AMS)

- AMS 6530 - Tubing Seamless-0.55 Ni-0.50 Cr-0.20 Mo (0.28-0.34C).

(Application for copies should be addressed to the Society of Automotive Engineers, 400 Commonwealth Drive, Warrendale, PA 15096.)

AMERICAN NATIONAL STANDARDS INSTITUTE (ANSI)

- A5.10 - Standard Specification for Aluminum and Aluminum Alloy Bare Welding Rods and Electrodes.

(Application for copies should be addressed to American National Standards Institute, 1430 Broadway, New York, NY 10018.)

AMERICAN SOCIETY FOR TESTING AND MATERIALS (ASTM)

- A 178 - Standard Specification for Electric-Resistance-Welded Carbon Steel and Carbon-Manganese Steel Boiler (DoD adopted)
- A 182 - Standard Specification for Forged or Rolled Alloy Pipe Flanges, Forged Fittings, and Valves and Parts for High Temperature Service. (DoD adopted)
- A 213 - Standard Specification for Seamless Ferritic and Austenitic Alloy-Steel Boiler, Superheater and Heat-Exchanger Tubes. (DoD adopted)

ASTM (Continued)

- A 216 - Standard Specification for Steel Castings, Carbon, Suitable for Fusion Welding, for High Temperature Service. (DoD adopted)
- A 240 - Standard Specification for Heat-Resisting Chromium and Chromium-Nickel Stainless Steel Plate, Sheet, and Strip for Pressure Vessels. (DoD adopted)
- A 302 - Standard Specification for Pressure Vessel Plates, Alloy Steel, Manganese-Molybdenum and Manganese-Molybdenum-Nickel. (DoD adopted)
- A 335 - Standard Specification for Seamless Ferritic Alloy-Steel Pipe for High-Temperature Service.
- A 370 - Standard Test Methods and Definitions for Mechanical Testing of Steel forgings. (DoD adopted)
- A 473 - Standard Specification for Stainless and Heat-Resisting Steel forgings. (DoD adopted)
- A 487 - Standard Specification for Steel Castings Suitable for Pressure Service.
- A 494 - Standard Specification for Castings, Nickel and Nickel Alloy.
- A 515 - Standard Specification for Pressure Vessel Plates, Carbon Steel for Intermediate- and Higher-Temperature Service. (DoD adopted)
- A 516 - Standard Specification for Pressure Vessel Plates, Carbon Steel, for Moderate- and Lower-Temperature Service. (DoD adopted)
- A 537 - Standard Specification for Pressure Vessel Plates, Heat-Treated, Carbon-Manganese-Silicon Steel. (DoD adopted)
- A 743 - Standard Specification for Castings, Iron-Chromium, Iron-Chromium-Nickel, Corrosion Resistant, for General Application. (DoD adopted)
- A 744 - Standard Specification for Castings, Iron-Chromium-Nickel, Corrosion Resistant, for Severe Service. (DoD adopted)
- B 166 - Standard Specification for Nickel-Chromium-Iron Alloys (UNS N06600 and N06690) Rod, Bar, and Wire. (DoD adopted)
- B 209 - Standard Specification for Aluminum and Aluminum-Alloy Sheet and Plate. (DoD adopted)
- B 265 - Standard Specification for Titanium and Titanium Alloy Strip, Sheet and Plate.
- B 337 - Standard Specification for Seamless and Welded Titanium and Titanium Alloy Pipe. (DoD adopted)
- B 338 - Standard Specification for Seamless and Welded Titanium and Titanium Alloy Tubes for Condensers and Heat Exchangers. (DoD adopted)
- B 367 - Standard Specification for Titanium and Titanium Alloy Castings.
- B 443 - Standard Specification for Nickel-Chromium-Molybdenum-Columbium Alloy (UNS N06625) Plate, Sheet, and Strip.
- B 444 - Standard Specification for Nickel-Chromium-Molybdenum-Columbium Alloys (UNS N06625) Pipe and Tube.
- B 446 - Standard Specification for Nickel-Chromium-Molybdenum-Columbium Alloy (UNS N06625) Rod and Bar.

ASTM (Continued)

- B 564 - Standard Specification for Nickel Alloy forgings. (DoD adopted)  
E 604 - Standard Test Method for Dynamic Tear Testing of Metallic Materials. (DoD adopted)

(Application for copies should be addressed to the American Society for Testing and Materials, 1916 Race Street, Philadelphia, PA 19103.)

AMERICAN WELDING SOCIETY (AWS)

- A3.0 - Standard Welding Terms and Definitions. (DoD adopted)  
A5.1 - Specification for Covered Carbon Steel Arc Welding Electrodes. (DoD adopted)  
A5.2 - Specification for Iron and Steel Oxyfuel Gas Welding Rods. (DoD adopted)  
A5.4 - Specification for Covered Corrosion-Resisting Chromium and Chromium-Nickel Steel Welding Electrodes. (DoD adopted)  
A5.5 - Specification for Low Alloy Steel Covered Arc Welding Electrodes. (DoD adopted)  
A5.6 - Specification for Covered Copper and Copper Alloy Arc Welding Electrodes. (DoD adopted)  
A5.7 - Specification for Copper and Copper Alloy Bare Welding and Electrodes. (DoD adopted)  
A5.9 - Specification for Corrosion Resisting Chromium and Chromium-Nickel Steel Bare and Composite Metal Cored and Stranded Welding Electrodes and Welding Rods. (DoD adopted)  
A5.10 - Specification for Aluminum and Aluminum Alloy Bare Welding Rods and Electrodes. (DoD adopted)  
A5.13 - Specification for Solid Surfacing Welding Rods and Electrodes. (DoD adopted)  
A5.16 - Specification for Titanium and Titanium Alloy Bare Welding Rods and Electrodes. (DoD adopted)  
A5.23 - Specification for Low Alloy Steel Electrodes and Fluxes for Submerged Arc Welding. (DoD adopted)  
A5.27 - Specification for Copper and Copper Alloy Rods for Oxyfuel Gas Welding.  
A5.28 - Specification for Low Alloy Steel Filler Metals for Gas] Shielded Arc Welding. (DoD adopted)  
B4.0 - Standard Methods for Mechanical Testing of Welds. (DoD adopted)

(Application for copies should be addressed to the American Welding Society, Inc., 550 NW LeJeune Road, P.O. Box 351040, Miami, FL 33135.)

AMERICAN SOCIETY FOR NONDESTRUCTIVE TESTING (ASNT)

- ASNT Publication No. 103 - Glossary of Terms Frequently Used in Nondestructive Testing.

(Application for copies should be addressed to the American Society for Nondestructive Testing, 3200 Riverside Drive, P.O. Box 21442, Columbus OH 43221.)

(Nongovernment standards are generally available for reference from libraries. They are also distributed among nongovernment standards bodies and using Federal agencies.)

2.3 Order of precedence. In the event of a conflict between the text of this standard and the references cited herein, the text of this standard shall take precedence.

### 3. DEFINITIONS

#### 3.1 Terms related to both welding and brazing.

##### 3.1.1 General.

- (a) Except as noted herein, welding and brazing nomenclature and definitions shall conform to AWS A3.0.
- (b) Except as noted herein, nondestructive testing nomenclature and definitions shall conform to ASNT publication No. 103.

3.1.2 Acceptable. An item is acceptable when it complies with or conforms to the applicable standard or specification.

3.1.3 Activity. The term activity refers to all sites of an organization, under the same quality assurance management and using the same quality assurance plan, performing work to which this standard is applicable. The quality assurance manual shall contain a paragraph approved by an authorized representative, specifically addressing the transfer of qualified procedures from one site to another within the activity.

3.1.4 Applicable fabrication document. Applicable fabrication document is the document invoked by the contract, purchase order or circular of requirements governing the work being accomplished.

3.1.5 Approval (approved). Approval means the item under consideration requires acceptance by NAVSEA or its authorized representative. "Approval" or "approved" as used herein shall be by the NAVSEA authorized representative unless NAVSEA approval is specified.

3.1.6 Authorized representative. An authorized representative is any Government representative specifically authorized to approve equipment, material or procedures within the scope of this document for NAVSEA. They are as follows:

- (a) For Government shipyards: The delegated representative of the Shipyard Commander.
- (b) For commercial shipyards: The delegated representative of the Supervisor of Shipbuilding, Conversion and Repair (SUPSHIP), or the American Bureau of Shipping when specified in the Ship's specifications for a particular ship. This includes all applicable areas in the shipyard and applicable items furnished to the shipyard by subcontractors.

- (c) For Government purchase items: The delegated representative of the Commanding Officer, Naval Ship Systems Engineering Station (NAVSSES), Philadelphia or of the Officer in Charge, NAVSSES Detachment, Mechanicsburg, or of the Officer in Charge, NAVSSES Detachment, Norfolk.
- (d) When delegated by NAVSEA, the representative of the Defense Contract Administration Services Management Area (DCASMA).
- (e) Technical representative specifically authorized by NAVSEA.

3.1.7 Essential elements. Essential elements are those elements, either material or process, that are important in establishing a welding or brazing procedure. These elements shall be defined as part of a welding or brazing procedure. Changes in these elements, after a procedure has been qualified, shall require a change in the written procedure and may require level I or level II requalification, depending on the element being changed and the magnitude of the change.

3.1.8 Inspector. An inspector is any contractor, Naval shipyard and other Government agency employee or American Bureau of Shipping Surveyor qualified as required by this document to accept or reject materials or workmanship on the basis of specified test results.

3.1.9 Performance qualification. A performance qualification is an action by which welders and welding operators are evaluated by nondestructive and destructive methods for their demonstrated ability to produce welds which meet the requirements of this specification. Also included are requirements for qualification record keeping.

3.1.10 Procedure. A procedure is a written fabrication instruction which contains all the applicable essential elements listed in this document.

3.1.11 Procedure qualification. Procedure qualification is an action by which test assemblies are prepared in accordance with a proposed procedure and evaluated by destructive or nondestructive tests or both. Also included are requirements for qualification record keeping.

3.1.12 Qualified. The term "qualified" means that the item under consideration has been approved as required by this standard.

## 3.2 Terms related to welding.

3.2.1 Build-up. Build-up is a surfacing variation in which surfacing metal is deposited to restore base material or weld surface dimensions.

3.2.2 Buttering. Buttering is a surfacing variation that deposits surfacing metal on one or more surfaces to provide metallurgical compatible weld metal for the subsequent completion of the weld.

3.2.3 Cladding. Cladding is a surfacing variation that deposits or applies surfacing materials, usually to improve corrosion or heat resistance.

3.2.4 Dissimilar metal welds. Dissimilar metal welds are welds involving two metals which differ sufficiently in metallurgical and physical properties to require special consideration in procedure qualification and inspection (see section 4 for exceptions).

3.2.5 Hardfacing. Hardfacing refers to a surfacing variation in which surfacing metal is deposited to reduce wear.

3.2.6 Internal tube-to-header welds. These are welds between various types of boiler tubes and their respective headers (or drums), such as economizer headers, superheater headers, and so forth. These welds are located on the interior of the header (or drum). Integrity of the tube-to-header connection is usually provided by a combination of welding and rolling the tube.

3.2.7 Keyhole welding. Keyhole welding is a technique in which a concentrated heat source penetrates completely through a workpiece, forming a hole at the leading edge of the weld pool. As the heat source progresses, the molten metal fills in behind the hole to form the weld bead.

3.2.8 Orifice gas (plasma arc welding and cutting). Orifice gas is the gas that is directed into the torch to surround the electrode. It becomes ionized in the arc to form the plasma, and issues from the orifice in the torch nozzle as the plasma jet.

3.2.9 Oscillation. Defining characteristics:

- (a) Amplitude. Amplitude is the distance normal to the direction of welding between the outermost positions which the electrode tip reaches while oscillating.
- (b) Dwell. Dwell is the time during which the electrode rests at any point in each oscillating swing or traverse.
- (c) Frequency. Frequency is the number of complete cycles made by the oscillating head in 1 minute, or other specified time increment.

3.2.10 Seal weld. Seal weld is a weld provided for a fluid containment function only, as in a closure where strength is provided by a separate device.

3.2.11 Special welds. Special welds are welds involving:

- (a) Base materials not covered in table I of this standard.
- (b) Filler materials not covered in table II of this standard.
- (c) Material thickness above those specified in table VI of this standard or
- (d) Processes which are not specified in table III of this standard.

3.2.12 Surfacing. Surfacing is the application by welding, brazing, or thermal spraying of a layer of material to a surface to obtain desired properties or dimensions, as opposed to making a joint. (See also buildup, buttering, cladding and hardfacing.)

3.2.13 Tube-to-tubesheet weld. Welds between tubing (usually heat transfer tubing) and the respective tube sheet usually occurring in some type of heat exchanger (see also 3.2.6).

3.2.14 Welding speed (travel speed). Welding speed is the rate of progression of the welding arc along the weld axis.

3.2.15 Wire feed angle. Wire feed angle is the angle between the filler metal and the tangent to the pipe or plate surface at the arc.

3.2.16 Wormhole porosity. Wormhole porosity refers to gas inclusions having an elongated form known as "wormholes" or "pipes" usually oriented almost perpendicular to the weld surface.

### 3.3 Terms related to brazing.

3.3.1 Brazement. Brazement is an assembly whose component parts are joined by brazing.

3.3.2 Clearance. Clearance is the actual gap at room temperature prior to brazing for capillary flow of filler metal.

3.3.3 Manual torch brazing. Manual torch brazing is torch brazing with the brazer controlling the torch with his hands.

3.3.4 Mechanized torch brazing. Mechanized torch brazing is torch brazing with an automatic or mechanical method of controlling the torch while brazing.

3.3.5 Peel test. Peel test is a destructive method of inspection where a lap joint is mechanically separated by peeling (see figure 20).

3.3.6 Preplaced brazing alloy. Preplaced brazing alloy is any form (shims, wire, rings, and so forth) of brazing alloy which is placed in a joint prior to brazing.

## 4. WELDING PROCEDURE QUALIFICATION

4.1 Scope. This section provides general requirements for the qualification of welding procedures. Specific qualification requirements for the categories listed below shall be as specified in 4.4.

- (a) Groove welds and fillet welds (manual, semi-automatic, automatic and machine welding).
- (b) Fillet welds - welding over primer coated surfaces.
- (c) Weld surfacing.
- (d) Dissimilar metal welds.
- (e) Resistance welding.
- (f) Stud welding.
- (g) Welds made without adding filler material (autogenous welds).
- (h) Seal, pipe socket and tube to tube sheet welds.
- (i) Special welds.

### 4.2 General requirements.

4.2.1 Responsibility. When this standard is specified by the applicable fabrication document, each activity qualifying procedures under the requirements of this standard shall prepare written welding procedures and

perform the required tests to qualify these procedures. The activity shall notify the authorized representative a minimum of 48 hours prior to the conduct of procedure qualification testing and afford him the opportunity to observe the welding of the test assemblies and the performance of the required nondestructive and destructive testing. The 48-hour time limit may be modified upon agreement between the authorized representative and the activity. Such observation shall be at the discretion of the authorized representative.

4.2.2 Certification of qualification testing. After testing, the responsible official of the activity shall certify that the tests and the test results meet all requirements of this standard and that the welding procedure meets all requirements of this standard and the applicable fabrication document. Qualification tests and data containing deviations from requirements may be submitted for approval if such deviations are specifically identified as deviations, and the technical justification for each deviation is provided. Procedure qualifications previously prepared for other Government agencies, American Bureau of Shipping (ABS), American Society of Mechanical Engineers (ASME), or other established regulatory codes may be submitted for approval to the authorized representative provided qualification testing and approval (to the other Government agencies or regulatory bodies requirements) occurred prior to an activity's invitation for bid or request for proposal. Nondestructive examination requirements, as specified in this standard but not required by other agencies, shall be accomplished on an additional test sample or, if approved by an authorized representative, on a production application. Such data shall be submitted for approval as required in 4.2.3.

4.2.2.1 The qualification limitations for welding procedure qualifications performed for other agencies shall be as specified in this standard. As an example, a flat position ASME procedure qualification may only qualify flat position welding in accordance with this standard.

4.2.3 Submittal for approval. Procedures are the activity's responsibility. Prior to production application of the welding procedure, the activity shall obtain approval (see 3.1.5) of the procedure qualification data. This entails submittal of the welding procedure qualification test report to the authorized representative for approval and submittal of the corresponding welding procedure to the authorized representative for information in accordance with the appendix.

4.2.3.1 Requirements. In addition to the general requirements covered by the Data Item Description of the appendix the following requirements shall also apply.

4.2.3.1.1 Welding procedure qualification test report. The welding procedure qualification test report shall be in accordance with 4.6.1.

4.2.3.1.2 Welding procedure. The welding procedure shall be in accordance with 4.3.

4.2.3.2 Lot conformance testing for mechanical properties, toughness, weldability, cleanliness, and so forth, for any filler material not classified in table II (for example, submerged-arc welding fluxes covered by table II, note 5) shall be also described in the submittal for approval.

4.2.4 Vendor qualification. It shall be the responsibility of each activity to assure that its subcontractors have qualified procedures based on approved qualification data.

4.2.5 Approval of procedure qualification for special welds. NAVSEA approval of procedure qualification data shall be obtained for special welds as defined in for the following areas:

- (a) Surface ship primary structure.
- (b) Submarine pressure hull structure.
- (c) Submarine intermediate pressure tanks.
- (d) P-1 and P-LT piping.
- (e) A-1, A-2, A-F and A-LT pressure vessels.

For welding processes not included in table III of this standard, the submittal shall include a description of the welding process, joint design, evaluation method and the proposed welding performance qualification tests.

4.2.6 Waiver of qualification. Qualification tests for welding on assemblies, the possible failure of which is remote and would not result in danger to the ship or components, such as identification plates, galley equipment, furniture, fixtures, and miscellaneous outfitting may be omitted provided this omission is permitted by the applicable fabrication document or is approved prior to the commencement of such work.

#### 4.2.7 Qualification levels.

4.2.7.1 General. When this standard is specified in the applicable fabrication document, procedure qualification is required for base materials as listed in table I, filler materials as listed in table II, welding processes and special welds as listed in 4.2.5 except as permitted by 4.2.6 and table III. Table III may be used to extend procedure qualifications to base material/filler metal combinations other than those specifically welded and tested. The essential elements for welding each base material, filler metal combinations shall be incorporated into the welding procedure and be in accordance with the requirements of this standard and the applicable fabrication document.

4.2.7.2 Level I. This qualification level covers the initial qualification of any welding procedure for the fabrication welding of wrought or cast material or the repair welding of wrought or cast material by any activity. Approval of the required level I welding procedure qualification shall be obtained from the authorized representative except as noted in 4.2.5. This qualification level covers any welding procedure to be qualified by performing the destructive and nondestructive tests required by 4.5. Qualification for fabrication welding of case or wrought material shall also qualify for repair welding of cast or wrought material within the limits of the qualified procedure. Qualification tests shall qualify for welding positions as specified in 4.2.8.

4.2.7.3 Level II. This qualification level is intended to permit procedure approval for a variation in a procedure, as outlined in 4.8, which has already been qualified by qualification level I. Approval of the required level II welding procedure qualification shall be obtained from the authorized representative. The required level II testing is as follows:

When a plate assembly is used, at least 15 inches of weld shall be inspected by radiography and ultrasonics (when required) as specified in table VII. If pipe is used for qualification, the largest size used in production shall be employed but need not be greater than nominal 3 inches in diameter and shall be inspected by radiography and ultrasonics (when required) as specified in table VII. Where thickness or geometry is such that radiography cannot be used, ultrasonic examination and two macro sections shall be substituted. Inspection requirements and acceptance standards shall be as specified in 4.5.1 and 4.5.2.6. Thickness of test assembly joint design and welding position to be used for the qualification shall be at the discretion of the qualifying activity. As an alternate, 15 inches of production weld or the largest size pipe used in production may be inspected by radiography and ultrasonics (when required) as specified in table VII for level II qualification. For weld surfacing, level I tests shall be used.

4.2.8 Welding position Qualification limits. The orientation of positions for welding procedure qualification test assemblies shall be classified by reference to the positions shown on figure 1. Procedure qualification test assemblies welded in a given position shall qualify the procedure as shown in table IV.

4.2.9 Repair of test assembly. Assemblies may be repair welded only under the following conditions:

- (a) The weld defects repaired are not indicative of an inadequate weld procedure, and are representative of defects that would be rejected by nondestructive tests required for production work.
- (b) The repair welding is representative of repair that would be performed on production work.
- (c) No cracks, other than crater-cracks, may be repair welded.
- (d) Only one cycle of repair welding is permitted.
- (e) Test results, including a description of the nondestructive test results which failed to meet the requirements, and repair work performed to correct the condition, shall be submitted with the procedure qualification test report.

4.2.10 Transferral of welding procedure qualification. Requalification of previously qualified procedures shall be required for procedures transferred from one activity to another.

4.2.10.1 Transfer of qualified procedures between sites of an activity shall be governed by requirements stated in the activity's quality assurance manual (see 3.1.3) and shall require approval by the authorized representative.

4.2.10.2 Transfer of qualified procedures from one Navy shipyard to another Navy shipyard shall require NAVSEA approval.

4.2.10.3 Procedures contained in NAVSEA technical manuals for specific applications may be used without requalification provided:

- (a) The NAVSEA procedure permits use without qualification, or authorization for waiver of qualification is obtained from NAVSEA.

- (b) Welders or welding operators are qualified in accordance with this standard for the applicable welding.
- (c) The NAVSEA procedure is incorporated, by the activity, into a separate written procedure which meets the requirements of this standard and has the approval of the activity's welding engineering representative.
- (d) The activity demonstrates its ability to produce welds, to the satisfaction of the authorized representative, using the final procedure.

#### 4.3 Written welding procedure content.

4.3.1 Essential elements of a welding procedure. Unless otherwise specified in the applicable fabrication document, the welding procedure shall include at least the applicable essential elements listed in table V.

4.4 Specific qualification requirements. This paragraph provides the requirements for qualification test assembly design, size, orientation, and methods of evaluation for qualification of welding procedures for both general applications and special applications.

##### 4.4.1 Groove welds and fillet welds.

4.4.1.1 Base material. Qualification test assemblies shall be made using either base materials procured to the applicable specifications referenced in the procedure or using base materials of the same alloy type or grade procured to alternate Government or commercial specifications. Base material forms may consist of either plate, pipe or other material as specified in table VI.

4.4.1.2 Test assembly size. Typical test assemblies are shown on figures 2 and 3. The size of each test assembly shall be sufficient to permit removal of the required test specimens, or additional test assemblies shall be welded as required, to furnish the remaining test specimens (see 4.5).

4.4.1.3 Test assembly joint design. The test assembly shall employ a butt weld joint in accordance with MIL-STD-22 or other applicable fabrication document. Joint design requirements for HAZ toughness testing shall be as shown on figure 24. A test assembly for preplaced filler metal insert joints shall include a consumable insert of the same material and shape as that to be used in production.

4.4.1.4 Test assembly for qualification of root deposition. If qualification is being performed for deposition of the root layer or for depositing previously qualified fill procedures over the root layer, only the root layer and one layer of fill material need be deposited over the root using the procedure to be followed in production welding (see table VII, note 13).

4.4.1.5 Material thickness qualification limits. Table VI indicates the material thickness range qualified by a specific qualification test material thickness. Qualifications performed in accordance with 4.4.1.4 are not subject to table VI, that is, the root deposition method is qualified thereby, and the qualification limits of the fill pass procedure govern the composite thickness qualification limits.

4.4.1.6 Post weld heat treatment. Test assemblies shall be subjected to the same post weld heat treatment as that required for production weld joints.

4.4.1.7 Joint design qualification limits. Qualification using a standard butt joint design qualifies casting repair welding and all standard joint designs of the applicable fabrication document or MIL-STD-22, including fillet welds of any size and edge seal welds, subject to the restrictions specified in 4.7.3 and 4.8.

4.4.1.8 Evaluation of procedure qualification test results. Evaluation of procedure qualification weldments shall be in accordance with 4.5.

4.4.1.9 Use of qualified groove butt weld procedures for repair, butter and build-up. Groove weld procedure qualification shall constitute approval for repair, buttering and build-up with deposited metal depth limited to the maximum thickness limitations of the procedure.

4.4.1.10 Qualification requirements for automatic/machine welding. Welding procedure qualification tests shall meet the requirements of 4.4.1.10.1 through 4.4.1.10.3.

4.4.1.10.1 Pipe. One weld in each qualifying position shall be made on the smallest and largest sizes (combination of diameter and nominal thickness) to be welded in production using the procedure being qualified, except that qualification testing employing a 5-inch diameter, 3/8-inch wall pipe or larger, shall qualify for all larger pipe (both diameter and thickness) within the limits of table VI. Both the small and large pipe shall be nondestructively tested and the larger pipe shall be destructively tested in accordance with table VII. Socket weld qualification shall be as specified in 4.4.7.1.

4.4.1.10.2 Plate. A qualification test assembly weld of sufficient length to provide the required test specimens shall be made to each qualifying position. The qualification test assemblies shall be tested as required by 4.5.

4.4.1.10.3 Special automatic/machine welds. Qualification requirements shall be as specified in 4.2.5.

4.4.1.11 Fillet welds - welding on bare surfaces. When this standard is specified in the applicable fabrication document, procedures for depositing fillet welds on bare surfaces (except for piping system applications, see 4.4.7) may be qualified in accordance with figure 8. The test assembly shall be welded with the type and largest diameter electrode to be used. Weld quality shall be considered acceptable provided visual examination of fractured weld surface discloses no cracks and no more than five porosity indications (including both "wormholes" and "porosity") larger than 1/16 inch in diameter in any 1 inch of weld. Any indication larger than 3/32 inch is unacceptable and the test assembly shall be rejected. Fillet weld qualifications in accordance with figure 8 are limited to those base metal/filler metal combinations acknowledged in MIL-STD-1628. Butt weld qualification may also qualify for fillet weld joints.

4.4.1.12 Fillet welds - welding over primer-coated surfaces. When this standard is specified in the applicable fabrication document, procedures for welding over primer-coated surfaces of S-1 materials with any process using a previously qualified procedure shall require an additional qualification in accordance with figure 9. The test assembly shall be welded with the type and the largest diameter electrode to be used. Weld quality shall be considered acceptable provided visual examination of the fractured weld surface does not disclose more than 5 porosity indications (including both "wormholes" and "porosity") larger than 1/16 inch diameter in any 1 inch of weld. Any indication larger than 3/32 inch is unacceptable and the test assembly shall be rejected.

4.4.2 Qualification requirements for weld surfacing. Buildup or buttering is qualified by qualification of a groove-weld procedure. Weld cladding shall be qualified as specified in 4.4.2.1. Hardfacing shall be qualified as specified in 4.4.2.2. Weld surfacing qualifications shall not be limited to a maximum thickness of base material on which to weld, except that the weld deposit shall not exceed the thickness of the base material qualified by the limitations of table VI.

4.4.2.1 Weld cladding for corrosion resistance. The test assemblies shall duplicate the production cladding with respect to the base material, filler material type, and welding positions except that base and filler material groupings of tables I and II and the cross qualification rules of table III shall apply. Position limitations for qualifications shall be as outlined in 4.2.8. The clad area and thickness shall be as shown on figures 4 or 5 as applicable. Testing shall be as specified in table VII. The weld clad surface shall be finish machined and liquid penetrant inspected. The test assembly shall meet the acceptance standards for weld overlay class 1 (finished machined surface) of NAVSEA 0900-LP-003-8000. The macro-specimens shall be examined and evaluated as specified in 4.5.2.6.

4.4.2.2 Hardfacing for wear resistance. The test assemblies shall duplicate the production hardfacing with respect to the base material, filler material type, and welding positions except that base and filler material grouping of tables I and II shall apply. Position limitations for qualifications shall be as outlined in 4.2.8. The hardfaced area shall be at least 4 inches by 1 inch finished surface area of weld metal (see figure 6). The hardfacing surface shall be machined to the finished dimensions shown on figure 6 prior to hardness testing. Testing shall be as specified in table VII. The hardness of any hardfacing weld deposit shall be as specified in the applicable Military specification, commercial specification, or manufacturer's data sheet. After hardness testing, the assembly shall be sectioned to provide a minimum of three coupons for macro-examination in accordance with 4.5.2.6.

4.4.3 Dissimilar metal welds. The test assembly shall be the joint design shown on figure 7 or a standard butt Joint design as specified in the applicable fabrication document or MIL-STD-22. The type and number of test specimens to be removed from the test assemblies shall be as specified in table VII. For the purposes of tables VII and VIII, the following combinations of S-groups are not, considered to be dissimilar metal. welds within each grouping:

- (a) S-1, S-2, S-3, S-3A, S-4, S-5, S-11A and S-11B.
- (b) S-21, S-22, S-25 and S-26.

- (c) S-35, S-36A and S-36B.
- (d) S-37A and S-37B.

The range of base material thickness qualified by the test assemblies shall be as specified in table VI. If plate is used, either longitudinal or transverse bend testing shall be employed. If pipe is used, radiographic inspection in lieu of bend testing shall be employed.

4.4.4 Resistance welding. Procedure qualification for resistance welding shall be in accordance with the requirements of MIL-W-6858.

4.4.5 Stud welding. Stud welding procedure qualification record shall include the following:

- (a) Intended application.
- (b) Equipment used.
- (c) Stud material and size.
- (d) Base material.
- (e) Gas shield and flow.
- (f) Timer range setting.
- (g) Maximum cable length.
- (h) Amperage range or machine settings.
- (i) Current and polarity.
- (j) Results of bending, flattening or torque testing.

4.4.5.1 Method of qualification. A minimum of 10 studs, as specified in MIL-S-24149/1 through MIL-S-24149/6, shall be welded for each material combination and each nominal weld base diameter to be used in production. Five studs shall be welded in the horizontal position and five in the overhead position, and shall be tested as follows.

- (a) Studs shall be tested by torquing until failure using any convenient means for applying the tensile load axially to the stud, such as the application of a sleeve over the stud using a washer and a nut with force being applied by a torque wrench. To ensure that the weld is loaded primarily in tension, the threads of the stud should be lubricated with molybdenum disulfide, graphite base or comparable lubricant. Torque required shall be not less than the value listed in table XVI for the stud material and size tested except that, when failure occurs outside the weld (in the stud or plate), the test shall be considered satisfactory if the torque was not less than 90 percent of the table value.
- (b) As an alternate to the torque tests, studs may be tested by bending as follows:
  - (1) For carbon steel and austenitic stainless studs, hammer each stud over until at least one-fourth of its length touches the test plate without cracking the weld, or until the stud fails without the weld cracking. In the case of collared studs, remove a portion of the collar in order to permit hammering of the stud.

- (2) For aluminum (5000 series) studs, each stud shall be bent to an angle of 15 degrees with no visible evidence of cracking in the weld zone or shank. The device used for bending may be similar to that shown on figure 10.
- (c) For load bearing applications add five additional studs to be welded. Section each stud-weld junction through the diameter along the long axis of the stud. Polish, etch and examine the weld and HAZ under 5X to 10X magnification. Linear indications 1/16 inch and greater in length shall be cause for rejection.

4.4.5.2 Procedure requirements. The stud welding procedure shall contain as a minimum the requirements listed in 4.4.5.

4.4.6 Welds made without adding filler metal. The test assembly shall consist of a duplicate of the production welds. Each test assembly shall be fully tested in accordance with 4.5. Where test assembly size or shape does not permit the above, testing two macro sections may be substituted for the destructive tests. Unless otherwise approved, the thickness qualified shall be limited to the test assembly thickness plus or minus 10 percent.

4.4.7 Seal welds. DiRe socket welds and tube-to-tubesheet welds (except internal tube-to-header welds in boiler components for internal tube-to-header welds, see 4.4.9).

4.4.7.1 Socket welds in pipe with nominal wall thickness less than 3/16-inch, tube-to-tubesheet welds and seal welds (other than edge and fillet type) shall be qualified by welding a test assembly (mock-up) which incorporates the base and filler materials, and weld joint design of the production weldment for the positions involved.

4.4.7.1.1 As a minimum the tube-to-tubesheet mock-up shall consist of 10 consecutively welded joints in each position to be qualified. The mock-up shall simulate the production application in all aspects (that is, same tube hole pattern, tube outside diameter (od) and wall thickness, tube sheet thickness (except 2 inches need not be exceeded), tube hole ligaments joint variables, number of passes, filler material diameter and any other variable which contributes to the integrity of the joint). All mock-up variables and any variation desired for production welding shall be identified in the submittal.

4.4.7.2 For socket welds in pipe of thickness greater than above and edge and fillet type seal welds, qualification shall be as above or by butt weld qualification in accordance with section 4.

4.4.7.2.1 Fillet type seal welds in pipe with nominal wall thickness less than 3/16-inch shall be qualified in accordance with 4.4.7.1.

4.4.7.3 For all socket welds. If the base material/filler material combination involved is not covered by MIL-STD-1628, a butt weld qualification in accordance with section 4 is required. This butt weld qualification shall be in addition to the tests required for 4.4.7.1 For automatic and machine welded socket welds, two mock-ups shall be prepared in accordance with 4.4.1.10 and inspected in accordance with 4.4.7.5.

4.4.7.4 In vertical pipe axis or 45-degree inclined pipe axis position socket welds, the fitting shall be on top of the pipe.

4.4.7.5 Mock-ups shall be visual and dye penetrant inspected in accordance with 4.5 and then sectioned into 4 quadrants (each tube-to-tubesheet weld shall be sectioned into 4 quadrants) and inspected in accordance with 4.5.2.6.

4.4.7.6 Seal weld qualification shall not be limited to a maximum base material thickness.

4.4.7.7 Welding procedure and qualification test data for tube-to-tube sheet welding shall be submitted for approval to NAVSEA.

4.4.8 Special welds. Special welds as defined in 3.2.11 shall be qualified, inspected, evaluated and recorded to all applicable requirements of this standard. In addition, for base metals and welding processes not covered by this standard, all variables and special techniques considered essential in producing a weld that will meet minimum material mechanical properties and the inspection requirements of this standard shall be recorded and submitted with the procedure to NAVSEA for approval. Refer to 4.2.5 for approval of procedure qualification for special welds.

4.4.9 Internal tube-to-header welds in boiler components. As a prerequisite each activity shall have a qualified butt welding procedure for the materials, preheat, welding process, post weld heat treatment and positions involved. The butt weld qualification test assembly shall be at least 5/8 inch thick. The requirements of this paragraph are applicable only to manual welding. For other than manual welding, qualification shall be in accordance with 4.4.8.

4.4.9.1 Qualification shall consist of welding and testing a mock-up in accordance with the following:

- (a) The mock-up shall consist of six joints which are welded consecutively.
- (b) Each joint shall simulate the production weld joint except:
  - (1) Groove depth shall be 3/16 inch minimum.
  - (2) Flat plate of the required alloy may be used. Plate thickness shall be at least 1 inch.
- (c) The number of weld passes for each joint shall equal the minimum number of passes allowed for production welding.
- (d) Position of welding shall be in accordance with 4.2.8.
- (e) Root pass welds shall be inspected visually and with dye penetrant or magnetic particle for porosity, cracks, slag and fusion in accordance with 4.5. Reentrant angle between weld and sidewalk shall be 90 degrees minimum and surface condition shall be as specified in (f) below.
- (f) Completed welds shall be inspected visually and with dye penetrant in accordance with 4.5. Root pass and final welds shall also be inspected to the requirements of NAVSEA 0951-LP-031-8010 for size, surface condition and other controlled attributes.

- (g) After completion of required NDT, three of the six welds shall be macro sectioned into quadrants and the resulting surfaces prepared and examined in accordance with 4.5.2.6(b) and (c). At least one section of each weld shall be taken through a root weld pass start.
- (h) The remaining three welds (and tubes) shall be machined down to 1/32 inch plus 1/32, minus 0 below the base material surface, examined, then machined to 1/32 inch plus 0 minus 1/64 above the original groove bottom and examined again. Examination and preparation of machined surfaces shall be in accordance with 4.5.2.6(b).
- (i) Acceptance criteria for NDT and macro section examination shall be based on tube wall thickness except that reinforcement shall be 1/8 inch maximum.
- (j) Failure of either the root pass or final weld by any inspection or test on any joint shall constitute failure of the qualification test. For compliance with 4.2.9(d), repair of a root pass defect shall preclude further repair.
- (k) Test failure shall require retesting of another complete (that is, six tube joints) mock-up.

4.5 Evaluation of procedure qualification weldments. This section provides methods for evaluation of the tests required for the qualification welding procedures. The type and number of destructive tests required for each assembly are shown in table VII.

4.5.1 Nondestructive tests. Prior to performing any destructive tests all procedure qualification test assemblies shall be non-destructively tested as required in table VII.

4.5.1.1 Visual. Visual examination shall ensure suitability of the weld surface for performance and evaluation of the required nondestructive testing. Grinding of weld surface is permitted to meet the acceptance criteria of NAVSEA 0900-LP-003-8000. Titanium and titanium alloy welds and weld beads shall exhibit a bright and shiny silvery luster.

4.5.1.2 Radiography, magnetic particle, liquid penetrant and ultrasonic. Radiography, magnetic-particle, and liquid-penetrant inspection shall be performed in accordance with MIL-STD-271. Ultrasonic inspection shall be performed in accordance with MIL-STD-271. Backing bars, if employed, may be removed and weld reinforcement ground smooth, prior to radiography and ultrasonic inspection.

4.5.1.3 Acceptance standards. Acceptance standards for magnetic-particle, liquid penetrant, and visual examination shall be based on the requirements of NAVSEA 0900-LP-003-8000, class I. For acceptable visual appearance for titanium and titanium alloy welds refer to 4.5.1.1. Acceptance standards for radiography shall be based on the requirements of class I of NAVSEA 0900-LP-003-9000. Acceptance standards for ultrasonic testing shall be class I of NAVSEA 0900-LP-006-3010.

4.5.2 Destructive tests. Required specimen preparation, dimensions, and mechanical testing shall be in accordance with AWS B4.0. Test results shall be evaluated as outlined in 4.5.2.1 through 4.5.2.6.

4.5.2.1 Transverse weld tension tests. For acceptance, transverse weld tension test specimens shall have a tensile strength that is not less than:

- (a) The minimum specified in the applicable base material specification. If materials of different minimum tensile strengths are used, the strength of the weaker material governs.
- (b) The specified minimum tensile strength of the weld metal in those cases where the fabrication documents allow the use of weld metal of lower room temperature strength than the base materials.
- (c) The maximum yield strength specified for the weakest of the two base materials for weldments made of materials without specified ultimate tensile strengths (such as HY-80).

In the above cases, if the specimen breaks in the base material outside of the weld or fusion line, the test shall be accepted as meeting the requirements, provided the strength is not more than 5 percent below the requirements specified herein. For castings, see note I of table VII.

4.5.2.2 Weld metal tension tests. For acceptance, weld metal tension test specimens shall meet the minimum specified mechanical properties of the applicable filler material specification.

4.5.2.3 Guided bend tests. When guided bend tests are specified in table VII, joints of similar materials shall be tested by transverse bends, and joints of dissimilar materials shall be tested by longitudinal or transverse bends.

4.5.2.3.1 Criteria for acceptance. For acceptance, the guided bend specimen after bending shall have no cracks or other open defects greater than 1/8 inch (except weld cladding). The maximum open defect dimension in the cladding of corrosion-resistant weld clad bend tests shall be 1/16 inch. Cracks occurring on the corners of the specimen during testing shall not be considered unless there is definite evidence that they result from slag inclusions or other internal defects. Openings in the base metal outside the weld deposit and heat affected zone shall not be cause for rejection.

4.5.2.4 Impact test. When specified in notes to table VII, specimens shall be prepared and tested. Weld metal Charpy V-notch specimens shall be taken transverse to the axis of the weld groove with one surface of each specimen not less than 1/16 inch below the finished surface of the weld after the removal of the weld reinforcement. The length of the notch shall be perpendicular to the surface of the weld. Base metal and heat affected zone (HAZ) specimens shall be removed in accordance with figure 2 and figure 24. Weld tests shall be evaluated to the requirements of the filler metal specification. Base metal and HAZ impact tests shall be evaluated to the requirements of the applicable base metal specification. Dynamic tear testing shall be in accordance with ASTM E 604 and may be substituted for Charpy V-notch testing as allowed in note 14 of table VII.

4.5.2.5 Hardness test. Specimens shall be prepared and evaluated in accordance with 4.4.2.2.

4.5.2.6 Macro-etch specimens. Specimens shall be removed transverse to the weld, suitably prepared and etched to show weld cross-section, and examined at a minimum of 5X magnification to the following requirements:

- (a) Weld cladding or hardfacing. Discontinuities in the weld area up to and including 1/32 inch in length are acceptable. Incomplete fusion at weld/base metal interface is not permitted. Certain wear resistant alloys are subject to fine cracking which does not defeat the intended purpose. Accordingly, this fine cracking will not be cause for rejection if confined to the weld deposit.
- (b) All other welds. Discontinuities in the weld area greater than 1/32 inch or 10 percent of the thickness of the weld, whichever is less, are unacceptable. Each cross-section shall exhibit no cracks, except that linear or rounded conditions at the root of partial penetration welds (including welds with backing rings or straps that are not removed) are acceptable (unless rejectable by (c) below) provided they do not exceed 1/32 inch in length and adjacent linear defects are not closer than 1/8 inch. For partial penetration welds, root conditions outside the original joint configuration shall not be evaluated. The pipe or tube inner diameter surface of socket and seal welds shall reveal no evidence of melting or burn through.
- (c) Tube-to-tubesheet and tube-to-header welds. Unless otherwise specified by the governing drawing, fabrication document, and so forth, weld throats (minimum leakage path) of all eight faces shall be no less than two-thirds of the specified wall thickness. All faces shall be free of cracks.

4.5.3 Special tests. When tests, such as explosion-bulge, dynamic tear and other tests not detailed in this standard are required, these tests will be specified by NAVSEA and information as to methods and guidance for performance of the require test and acceptance criteria will be provided at that time.

4.6 Data accumulation and reporting for procedure qualification. This section specifies the requirements for procedure qualification data reporting to obtain approval of a welding procedure qualification test report.

4.6.1 Test report. The welding procedure qualification test report shall include the essential elements of the welding procedure, as specified in table V, the destructive and nondestructive test results, and the repair data required in 4.2.9, if applicable, in sufficient detail to assure compliance with the requirements of tables III and VI. When heat affected zone (HAZ) Charpy V-notch (CVN) testing is performed, photomacrographs of CVN-HAZ specimens, and notch location shall be submitted with the test report (see figure 24). A sample for welding procedure qualification test report with form for data accumulation is provided for guidance only (see figure 11). The report shall contain a certification statement in accordance with 4.2.2.

4.6.2 Maintenance of records. The approved procedure qualification reports shall be retained by the activity as long as the procedure is applicable. Each qualifying activity shall retain the pertinent qualification test data, destructive test specimens and nondestructive test result reports including radiographs until written approval of the qualification data is obtained.

4.7 Changes requiring level I requalification of procedure. New welding procedure qualification test data shall be submitted to the authorized representative for approval, when any of the changes listed herein are made in the welding procedure. Changes other than those listed in this paragraph and those listed in 4.8 for level II qualification may be made in a welding procedure without the necessity for requalification; however, the revised welding procedure with all changes identified shall be submitted for information to the authorized representative. The changes specified in 4.7.1 through 4.7.8 require requalification of the welding procedure for qualification level I.

#### 4.7.1 Base material.

- (a) Unless as shown in table III, a change from a base material listed under one S-number in table I to a material listed under another S-number, or to any other material not listed in table I (unless considered a part of a group in accordance with note I of table I).
- (b) A change in the base material thickness to a thickness outside the limits for which the procedure was qualified (see table VI).
- (c) In plasma-arc welding when joints are made between two base materials that have different S-numbers, requalification is required even if the two base materials have been independently qualified using the same procedure.
- (d) In group S-11A, a change from HY-80 steel to HY-100 steel except as permitted by table III (see note 5, table III).
- (e) S-43 UNS number N06625 type materials require separate welding procedure qualification.

#### 4.7.2 Filler material.

- (a) Unless permitted by table III, a change from a filler material listed under one A-number in table II to a material listed under another A-number or to any other material not listed (unless considered a part of a group in accordance with note 1 of table II) except as follows:

- (1) When A-2C materials are used for joining materials with toughness requirements that are 1/2-inch thick and greater, a change from one group to another group as follows:

Group A - MIL-A1 and MIL-B5  
Group B - MIL-B1, B2, 70S-1 through 70S-6 and 70S-8  
Group C - MIL-70S-7 and MIL-70S-9

- (2) In A-2C materials, for MIL-B1 wire, a change from MIL-F4, flux to any other flux or vice-versa.
- (b) In submerged-arc welding, a change in the type flux used, except as permitted in table II.
- (c) In plasma-arc welding, the addition or deletion of supplementary powdered filler metal.

- (d) In plasma-arc welding or weld surfacing, a change in the form of filler metal from solid to fabricated wire, flux cored wire, powdered metal or vice versa.
- (e) In plasma-arc weld surfacing, a change from a homogeneous powdered metal to a mechanical mixed powdered metal or vice versa.
- (f) For internal tube-to-header welds in boiler components.
  - (1) A change in electrode coating classification, that is, MIL-XX15 to MIL-XX16 or MIL-XX18, and so forth, and vice-versa; or:
  - (2) An increase in electrode diameter of 1/32 inch or more from that qualified for any weld pass.
- (g) In stud welding, a change in the nominal weld base diameter of the stud.
- (h) For weld surfacing applications, when using the automatic or mechanized gas tungsten-arc or plasma-arc processes, a reduction of 10 percent or greater in the filler wire (or powder) feed rate from that recorded in the procedure qualification record.
- (i) See table II, note 2.
- (j) For submerged-arc welding, a change in the flux trade name when the flux is not classified in table II. Also a change in the flux type (for example, neutral to active and vice-versa) for multilayer welds in S-1 or S-2 materials.

#### 4.7.3 Joint design.

##### 4.7.3.1 For full penetration joints welded from one side only:

- (a) The omission of a backing ring or backing strip.
- (b) The addition or omission of a preplaced filler metal insert, except that welding a full penetration joint with or without a preplaced filler metal insert qualifies also for welding joints with a backing ring or backing strip.
- (c) Change in the shape of a consumable insert.
- (d) Change from a metal backing strip to a ceramic or other non-metallic backing strip. Full penetration joints welded from one side only with or without a backing ring, backing strip or preplaced filler metal insert, also qualify for welding full penetration joints welded from both sides and partial penetration joints.

##### 4.7.3.2 In tube-to-header joints for boiler components:

- (a) A 1/32 inch or more decrease in root opening from that qualified. (Root opening is one-half the difference between nominal tube od and nominal counterbore size.)
- (b) A decrease in included angle of 5 degrees or more from that qualified (any beveling of the header side of the counterbore shall also be considered as Part of the weld joint with angular decreases of up to 10 degrees provided the root opening is at least 1/16 inch greater than that qualified).

- (c) For tube end lands 1/16 inch and less, a decrease in tube end land below that qualified.
- (d) An increase in counterbore depth of 1/32 inch or greater beyond that qualified, except that qualification performed on 3/16 inch deep counterbores shall qualify up to and including 1/4 inch deep counterbores.

#### 4.7.4 Process.

- (a) A change from one welding process to another process (shielded metal-arc, gas metal-arc, oxyacetylene, gas tungsten-arc, flux cored-arc, and so forth),
- (b) For gas tungsten-arc process and plasma-arc process, the addition or omission of filler material or a change from electrically hot to cold-wire or vice-versa. The addition of filler material at the end of the pass to fill craters is not cause for requalification.
- (c) A change within a process of arc-metal transfer characteristics such as gas metal-arc spray or pulsed spray transfer to short-circuiting arc transfer or vice versa, or electro-slag to electro-gas or vice versa. A change to or from the pulsed arc mode in gas tungsten-arc welding.
- (d) A change from machine/automatic to semi-automatic and vice-versa.
- (e) A change from single-arc to multiple-arc, or vice-versa, or a change to another type of multiple-arc (for example, from series to parallel-arc).
- (f) A change from manual to machine, automatic or semi-automatic and vice versa.
- (g) In plasma-arc welding or weld surfacing a change in the arc from transferred to non-transferred or vice versa.
- (h) In plasma-arc welding or weld surfacing the addition or elimination of an oscillating motion of the torch or filler wire.
- (i) In automatic weld surfacing with oscillation the addition or deletion of a dwell period in the oscillation.
- (j) In automatic weld surfacing a change from a simple harmonic to a constant velocity oscillating motion or vice versa.
- (k) In plasma-arc welding or weld surfacing a change in the type or model of welding equipment.

#### 4.7.5 Electrical characteristics.

- (a) Except for a shielded metal-arc process, a change in the welding current from alternating current (ac) to direct current (dc) or vice versa or a change in polarity.
- (b) For base metals having toughness requirements, an increase in the heat input over that qualified. The heat input shall be by the following formula:

$$\text{Heat input (joules/inch)} = \frac{\text{Voltage} \times \text{amperage} \times 60}{\text{travel rate (inches/minute)}}$$

Fabrication document requirements for heat input shall not be exceeded in any case.

- (c) For qualification of socket and fillet type seal weld procedures in pipe with nominal wall thickness less than 3/16 inch, in welding current greater than 10 percent from that used to qualify the procedure for a specific pipe wall thickness.

4.7.6 Position. A change to a position other than one already qualified as specified in 4.2.8 . Also a change in weld progression from vertical up to vertical down, or vice versa, for any base material having toughness requirements (except root pass welds which are completely removed by backgouging) .

4.7.7 Shielding gas (torch, purge gas and powder feed gas) .

- (a) A change from a mixture of gases to another mixture of gases or to a single gas.
- (b) A change from a single gas to another gas or mixture of gases.
- (c) For the plasma arc process a change in composition or flow rate of the orifice gas.
- (d) A change of more than 5 percent of any component non-inert gas in gas mixture.
- (e) When using a mixed inert gas, a change of plus or minus 25 percent or 5 cubic feet per hour (whichever is larger) in the flow rate of the minor constituents of the gas mixture.
- (f) A decrease of more than 10 percent or 5 cubic feet per hour (whichever is larger) in the rate of gas flow below that used during qualification for shielding gases only.
- (g) The addition or deletion of a shielding gas.
- (h) Elimination of purge gas except that purge gas may be deleted as follows:
  - (1) Welds rewelded from the reverse side.
  - (2) For other than S-51 and S-53, partial penetration and fillet welds and groove welds made with backing strips or rings.
  - (3) For other than S-51 and S-53, socket welds unless qualification was performed with socket weld joints and purging was employed.

For S-51 and S-53 materials deletion of purging shall be as specifically approved in the procedure qualification or as specifically allowed in the applicable fabrication document.

- (i) For plasma arc keyhole welding a change in the nominal composition of the backing (that is, purge) gas or gas mixture.
- (j) See note 8 of table II.

4.7.8 Beat treatment.

- (a) A decrease in preheat or interpass temperature below the minimum temperature specified by the applicable fabrication document.
- (b) An increase in preheat o interpass temperature above the maximum temperature specified by the applicable fabrication document except for S-1 materials.
- (c) The addition or omission of post-weld stress-relief heat treatment, except for S-1 materials (unless required by (e) below).

- (d) A change in post-weld heat treatment outside the temperature range specified in the applicable fabrication document for the materials involved.
- (e) For base metals and weld metals having impact requirements a change in the post weld heat treatment temperature and time range from that recorded in the procedure qualification record. The procedure qualification test shall be subjected to heat treatment essentially equivalent to that encountered during fabrication of the weldments, including at least 80 percent of the aggregate times at temperature.

4.8 Procedure changes requiring level II requalification. One additional qualification test assembly as specified in 4.2.7.3 shall be welded whenever the following changes are made to a procedure qualified under level I:

- (a) An increase in bare electrode, rod or wire diameter, of more than 0.015 inch for gas metal-arc or more than 1/32 inch for gas tungsten-arc and plasma-arc than that previously qualified.
- (b) An increase in covered electrode diameter of over 1/32 inch for horizontal, vertical, and overhead welding and an increase in diameter of over 1/16 inch for flat position welding or horizontal fillets.
- (c) In automatic/machine or semi-automatic welding, a decrease of more than 20 percent in the included angle of the welding groove beyond that qualified.
- (d) A change in particle size of flux used in automatic, machine or semi-automatic submerged-arc welding.
- (e) In tube-to-tube sheet welds, a decrease in the number of weld passes.
- (f) In oxy-fuel gas welding, a change in the type of fuel gas employed.
- (g) A change of more than plus or minus 15 percent in the welding current or voltage from the range qualified for automatic, machine or semi-automatic welding.
- (h) For materials not having toughness requirements (see 4.7.6) a change in weld progression from vertical-up to vertical-down or vice versa (except for root pass welds which are completely removed by backgouging).
- (i) In plasma-arc weld surfacing a change of more than 10 percent in the powdered metal feed rate recorded in the procedure qualification record.
- (j) In plasma-arc weld surfacing a change in the powdered metal particle size range recorded in the procedure qualification record; a change of 15 percent in the amount of dust (minus 325 Tyler Screen equivalent) recorded in the procedure qualification record.
- (k) In plasma-arc welding or weld surfacing a change of 10 percent or more in the diameter of the constricting orifice in the torch.
- (l) In plasma-arc weld surfacing a change of more than 10 percent in the welding current or voltage recorded in the procedure qualification record.

- (m) In plasma-arc welding or weld surfacing a change of more than 5 percent in the flow rate of the plasma gas or powdered metal feed gas recorded in the procedure qualification record.
- (n) In plasma-arc welding or weld surfacing a change of more than 15 percent in the travel speed range recorded in the procedure qualification record.
- (o) In plasma-arc weld surfacing a change, of more than 10 percent in oscillation displacement recorded in the procedure qualification record.
- (p) In plasma-arc weld surfacing a change of more than 10 percent in the filler wire wattage recorded in the process specification. Wattage refers to resistance heated filler wire and is a function of current, voltage and wire stickout dimension.
- (q) In automatic weld surfacing with oscillation, a change in the range of dwell time beyond the range qualified.
- (r) In automatic weld surfacing with oscillation, a change in the frequency of oscillation greater than plus or minus 20 percent beyond the frequency used for qualification.
- (s) In automatic weld surfacing by circumferential deposition, a change in the torch offset greater than a distance which moves the torch plus or minus 5 degrees of the circumference beyond the offset used during qualification.
- (t) A decrease of more than 10 percent in the rate of torch shielding gas flow.
- (u) In automatic welding or weld surfacing, the omission of self-regulating arc length or voltage control if the procedure was qualified with such control.
- (v) For the plasma-arc process, termination of a weld made with the keyhole technique after overlapping a completed part of the weld, as occurs in circumferential welds or in repair welding.
- (w) For internal tube-to-header welding a change of more than plus or minus 10 percent in the actual amperage recorded during qualification.
- (x) For the automatic or mechanized gas tungsten-arc or plasma-arc process an increase of 10 percent or greater in the filler wire or powder feed rate from that recorded in the procedure qualification record.

## 5. WELDING PERFORMANCE QUALIFICATION

5.1 Scope. This section provides the requirements for qualification testing of welders and welding operators. Also included are the requirements for qualification records with suggested record format and forms for data accumulation and reporting.

### 5.2 General requirements.

5.2.1 Responsibility. When this standard is specified by the applicable fabrication document, each activity shall establish that each welder and welding operator to be employed for welding has been qualified by demonstrating his ability to produce welds which meet the requirements of this section. Welder or operator qualification is not required for operators of stud welding and spot welding equipment.

5.2.1.1 Waiver of qualification tests. Qualification tests of welders working on assemblies, the possible failure of which is remote and would not result in danger to the ship plant or structure such as identification plates, galley equipment, furniture, fixtures, miscellaneous outfitting, may be omitted provided this omission is permitted by the applicable fabrication document or is approved.

5.2.2 Prerequisite. As a prerequisite to performance qualification, each activity shall have qualified procedures in accordance with section 4 for all applications for which performance qualification is intended. Although it is essential that the welder be cognizant of the contents of the qualified procedures, this requirement shall not be interpreted to mean that the performance qualification must be accomplished in accordance with any qualified procedure. Performance qualification shall be accomplished as specified in this section. Where multiple performance qualifications are attained as specified in 5.2.5, the welder shall be familiar with the content of each involved procedure. If subsequent procedure qualification data approvals are obtained for procedures for which the multiple performance qualification of 5.2.5 would apply, the qualified welder shall be familiarized with the contents of each new procedure.

5.2.3 Method of establishing qualification. Method of establishing qualification is as follows:

- (a) Each welder and welding operator shall know the workmanship and visual inspection requirements of all fabrication documents to which the welder will be working. To assure this knowledge, each welder and welding operator shall be trained and tested in accordance with a program meeting the requirements of 5.2.3.1.
- (b) Ensuring that each welder and welding operator has satisfactorily welded the applicable performance qualification test assemblies.
- (c) Inspecting each qualification test assembly in accordance with the requirements of this section.
- (d) Evaluating the results of either the destructive or nondestructive tests or both in accordance with the applicable standards unless otherwise specified in this standard.
- (e) Maintaining current records of the extent of each welder and welding operator qualification (see 5.5.1).

5.2.3.1 Training shall be administered in accordance with a program approved by one of the activity's MIL-STD-271 certified level III non-destructive test examiners. This program shall include:

- (a) A written procedure covering all aspects of training, and associated responsibility. A copy of the procedure shall be provided to the authorized representative for approval.
- (b) Training in workmanship and detailed visual inspection requirements of all fabrication documents to which welding is performed.
- (c) Examinations covering detail workmanship and visual inspection requirements to be passed by each person with a grade of no less than 75 percent.
- (d) Approval of items a, b, and c by the level III examiner.

- (e) Maintenance of examination records for each welder or welding operator which shall include: name, fabrication/acceptance standards covered, date of test, and certifying signature of test administrator.
- (f) Re-testing of each welder or welding operator every 3 years.
- (g) Auditing of the entire program by the level III examiner to assure adequacy. Audits shall be conducted at least once in every 2 years.

5.2.4 Alternate qualification methods. As an alternative to 5.2.3(b) qualification requirements for welders or welding operators shall be satisfied as follows:

- (a) Welding a production weld which is radiographically or ultrasonically inspected and found satisfactory. Permission to use this method of establishing performance qualification must be obtained for each welder and welding operator from the authorized representative prior to start of the individual's production work.
- (b) Welding satisfactory procedure qualification test assemblies subject to the limitations of performance qualifications in section 5.
- (c) Qualifying in accordance with the requirements of other U.S. Government agencies, ABS or ASME within the limits imposed this standard, provided evidence of qualification is verified and approved.

5.2.5 Qualification limits by base material, filler metal and process. Multiple performance qualification may be attained by qualifying as outlined in table VIII. When radiography is used for evaluation, S-1 material may be used except as otherwise noted in table VIII. When bend tests are used for evaluation, the base material shall be compatible to the filler metal with regard to weldability and shall be of comparable strength. Utilization of commercially equivalent filler metal (see 5.6.2(a)) is permitted for performance qualification tests.

5.2.6 Qualification limits by position and joint type. The positions and joint types for which a test assembly qualifies are as shown in table IX.

5.2.7 Requirements for special welds. For special welds, the proposed performance qualification program shall be included with the procedure qualification data submitted for approval.

5.2.8 Repair to test assemblies. Test assemblies, other than those or automatic and machine welding, may be repair welded under the following conditions.

- (a) No cracks, other than crater cracks, may be repair welded.
- (b) Only one cycle of repair welding is permitted and the repair shall be recorded on the permanent test records.
- (c) All test results, including a description of the nondestructive test results which failed to meet the requirements shall be recorded on the permanent test record.

Qualification test assemblies for automatic and machine welding shall not be repair welded.

5.2.9 Retests. If a performance qualification test assembly fails to meet the applicable requirements, retests may be allowed under the following conditions:

- (a) One retest may be made without further training for each test assembly that failed.
- (b) Subsequent retests may be made for each test assembly that failed to meet the requirements provided the welder or welding operator has had at least 4 hours of training or practice designed to correct the reasons for previous failures.

5.2.10 Transferral of qualification. Transfer of performance qualification from one activity to another is not permitted without specific approval by the authorized representative.

5.2.11 Maintenance of qualification. Each activity shall establish that an active qualification status is maintained for each qualified welder, or welding operator. This requirement pertains only to process qualification without regard to the initial qualification limitations of 5.2.5 and 5.2.6. Evidence of maintenance of qualification, consisting of at least one verification of process use (that is, fabricator certification of use of "Manual metal arc", "gas metal arc," and so forth), during each 3-month period or calendar quarter shall be maintained.

5.2.11.1 Renewal of qualification. Renewal of qualification due to 3-month or calendar quarter lapse as noted in 5.2.11 shall be made with the specific welding process by making only one test joint (plate or pipe) with all the essential elements used on any one of the welder's or welding operator's previous qualification test joints. This will reestablish the welder's or welding operator's qualification for all conditions for which he had previously qualified with the specific welding process. Renewal of qualifications under all other conditions shall be in accordance with initial qualifications required by this standard except where lesser requirements are approved by the authorized representative.

5.2.11.1.1 Each welder and welding operator shall be re-tested every 3 years in accordance with 5.2.3(a).

5.2.11.2 Loss of qualification. Requalification is required when the representative has specific reason to question the ability of the welder or welding operator to make welds that meet the requirements of the applicable fabrication document.

5.2.12 Vision test requirements. Each welder and welding operator (except or tack, fillet, spot and stud welders) shall be required to pass an annual vision test. Vision tests shall be conducted using standard test methods for determining visual acuity. The standard of acceptance for vision tests shall be natural or corrected near distance acuity such that the individual is

capable of reading J1 letters on the standard Jaeger type chart for near vision. Other equivalent visual tests such as the Snellen chart may be substituted for the Jaeger chart. When corrective aids are used for the vision test, equivalent aids shall be employed in production work.

### 5.3 Performance qualification test requirements.

#### 5.3.1 Manual, semi-automatic, automatic and machine welding.

5.3.1.1 Base material form, size, and thickness. Qualification tests performed on a given base material form and thickness shall qualify as shown in table X with limitations as indicated. Test assemblies employing butt joint designs specified in MIL-STD-22 may be used in lieu of those on figures 14, 15 and 22 provided the thickness requirements of table X are met. Test assemblies which simulate production assemblies may be used in lieu of those specified in table X in which case the qualification will be limited to the base material form and joint design employed and a thickness range of T or 0.058 inch (whichever is less) to 2T (where T is equal to the nominal thickness of the test assembly). Test assembly evaluation shall be as specified in 5.4.

5.3.1.2 Requirements for repair welding of castings. The performance qualification test assemblies for repair welding of castings shall meet the requirements specified in 5.3.1.1. Either cast or wrought base material may be used.

5.3.1.3 Automatic and machine welding. Welding operators shall qualify using equipment possessing control features similar to those of the equipment which will be used to make the production welds and shall be required to set the equipment with regard to adjustments and settings which affect the welding characteristics and weld-bead placement. Welders qualified to a multiple position semi-automatic process shall be qualified to machine/automatic weld multiple positions by performing a single position performance test using the machine/automatic process equipment.

#### 5.3.2 Fuel gas welding.

5.3.2.1 Base material form, size and thickness. Performance qualification tests performed on a given base material form and thickness shall qualify as shown on figures 12 and 13 as applicable. Qualification position limitations shall be as specified in table IX. Test assembly shall be tested and evaluated as specified in 5.4.

#### 5.3.3 Tack and fillet welder.

5.3.3.1 Base material form and size. Qualification tests shall conform to the requirements of table X, test no. 8. The positions for which a test assembly welded in a given position qualify are shown in table IX. Test assembly shall be tested and evaluated as specified in 5.4.

5.3.3.2 Extent of qualification. Tack and filler welders shall be qualified as required by table VIII.

5.3.4 Weld surfacing (hardfacing and corrosion-resisting). Qualification for weld surfacing shall be obtained as permitted by table IX or alternately by table X, test no. 9. Test assembly shall be tested and evaluated by visual, dye penetrant and macroetch examination as specified in 5.4.

5.3.5 Seal, socket and tube-to-tubesheet welds.

5.3.5.1 Seal welds, other than edge or fillet type, socket welds in piping with nominal wall thicknesses less than 3/16 inch, and tube-to-tubesheet welds shall require welding, inspecting and evaluating mock-ups of the production weld in accordance with 4.4.7 except as follows:

- (a) Qualified positions, materials and thicknesses shall be in accordance with section 5.
- (b) Tube-to-tubesheet test assemblies shall consist of a minimum of six joints, all of which are welded consecutively.
- (c) The requirements of 4.4.7.3 do not apply.
- (d) The smallest pipe size to be welded in production shall be used for the socket weld test. This test shall be designated as number 3S.

5.3.5.2 Socket welds in piping with wall thicknesses greater than in 5.3.5.1 and edge and fillet type seal welds, shall require completion of mock-up testing as specified above or pipe butt weld qualification in accordance with section 5.

5.3.5.2.1 Fillet seal welds in piping with wall thickness less than 3/16 inch shall require mock-up testing in accordance with 5.3.5.1.

5.3.6 Internal tube-to-header welding of boiler components. Welders shall be qualified on a test assembly consisting of four joints which are welded consecutively. Joint design shall simulate the production joint except as specified by 4.4.9.1(b). S-1 material may be used. The requirements of this paragraph apply only to manual welding. Qualification shall otherwise be in accordance with 4.4.9. The requirements of this paragraph do not negate any additional requirements as may be imposed by specific component fabrication or repair documents.

5.3.6.1 Welding shall be performed under the space restrictions depicted by figure 25. The entire space restriction assembly shall be held at 400 degrees Fahrenheit (deg. F) minimum for the entire test. The welder shall perform all grinding and any repair weld preparation in the heated assembly. After completion of all welding and grinding of all joints the test assembly shall be removed and cooled as required for root and final weld NDT inspection.

5.3.6.2 The root pass and finished welds of the test assembly shall be non-destructively tested in accordance with 4.4.9.1(e), (f) and (i). Undercut of 1/32-inch maximum is permissible along the plate weld toes.

5.3.6.3 After successful nondestructive testing, all four welds shall be macrosectioned and examined in accordance with 4.4.9.1(g) and (i).

5.3.6.4 Qualification position shall be in accordance with table IX.

5.3.6.5 Failure of either the root pass or final weld by any inspection or test on any joint shall constitute failure of the qualification test. Repair of the test assembly as a result of a root pass defect shall preclude further repair (see 5.2.8(b)).

5.4 Test and evaluation of qualification test assemblies. This section provides for evaluation of test assemblies required for qualification. The tests required for each assembly are as specified in table XI. For suggested removal of destructive test specimens (when used), see figures 12 through 17.

#### 5.4.1 Nondestructive inspection.

5.4.1.1 Visual examination. Visual examination shall be performed for weld surface geometry and weld surface soundness. For titanium and titanium alloy welds refer to 4.5.1.1.

5.4.1.2 Nondestructive test performance. Nondestructive testing shall be performed in accordance with MIL-STD-271. Except as permitted by 5.4.1.3, test assembly welds shall be 100 percent inspected.

5.4.1.3 Acceptance standards. Acceptance standards for magnetic-particle, liquid penetrant, and visual examination shall be based on the requirements of NAVSEA 0900-LP-003-8000, class I. For acceptable visual appearance of titanium, and titanium alloy welds refer to 4.5.1.1. Acceptance standards for radiography shall be based on the requirements of class I of NAVSEA 0900-LP-003-9000. Acceptance standards for ultrasonic testing shall be class I of NAVSEA 0900-LP-006-3010. For plate assemblies, 1 inch of weld at each end of the test assembly need not be evaluated.

5.4.2 Destructive tests. Required specimen preparation, dimensions, and mechanical testing shall be in accordance with AWS B4.0.

5.4.2.1 Guided-bend tests. Acceptance standards shall be specified in 4.5.2.3.1.

5.4.2.2 Break test. The tack and fillet welder qualification test specimen shall be flattened in accordance with figure 16 such that the root of the weld is in tension. The load shall be steadily increased until the specimen fractures. The fractured surfaces shall be examined without magnification. Evidence of cracks, incomplete root function in excess of 10 percent of the weld length, wormholes or porosity in excess of three pores over 1/16 inch diameter in any 1 inch of fillet weld or an accumulation of more than 10 pores in 8 inches of the test plate shall be cause for rejection.

5.4.2.3 Macro-etch specimen. Specimens shall be extracted transversely to the weld, prepared, and etched to show weld cross-section and examined at a minimum of 5X magnification. Acceptance standards shall be as specified in 4.5.2.6

5.5 Data accumulation and records. This section provides requirements for performance qualification data accumulation and maintenance of records. A sample is provided for guidance (see figure 18).

5.5.1 Records. The welder qualification test record shall include at least the following information:

- (a) Welder or welding operator identification (name, clock number or social security number).
- (b) Date of test.
- (c) Qualification test number, process, position, base material type, and filler metal type and size.
- (d) Results of qualification test.
- (e) Record of omission of space restriction when not used in pipe tests.
- (f) Certifying signature by fabricator.

5.5.1.1 The examination specified in 5.2.3(a) shall also be maintained as part of the welder qualification record.

5.5.2 Radiographs, test assemblies, and metallographic sections required for welding personnel qualifications need not be retained.

5.5.3 Detailed records of maintenance of personnel qualification (see need only be retained for the current and preceding calendar quarter.

5.6 Changes requiring requalification of welder or welding operator. Requalification of welder or welding operator is required for the changes specified in 5.6.1 through 5.6.7.

5.6.1 Base material. A change from one base material thickness to thickness outside the limits specified in table X and figures 12 and 13.

5.6.2 Filler material.

- (a) A change from a filler material listed under one A-number in table II to a filler material listed under another A-number, except as permitted by table VIII. Filler materials conforming to AWS, ASTM, ASME, and so forth, classifications, and for which there is qualified procedure (see 5.2.5), may be grouped with the appropriate A-number of table II, and the extent of welder performance cross-qualification by A-numbers shall be as permitted by table VIII.
- (b) For internal tube to header weld joints, a change in electrodes coating classification, that is, MIL-XX15 to MIL-XX16 or MIL-XX18, so forth and vice versa.
- (c) For internal tube to header weld joints, an increase in electrode diameter of 1/32 inch or more than that qualified for any weld pass.
- (d) A change in the form of filler metal from solid to fabricated wire, flux cored wire, powdered metal or vice versa.

- (a) For gas metal-arc, a change from one mode to any other mode (spray, short circuiting, or pulsed).
- (b) For gas tungsten-arc, a change to or from the pulsed arc mode.
- (c) For plasma-arc, a change from transferred arc mode to non-transferred arc mode and vice versa.
- (d) For plasma-arc, a change from welding to weld surfacing and vice versa.
- (e) A change from one welding process to any other welding process (as defined in the master chart of welding and allied processes - AWS A3.0).

5.6.4 Position. A change to a welding position other than one already qualified (see table IX) or a change in progression from vertical up to vertical down or vice versa.

5.6.5 Joint design.

- (a) In full penetration butt joints welded from one side, the omission of a backing ring or backing strip.
- (b) In full penetration butt joints welded from one side, the omission or addition of a preplaced filler metal insert (for the welder or welding operator who makes the root pass or root pass plus an additional layer) except as permitted by table X.
- (c) In internal tube-to-header joints for boiler components:
  - (1) A 1/32 inch or more decrease in root opening from that qualified. Root opening is one-half the difference between nominal tube od and nominal counterbore size.
  - (2) A decrease in included angle of 5 degrees or more from that qualified (any beveling of the header side of the counterbore shall also be considered as part of the weld joint included angle). However, requalification is not required for joints with angular decreases of up to 10 degrees provided the root opening is at least 1/16 inch greater than that qualified.
  - (3) For tube end lands 1/16 inch and less, a decrease in tube end land below that qualified.
  - (4) An increase in counterbore depth of 1/16 inch or greater beyond that qualified, except that qualification performed on 3/16 inch deep counterbores shall qualify up to and including 1/4 inch deep counterbores.
- (d) In full penetration butt joints, the use of a plasma-arc keyhole technique for fusing the root pass.

5.6.6 Accessibility. For pipe welders when there is a change from a condition of no restriction on joint accessibility to a condition of restricted (12 inches and under) accessibility and the existing qualification was made under no restriction (over 12 inches). Refer to figure 21 for layout and construction of restricted accessibility qualification test assembly positions.

5.6.7 Shielding gas.

- (a) For gas shielded-arc welding, a change from argon, helium, or mixtures thereof to mixtures containing more than 5 percent oxygen or more than 25 percent carbon-dioxide or to straight carbon-dioxide and vice versa.
- (b) For plasma-arc welding, when using the keyhole technique, a change in orifice gas from argon to mixtures of argon and helium, or the addition of hydrogen to the orifice gas or gas mixture and vice versa.
- (c) For flux cored arc welding, the deletion of a shielding gas.

5.6.8 Fabrication documents requirements. Welding to the requirements of a fabrication document shall require training and testing on the requirements of that document in accordance with 5.2.3(a).

6. BRAZING

6.1 Scope. This section contains the requirements necessary to qualify brazing procedures, brazers and brazing operators for applications other than piping and pressure vessels. The requirements for piping and pressure vessel applications are contained in NAVSEA 0900-LP-001-7000.

6.2 General requirements. The purpose of these qualification requirements is to ensure that qualified procedures are used with adequate equipment by properly trained personnel. Each activity performing work within the scope of this document shall direct and supervise the necessary qualification tests. Upon completion of all qualification tests, each activity shall certify that the tests and test results meet all the requirements of this standard and shall maintain records of the qualification tests, as specified in 6.3.4 and 6.4.10. Approval of the required qualification test data shall be obtained from NAVSEA or its authorized representative as specified in this section. Subject to approval, procedures, brazers, and brazing operators previously qualified to the requirements of prior issues of this document or to NAVSEA 0900-LP-001-7000 on which qualification records are still available, and qualifications have not lapsed, shall not require requalification.

6.2.1 Specifications covering brazing filler metals require the following caution label, as a minimum, to be prominently displayed in legible type on all individually packaged units.

CAUTION

Welding, including brazing, may produce fumes and gases hazardous to health. Avoid breathing these fumes and gases. Use adequate ventilation.

All brazing procedures and instructions to brazers and brazing operators should carry this or a similar statement and appropriate safety measures should be taken to ensure that brazing is performed under optimum conditions of ventilation.

6.3 Brazing procedure qualification.

6.3.1 Responsibility. Before any brazing is performed, each activity shall accomplish the following:

- (a) Prepare a written brazing procedure including essential elements as specified in 6.3.8.1.
- (b) Qualify the proposed brazing procedure by brazing test assemblies and performing nondestructive and destructive tests in accordance with the requirements of this section. Except as noted herein, procedure qualification tests are not required for manual torch brazing with base materials, brazing alloys and flux combinations specified by table XII. Qualification tests shall be performed for manual torch brazing procedures that specify materials not classified in table XII and for all other brazing processes including those listed in 6.3.1(c) which specifies heating sources other than manual-torch.
- (c) Other brazing processes:
  - (1) Mechanical-torch
  - (2) Furnace
  - (3) Induction
  - (4) Electrical resistance
  - (5) Dip brazing - salt and flux bath

6.3.2 Certification of qualification testing. After testing, the responsible official of the activity shall certify that the tests and the test results meet all requirements of this standard. In as much as the activity is responsible for the quality of its work as well as that of its subcontractors, the activity shall submit qualification tests and data of its subcontractors only after careful review and verification of their completeness. Qualification tests and data containing deviations from requirements may be submitted if such deviations are identified, and the technical justification for each deviation is provided. When brazing to the requirements of the American Society of Mechanical Engineers (ASME) code is specified or approved, the specific component or system specifications or approval letter shall be identified. Procedure qualification previously prepared for other Government agencies, American Bureau of Shipping (ABS), American Society of Mechanical Engineers (ASME), or other established regulatory codes may be used provided qualification testing and approval (by the other Government agencies or regulatory bodies) occurred prior to the activity's invitation for bid or request for proposal. It is the intent of this provision that certified qualification data acquired by these agencies be considered acceptable proof of qualification. Such data shall be submitted for approval as requested in 6.3.3.

6.3.3 Approval and data provision requirements. When qualification testing is required, the activity shall submit the essential elements of the brazing procedure and detail qualification test results to NAVSEA or its authorized representative for approval in accordance with the appendix. Procedures are the activity's responsibility but shall be submitted for information. Resubmission of procedures for changes which do not involve requalification is not required. Brazing procedure submittal does not mitigate the performing activity's responsibility for conformance with the requirements of this document.

6.3.3.1 Requirements. In addition to the general requirements covered by the Data Item Description of the appendix, the following requirements shall also apply.

- (a) Brazing procedure qualification test report. The brazing procedure qualification test report shall be in accordance with 6.3.4.
- (b) Brazing procedure. The brazing procedure shall be in accordance with 6.3.8.

6.3.4 Test report. The procedure qualification test report shall include the essential elements of the brazing procedure as specified in 6.3.9 and the results of the destructive and nondestructive tests specified in 6.3.9.

6.3.5 Maintenance of records. The approved procedure qualification reports shall be retained by the activity as long as the procedure is applicable. Each qualifying activity shall retain the pertinent qualification test data, destructive test specimens and nondestructive test result reports until written approval of the qualification data is obtained.

6.3.6 Vendor qualification. It shall be the responsibility of each activity to assure that its sub-contractors comply with the qualification provisions of this document.

6.3.7 Transferral of brazing procedure qualification. Requalification of previously qualified procedures shall be required for procedures transferred from one activity to another.

6.3.7.1 Transfer of qualified procedures between sites of an activity shall be the same as for welding procedures (see 4.2.10.1).

6.3.7.2 Transfer of qualified procedures between Navy shipyards shall be the same as for welding procedures (see 4.2.10.2).

6.3.7.3 Procedures contained in NAVSEA technical manuals shall be the same as for welding procedures (see 4.2.10.3).

6.3.8 Written brazing procedure content.

6.3.8.1 Essential elements. The brazing procedure shall include the following essential elements as applicable:

- (a) Base metal (pipe/tubing and fitting).
  - (1) Type
  - (2) Specification
  - (3) Thickness range qualified
- (b) Brazing process (see 6.3.1(c)).
- (c) Brazing alloy specification and classification (as specified in table XIV).
- (d) Fluxes where required - specification and type, trade or brand designation.

- (e) Joint design.
- (f) Torch brazing - type of fuel gas.
- (g) Type of flame - that is, neutral, oxidizing, or reducing.
- (h) Furnace (atmosphere), if used.
- (i) Position of brazing.
- (j) Induction brazing - frequency and source of high-frequency electric current.
- (k) Pre-cleaning of base metal joint surfaces - method of cleaning joints (emery, polishing, chemical cleaning, and so forth).
- (l) Fixturing.
- (m) Placement of brazing alloy - method of applying the brazing alloy (face feeding, insert ring, shims, and so forth).
- (n) Joint fit-up - maximum clearances.
- (o) Nondestructive testing requirements (reference to inspection procedure of fabrication plan).
- (p) Applicable thicknesses.
- (q) For procedures involving use of minimum flux technique: fluxing technique and internal purge requirements (if used).

6.3.9 Procedure qualification test requirements. The brazing procedure shall be qualified where required by 6.3.1(b) as follows:

6.3.9.1 Qualification test assemblies. Base materials and brazing alloys shall be as specified in tables XIII and XIV. The size of each test assembly shall be sufficient to permit removal of the required test specimens. The method used in brazing the qualification test assemblies shall be in accordance with proposed brazing procedure. No repair of test joints is permitted. Qualification shall be obtained for the position to be used in production, except qualification in either the flat-flow, vertical-up flow or horizontal-flow position shall also qualify the vertical-down flow position. Material thickness limits are shown in table XV. Butt or scarf joints shall qualify for lap joints and vice versa. Type and number of tests shall be as specified in table XV.

6.3.9.2 Qualification assembly destructive test evaluation.

6.3.9.2.1 Tension test. Reduced specimens conforming to figure 19 shall be used for tension tests. The stress shall be computed by dividing the ultimate load of the nominal total cross sectional area of the thinnest member comprising the joint. The tension specimen shall have as a minimum a tensile strength that is not less than:

- (a) The specified tensile strength of the base material in the annealed condition.
- (b) The specified tensile strength of the weaker of the two members, in the annealed condition, if materials of different specified minimum tensile strengths are used.
- (c) If the specimen breaks in the base metal outside of the braze, the test shall be accepted as meeting the requirements provided the strength is not more than 5 percent below the specified tensile strength of the base material in the annealed condition.

6.3.9.2.2 Peel test. The peel test specimen shall conform to figure 20. The peel specimen shall show evidence of brazing alloy along each edge. Specimens shall be separated or peeled either by clamping "section A" and striking the fulcrum point with a suitable tool or by clamping "section A" and "section B" in a machine suitable for separating the sections under tension. The separated faying surfaces of joints shall meet the following criteria:

- (a) The total area of defects, unbrazed areas, flux inclusions, and so forth, shall not exceed 30 percent of the total area of any faying surface.
- (b) The sum of the lengths of the defects measured on any one line in the direction of the lap shall not exceed 25 percent of the lap.

6.3.9.3 Qualification assembly nondestructive test evaluation. Brazements shall be limited to visual examination without magnification to the following acceptance standards:

- (a) Excess braze metal. Braze filler metal in excess of that required by (c) is acceptable provided the excess alloy does not interfere with the function of the completed assembly.
- (b) Residual flux. Visual evidence of residual flux is not permitted on the surface of a completed joint.
- (c) Evidence of brazing alloy on completed joints. Brazed joints shall be considered acceptable when the total length of exposed brazing alloy along the length or perimeter of the joint is equal to or greater than 3/4 of the joint length.

6.3.10 Changes requiring requalification of brazing procedures. A revised brazing procedure shall be prepared and the procedure requalified when any of the changes specified in 6.3.10.1 through 6.3.10.7 are made (except where qualification is not required as specified in 6.3.1). Changes other than those specified in 6.3.10.1 through 6.3.10.7 may be made without requalifying the procedure but must be documented in the revised procedure.

#### 6.3.10.1 Base material.

- (a) A change from a base material classified under one P-number in table XIII to a material classified under another P-number in table XIII, or to any other base material not classified in table XIII. Requalification is not required when the base material P-numbers have been qualified for brazing in a dissimilar base material joint. (A similar base material joint is one in which both base materials are in the same P-number group.)
- (b) A change in base material thickness to a value outside the range qualified in accordance with table XV.

6.3.10.2 Brazing alloy. A change from a brazing alloy classified under one P-number in table XIV to a brazing alloy classified under another F-number, or to a brazing alloy not classified in table XIV, except that grade IV may be used in repairing by manual torch or induction brazing Joints which were brazed with a brazing alloy of a different F-number, without requalification of the procedure.

6.3.10.3 Braze process. A change from one braze process listed in 6.3.1(c) to another process listed in 6.3.1(c) or to a braze process not listed except as permitted in 6.3.1(b).

6.3.10.4 Flux. A change in type of flux except as permitted by table XII.

6.3.10.5 Furnace atmosphere. A change in the furnace atmosphere from one basic type to another basic type.

6.3.10.6 Induction braze.

- (a) A change in the source of high-frequency electric current (motor generator, resonance spark gap, vacuum tube oscillator, transformer, and so forth).
- (b) A change in the frequency of greater than plus or minus 50 percent of the range qualified.

6.3.10.7 Position. A change in braze position.

#### 6.4 Brazer and braze operator performance qualification.

6.4.1 Responsibility. When this standard is specified by the applicable fabrication document, each activity shall establish that each brazer and braze operator to be employed for braze has been qualified by demonstrating his ability to produce sound and satisfactory joints in accordance with this section.

6.4.2 Prerequisite. As a prerequisite to performance qualification, each activity shall have procedures qualified in accordance with this section for all applications for which performance qualification is intended. Although it is essential that the brazer be cognizant of the contents of the procedure being used for qualification, this requirement shall not be interpreted to mean that the performance qualification must be accomplished in accordance with the qualified procedure. Performance qualification shall be accomplished as specified in this section.

6.4.3 Method of establishing qualification. Method of establishing qualification is as follows:

- (a) Each brazer and braze operator shall know the workmanship and visual inspection requirements of all fabrication documents to which the brazer will be working. To assure this knowledge, each brazer and braze operator shall be trained and tested in accordance with a program meeting the requirements of 6.4.3.1.
- (b) Ensuring that each brazer and braze operator has satisfactorily braze the applicable performance qualification test assemblies
- (c) Inspecting each qualification test assembly in accordance with the requirements of this section.
- (d) Evaluating the results of either the destructive or nondestructive tests or both in accordance with the applicable standards unless otherwise specified in this standard.
- (e) Maintaining current records of the extent of each brazer and braze operator qualification (see 6.4.10).

6.4.3.1 Training shall be administered in accordance with a program approved by one of the activity's MIL-STD-271 certified level III non-destructive test examiners. This program shall include:

- (a) A written procedure covering all aspects of training and associated responsibility. A copy of the procedure shall be provided to the authorized agent for approval.
- (b) Training in workmanship and detailed visual inspection requirements of all fabrication documents to which brazing is performed.
- (c) Examinations covering all significant workmanship and visual inspection requirements to be passed by each person with a grade of no less than 75 percent.
- (d) Approval of items (a), (b), and (c) by the level III examiner.
- (e) Maintenance of examination records for each brazer or brazing operator which shall include: name, fabrication/acceptance standards covered, date of test, and certifying signature of test administrator.
- (f) Re-testing of each brazer or brazing operator every 3 years.
- (g) Auditing of the entire program by the level III examiner to assure adequacy. Audits shall be conducted at least once in every 2 years.

6.4.4 Alternate qualification methods. As an alternative to 6.4.3(b), qualification requirements for brazers or brazing operators shall be satisfied as follows:

- (a) Brazing a production joint which is ultrasonically inspected by qualified personnel and found satisfactory. Permission to use this method of establishing performance qualification must be obtained for each brazer and brazing operator from the authorized representative prior to start of the individual's production work.
- (b) By brazing satisfactory procedure qualification test assemblies.
- (c) By having been qualified by other U.S. Government agencies, American Bureau of Shipping, or ASME, within the limits covered by the qualification tests passed, provided evidence of qualification is verified and approved.

6.4.5 Transferral of qualification. Transfer of performance qualification from one activity to another is not permitted without specific approval by the authorized representative,

6.4.6 Qualification requirements. Brazer qualification shall consist of making a joint in the flat flow and vertical-up flow positions (see figure 23) with the thickness a minimum of 1/16 inch. Each joint when peeled or ultrasonically tested shall show bonding on at least 70 percent of the lapped area. Qualification with any one base material, any one flux and any one brazing alloy qualifies for all combinations listed in table XII for a given process.

6.4.6.1 Brazers qualified for pipe brazing shall be considered qualified for all other brazing within the process, material and thickness limitations of their piping qualification.

6.4.6.2 Fabrication documents requirements. Braze to the requirements of a fabrication document shall require training and testing on the requirements of that document in accordance with 6.4.3(a).

6.4.7 Retests. If a performance qualification test assembly fails to meet the applicable requirements, a retest may be allowed under the following conditions:

- (a) One retest may be made without further training for each test assembly that failed.
- (b) Subsequent retests may be made for each test assembly that failed to meet the requirements provided that brazer or brazing operator has had at least 4 hours of training or practice designed to correct the reasons for previous failures.

6.4.8 Maintenance of qualification. Each activity shall establish that an active qualification status is maintained for each qualified brazer or brazing operator. Evidence consisting of at least one verification of process use (that is, fabricator certification of use of "manual torch brazing", or "induction brazing") at any time during each 3-month or calendar-quarter period, shall be maintained. The intent of this requirement is to cause verification of each production brazer's or brazing operator's use of the qualified processes once in each calendar-quarter subsequent to the quarter in which he was qualified and four times in each subsequent calendar year.

6.4.8.1 Renewal of qualification. Renewal of performance qualification is required (1) when a brazer or brazing operator has not used the specific brazing process in the preceding calendar quarter, or (2) when the authorized representative has specific reason to question the ability of a brazer or brazing operator to make brazed joints that meet the specification requirements. Renewal of qualification under (1) need be made on only a single test assembly in any position and where requirements of 6.4.6 are met renewal will reestablish the brazer or brazing operator's qualification for the specific process for any thickness, position, brazing alloy and base materials for which he was previously qualified unless otherwise specified by the authorized representative.

6.4.8.1.1 Each brazer and brazing operator shall be retested every 3 years in accordance with 6.4.3(a).

6.4.9 Requalification requirements. Requalification of brazers and brazing operators is required for any of the following changes or conditions.

- (a) Base material. A change to a base material not listed in table XIII except as permitted by note 1 thereto.
- (b) Brazing alloy. A change to a brazing alloy not listed in table XIV except as permitted by note 1 thereto.

6.4.10 Test records. Qualification test records of each brazer or brazing operator, together with identification data, shall be kept by the activity. These records shall include the following information:

- (a) Brazer or brazing operator identification (name, clock number or social security number).
- (b) Date of test.
- (c) Process, position, base material types (P-No.) material thickness and brazing alloy type (F-No.).
- (d) Results of qualification tests.
- (e) Record of space restrictions, if applicable.
- (f) Certifying signature by activity delegated representatives.

6.4.10.1 Detailed records of maintenance of personnel qualification (see 6.4.8) need only be retained for the current and preceding calendar quarter.

6.4.10.2 The examination of 6.4.3(a) shall also be maintained as part of the brazer qualification record.

6.4.11 Vision test requirements. Each brazer or brazing operator shall be required to pass an annual vision test. Vision tests shall be conducted using standard test methods for determining visual acuity. The standard of acceptance for vision tests shall be natural or corrected near distance acuity such that the individual is capable of reading J1 letters on the standard Jaeger type chart for near vision. Other equivalent visual tests such as Snellen chart may be substituted for the Jaeger chart. When corrective aids are used for the vision test, equivalent aids shall be employed in production work.

## 7. NOTES

### 7.1 Subject term (key word) listing.

Machine welding, automatic  
Machine welding, manual  
Machine welding, semi-automatic  
Procedure, brazing  
Procedure, welding

7.2 Changes from previous issue. Asterisks are not used in this revision to identify changes with respect to the previous issue due to the extensiveness of the changes.

#### Custodians:

Army- MR  
Navy- SH

#### Preparing activity:

Navy - SH  
(Project THJM-0116)

#### Review activities:

Army - AV, AT  
Navy - OS, MC  
DLA - GS

#### User activity:

Army - MI

TABLE I. Grouping of base materials (welding).<sup>L1J</sup>

Letter number	Applicable document	Class or type
S-1	Carbon steel	
	ASTM A 216	WCB
	ASTM A 515	Grade 55 (plate) Grade 60 (plate) Grade 65 (plate) Grade 70 (plate)
	ASTM A 516	Grade 70 (plate)
	WW-P-404	Pipe seamless and welded
	MIL-S-15083	Grade 70-36 (cast) Grade 65-35 (cast) Grade CW (cast) Grade B (cast)
	MIL-T-16286	Class a (tube seamless) Class g (tube seamless)
	ASTM A 178	Tubes welded
	MIL-S-24093	Forgings
	MIL-T-20157	Type E (tube and pipe)
	MIL-S-24412	Grade HT (shape)
	MIL-F-20236	Flanges, pipe
	MIL-F-20670	Flanges, pipe
	MIL-S-22698	Plate, bar and shapes
	MIL-S-23194	Composition C (forgings)
	MIL-S-23284	Class 3 Class 4
	MIL-S-24238	Composition C (plate)
	MIL-P-24338	Pipe
	MIL-F-24339	Fittings and flanges
S-2	Quenched and tempered carbon steel	
	ASTM A 537	Class 2
S-3	Carbon molybdenum steel	
	MIL-S-870	CMo (cast)
	DOD-F-24669/2	CMo class a (forgings) CMo class b (forgings)
	MIL-T-16286	CMo class d (tube)
	DOD-F-24669/1	CrNi type 8620 (bar and forgings)
	MIL-T-20155	CMo (tube and pipe)
S-3A	Alloy steels (Cr content not to exceed 3/4 percent; total alloy	
		not to exceed 2 percent)
	ASTM A 3	MnMo grade B (plate)
	MIL-S-23194	NiCrMo Comp. A (forgings)
	MIL-S-24238	NiMnMo Comp. A (plate)

See footnotes at end of table.

TABLE I. Grouping of base materials (welding). <sup>L1</sup>J - Continued

Letter number	Applicable document	Class or type
S-4	Alloy steels (Cr content 3/4 - 2 percent, total alloy not to exceed 2-3/4 percent)	
	AMS 6530	CrNiMo, type 8630 (tube)
	MIL-T-6736	CrMo, type 4130 (tube)
	MIL-S-8699	CrMoV, type 4330 (bar, forging)
	MIL-S-15464	CrMo class 1 (casting)
	ASTM A 182	F11
	ASTM A 213	Grade T11 (tube)
	DOD-F-24669/1	CrMo type 4130 (bar)
	MIL-P-24691/2	CrMo, grade P11 (tube and pipe)
	DOD-F-24669/2	CrMo, class a (forgings)
	MIL-S-18728	CrNiMo, type 8630 (plate)
	MIL-S-18729	CrMo, type 4130 (plate)
S-5	Alloy steels (total alloy content 10 percent max)	
	ASTM A 182	F22
	ASTM A 213	T22
	MIL-S-860	CrMoV, grade F (forgings)
	MIL-S-15464	CrMo, class 2 (casting)
	MIL-T-16286	CrMo, class e (tube)
	MIL-P-24691/2	CrMo, grade P22 (tube and pipe)
	DOD-F-24669/2	CrMo, class b (forging)
	DOD-F-24669	CrMo, (bar and forgings)
S-6	High alloy steels (martensitic)	
	MIL-L-24128	403 (bars, rods, forgings)
	QQ-S-763	403, (bars, rods, forgings) 410 414 420
	QQ-S-766	410, (plate, sheet, strip) 420
	DOD-F-24669/7	403 (bars) 410
	DOD-F-24669/6	403 (bars) 410 414 420
	MIL-S-16993	12 percent Cr, class 1 (casting) 12 percent Cr, class 2 (casting)
S-6A	High alloy steels (martensitic)	
	ASTM A 182	F6NM (forgings) <sup>L3</sup> J
	ASTM A 240	410S (plate, sheet, strip)
	ASTM A 473	410S (forgings)
	ASTM A 487	Ca6NM (castings) <sup>L3</sup> J

See footnotes at end of table.

TABLE I. Grouping of base materials (welding). L1J - Continued

Letter number	Applicable document	Class or type
S-7	High alloy steels (ferritic)	
	QQ-S-763	405 (bar, shapes, forgings) 430
	QQ-S-766	430 (plate, sheet, strip)
S-8	High alloy steels (austenitic)	
	QQ-S-763	304 (bar, shapes, forgings) 304L 309 310 316 316L 321 347
	QQ-S-766	304 304L 309 310 316 316L 321 347 348
	MIL-S-867	Class I (castings) Class II Class III
	MIL-P-24691/3	304 (pipe) 304L 316 316L 321 347
	MIL-T-8504	304 (tubing)
	MIL-T-16286	Class c (tube seamless)
	MIL-S-17509	Class I, II, III
	MIL-S-23193	Composition A (304) Composition B (348) Composition C (316)
	MIL-S-23195	304 (bar and forgings) 304L 347 348
	MIL-S-23196	304 (plate, sheet, strip) 304L 347 348

See footnotes at end of table.



TABLE I. Grouping of base materials (welding). L1J - Continued

Letter number	Applicable document	Class or type
S-8 (Cont'd)	MIL-T-23226  MIL-F-23467  ASTM A 743 ASTM A 744 ASTM A 744	304 (tube and pipe) 304L 347 348 304 (fittings/flanges) 304L 347 348 CN-7M (castings) CN-7MS CN-7M (castings) CN-7MS
S-11A	Quenched and tempered alloy steels	
	MIL-S-16216  MIL-S-23008  MIL-S-21952  MIL-S-23009 MIL-S-23284  MIL-L-24451	HY-80 (plate) HY-100 HY-80 (castings) HY-100 HY-80 (bars) HY-100 HY-80 (forgings) Class 1 Class 2 HY-80 (heads) HY-100
S-11B	Quenched and tempered alloy steels	
	MIL-S-24371	HY-130 (plate, castings, bars, forgings, extrusions and shapes)
S-11C	Age hardening alloy steel	
	MIL-S-24645	HSLA-80 (plate, sheet or coil)
S-11D	Age hardening alloy steel	
	MIL-S-24645	HSLA-100 (plate, sheet or coil)
S-21	Aluminum and aluminum base alloys	
	QQ-A-200/1 QQ-A-225/1 QQ-A-225/2 QQ-A-250/1 QQ-A-250/2 WW-T-700/1 WW-T-700/2	3003 (extruded bars, rods) 1100 (bars, rods) 3003 (bars, rods) 1100 (plate) 3003 (plate and sheet) 1100 3003

See footnotes at end of table.

TABLE I. Grouping of base materials (welding). L1J - Continued

Letter number	Applicable document	Class or type
S-22	Aluminum and aluminum base alloys	
	QQ-A-200/6	5454 (extruded bar, rods)
	QQ-A-225/7	5052 (bar, rod)
	QQ-A-250/8	5052 (plate)
	QQ-A-250/10	5454
S-25	Aluminum and aluminum base alloys	
	QQ-A-200/5	5086 (extruded bar, rod)
	QQ-A-200/4	5083
	QQ-A-200/7	5456
	QQ-A-250/6	5083
	ASTM B 209	5086
	ASTM B 209	5456
	WW-T-700/5	5086 (seamless tube)
S-26	Aluminum and aluminum base alloys	
	QQ-A-601	43 (castings) 214 355 356
	MIL-A-21180	A356 (castings)
S-31	Copper and copper base alloys	
	QQ-C-576	99.9 Cu (plate, bar)
S-32	Brass	
	QQ-C-390	Alloy C85700 (castings)
	QQ-B-637	Naval brass (alloy 464) (rod/bar/forgings)
	QQ-B-639	Naval brass alloy (rod, bar and forgings)
		Alloy 462
		Alloy 464
S-33	Silicon bronze	
	QQ-C-390	Alloy C87200 (castings)
	QQ-C-591	Alloy 655 (rod, shapes, flats)
S-34	Copper nickel	
	MIL-T-15005	70/30 (tube) 90/10
	MIL-C-15726	70/30 (plate, bar, rod) 90/10
	MIL-T-16420	70/30 (tube) 90/10
	MIL-C-20159	UNS No. C96200 (castings) C96400

See footnotes fit end of table.

TABLE I. Grouping of base materials (welding). L1J - Continued

Letter number	Applicable document	Class or type
S-35	Aluminum bronze	
	QQ-C-390	Alloy C95200 (castings)
	QQ-C-450	Alloy 606 (plate, bar)
	QQ-C-465	Alloy 613, 614 (rod, bar, plate, strip, flats and forgings)
		Alloy 606
		Alloy 614
		Alloy 642
	QQ-C-390	Alloy C95400 (castings)
		Alloy 15
S-36A	Nickel-aluminum bronze	
	QQ-C-390	Alloy C95500 (castings)
	QQ-C-465	Alloy 630 (bar/rod/plate/strip/forging)
	QQ-C-390	Alloy C95500 (castings)
	MIL-B-24480	Alloy C95400 or C95500
		Alloy 1 (castings)
	QQ-C-465	Flat products/shapes/forgings
	MIL-B-24480	Castings
S-36B	Manganese-nickel-aluminum bronze	
	MIL-B-24480	Alloy 2 (castings)
S-37A	Manganese bronze	
	QQ-B-728	Class A
		Class B
	QQ-C-390	Alloy C86100
		Alloy C86200
		Alloy C86300
		Alloy C86400
		Alloy C86500
S-37B	Nickel-manganese bronze	
	QQ-C-390	Alloy C86800
S-38	Tin bronze	
	MIL-B-16541	Castings
	QQ-C-390	Alloy C94700
S-39	Phosphor bronze	
	QQ-B-750	Composition A
		Composition D
	MIL-T-3595	Composition D (tubing)

See footnotes at end of table.

TABLE I. Grouping of base materials (welding). L1J - Continued

Letter number	Applicable document	Class or type
S-42	Nickel and nickel base alloys	
	QQ-N-281	NiCu, class A (bar, plate, rod, forging,) Class B
	MIL-N-24106	NiCu, class A (bar, rods, forgings)
	QQ-N-288	NiCuSiCb, composition E (casting)
	MIL-T-1368	NiCu (tubing)
	MIL-T-23520	NiCu (tube and pipe)
	QQ-N-288	Composition E
	MIL-N-17163	NiCu (bar, rod, plate, forging, and so forth)
	MIL-F-23509	Fittings and flanges
S-43	Nickel-chromium iron	
	MIL-F-23508	Fittings and flanges
	ASTM B 166	Bar, rod, forging
	ASTM B 564	
	MIL-B-15382	Bar and rod
	MIL-T-23227	Tube and pipe
	MIL-N-23228	Condition A (plate)
	MIL-N-23229	Condition A (bar, rod, forging)
	MIL-N-24271	Castings
	ASTM A 494	GR CW-6MC
	ASTM A 494	GR CW-6MC MOD L2J
	ASTM B 443	UNS N06625 (plate)
	ASTM B 444	UNS N06625 (pipe and tube)
	ASTM B 446	UNS N06625 (bar and rod)
S-51 L3J	Titanium and titanium alloy	
	ASTM B 337	GR 1, 2 and 7 (seamless and welded pipe)
	ASTM B 338	GR 1, 2 and 7 (seamless and welded tubing)
S-53 L3J	Titanium alloys	
	MIL-T-9046	Comp. AB-1 (sheet plate)
	MIL-T-9047	Comp. 6 (bars, forgings)
	ASTM B 265	Grade 5 (sheet, strip, plate)
	ASTM B 367	Grade C5 (castings)

L1J If material of similar chemistry and mechanical properties is not listed under an "S" group, it may be considered as a part of a group upon approval.

L2J Si = 0.40 maximum, Al = 0.15 maximum, and Cb + Ta = 3.15 - 4.50.

L3J Welding procedures utilizing this material require special approval from NAVSEA.

TABLE II. Grouping of filler materials (welding).<sup>L1J</sup>

Group	Applicable document	Filler material type
A-1A	Low and medium carbon steel (covered electrodes)	
	AWS A5.1	6010 6011 6012 <sup>L2J</sup> 6013 <sup>L2J</sup> 6020 6027 7024 <sup>L2J</sup>
A-1B	Low and medium carbon steel (bare rod)	
	AWS A5.2	Class RC-40 Class RC-45
A-2A	Carbon and low alloy steel (covered electrode)	
	MIL-E-22200/1	MIL-7018
	MIL-E-22200/6	MIL-7013 MIL-7016
	MIL-E-22200/7	MIL-7010-A1 MIL-7011-A1 MIL-7018-A1 MIL-7020-A1
	MIL-E-22200/10	MIL-7018M
A-2B	Carbon and low alloy steel (bare electrode, rod and inserts)	
	MIL-E-23765/1	MIL-70S-1 MIL-70S-2 MIL-70S-3 MIL-70S-4 MIL-70S-5 MIL-70S-6
	MIL-1-23413 (inserts)	MIL-MS-1 MIL-MS-2
A-2C	Carbon and low alloy steel (bare electrode and flux)	
	MIL-E-18193 MIL-F-18251	MIL-A1 (wire) <sup>L3J</sup> MIL-F1 (flux) <sup>L3J</sup> MIL-F3 (flux) <sup>L3J</sup>
	MIL-E-23765/1	MIL-70S-1 (wire) <sup>L3J</sup> MIL-70S-2 (wire) <sup>L3J</sup> MIL-70S-3 (wire) <sup>L3J</sup> MIL-70S-4 (wire) <sup>L3J</sup> MIL-70S-5 (wire) <sup>L3J</sup> MIL-70S-6 (wire) <sup>L3J</sup>

MIL-70S-7 (wire) L <sub>3</sub> J
MIL-70S-8 (wire) L <sub>3</sub> J
MIL-70S-9 (wire) L <sub>3</sub> J
MIL-70S-F (flux) L <sub>3</sub> J

See footnotes at end of table.

TABLE II. Grouping of filler materials (welding). L1J - Continued

Group	Applicable document	Filler material type
A-2C (Cont'd)	MIL-E-18193 MIL-F-19922 MIL-F-18251	MIL-B1 (wire) L3J MIL-B20 (flux) L3J MIL-B80 (flux) L3J MIL-F2 (flux) L3J MIL-F4 (flux) L3J
	MIL-E-18193 MIL-F-19922	MIL-B2 (wire) L3J MIL-B3 (wire) L3J MIL-B5 (wire) L3J MIL-B80 (flux) L3J
A-2D	Low alloy steel (flux cored electrodes)	
	MIL-E-24403/1	MIL-70T-1 MIL-71T-1 MIL-70T-5 MIL-71T-5 MIL-70T-6 MIL-70T-8 MIL-71T-8 MIL-71T8-Ni1
A-3A	Carbon and low alloy steel (low hydrogen covered electrodes)	
	MIL-E-22200/6	MIL-8015-C3 MIL-8016-C3 MIL-10015 MIL-10016
	MIL-E-22200/1	MIL-8018-C3
A-3B	Carbon and low alloy steel (bare electrode)	
	MIL-E-23765/2	MIL-80S-3
A-3C	Carbon and low alloy steel (bare electrode and flux)	
	MIL-E-23765/2	MIL-80S-1 (wire) MIL-80S-2 (wire) MIL-80S-1F (flux) MIL-80S-2F (flux)
A-3D	Carbon and low alloy steel (flux cored electrode)	
	MIL-E-24403/1	MIL-80T1-Ni1 MIL-80T1-Ni2 MIL-81T1-Ni1 MIL-81T1-Ni2
A-4A	Low alloy, high yield steel (covered electrode)	
	MIL-E-22200/5	MIL-10018-N1 L4J

See footnotes at end of table.

TABLE II. Grouping of filler materials (welding). L1J - Continued

Group	Applicable document	Filler material type
A-5A	Low alloy, high yield steel (covered electrode)	
	MIL-E-22200/1	MIL-9018-M MIL-10018-M MIL-11018-M
	MIL-E-22200/10	MIL-10018-M1 MIL-12018-M2
	MIL-E-22200/9	MIL-14018-M1
A-5B	Low alloy, high yield steel (bare electrode)	
	MIL-E-23765/2	MIL-100S-1 MIL-100S-2 MIL-120S-1
	MIL-E-24355	MIL-140S-1
A-5C	Low alloy, high yield steel (bare electrode and flux)	
	MIL-E-23765/2	MIL-100S-1 (wire) MIL-100S-1F (flux) MIL-100S-2 (wire) MIL-100S-2F (flux) MIL-120S-1 (wire) MIL-120S-1F (flux)
A-5D	Low alloy, high yield steel (flux cored electrode)	
	MIL-E-24403/2	MIL-100TC L7J , L8J , L2J MIL-100TM L7J , L8J , L2J MIL-100TS L7J , L2J MIL-101TC L8J , L2J MIL-101TM L8J , L2J MIL-101TS L2J MIL-110TC L7J , L8J
A-6A	CrMo steel (1.0 to 2.5 percent Cr, 0.4 to 1.2 percent Mo) (covered electrode)	
	MIL-E-22200/8	MIL-80XX-B2L or B2 MIL-90XX-B3L or B3
	AWS A5.5	E80XX-B2L or B2 E90XX-B3L or B3
	MIL-E-8697	HT-4130

See footnotes at end of table.

TABLE II. Grouping of filler materials (welding). L1J - Continued

Group	Applicable document	Filler material type
A-6B	CrMo steel (1.0 to 3.0 percent Cr, 0.4 to 1.2 percent Mo) (bare electrode, rod and insert)	
	MIL-1-23413	MIL-515 MIL-521
	AWS A5.23	EB2 EB3
	AWS A5.28	ER80S-B2L ER80S-B2 ER90S-B3L ER90S-B3
A-7A	CrMo steel (4.0-13.5 percent Cr, 0.4-1.4 percent Mo) (covered electrode)	
A-7A-1	MIL-E-22200/8	MIL-502-XX MIL-502-XX-L MIL-505-XX
A-7A-2	MIL-E-22200/8	MIL-410-XX MIL-410-NiMoXX
A-7B	CrMo steel (4.0-13.5 percent Cr, 0.4-1.4 percent Mo) (bare electrode, rod and insert)	
A-7B-1	MIL-1-23413	MIL-505
A-7B-2	MIL-E-19933	MIL-410 MIL-410 NiMo L5J
A-7C	High alloy steel (ferritic) (chromium 15-18 percent) (covered electrode)	
	AWS A5.4	E430
A-7D	High alloy steel (ferritic) (chromium 15-18 percent) (bare electrode and rod)	
	AWS A5.9	ER430

See footnotes at end of table.

TABLE II. Grouping of filler materials (welding). L1J - Continued

Group	Applicable document	Filler material type
A-8A	High alloy steel (austenitic) (covered electrode)	
	MIL-E-22200/2	MIL-16.8.2-XX MIL-308-XX MIL-308L-XX MIL-308HC-X MIL-309-XX MIL-309CB-XX MIL-310-XX MIL-312-XX MIL-316-XX MIL-316L-XX MIL-317-XX MIL-318-XX MIL-330-XX MIL-347-XX MIL-347HC-XX MIL-349-XX
	AWS A5.4	E320
A-8B	High alloy steel(austenitic) (bare electrode, rod and insert)	
	MIL-E-19933	MIL-308 L5J MIL-308L L5J MIL-308HC L5J MIL-309 L5J MIL-310 L5J MIL-312 L5J MIL-316 L5J MIL-316L L5J MIL-317 L5J MIL-318 L5J MIL-321 L5J MIL-347 L5J
AWS A5.9 MIL-I-23413 (inserts)		ER320 MIL-308 MIL-308L MIL-310 MIL-312 MIL-316 MIL-316L MIL-348

See footnotes at end of table.

TABLE II. Grouping of filler materials (welding). L1 - Continued

Group	Applicable document	Filler material type
A-21B	Aluminum alloy (bare electrode, rod and insert)	
	AWS A5.10 MIL-I-23413 (insert)	ER-1100 MIL-1100
A-22B	Aluminum alloy (bare electrode, rod and insert)	
	AWS A5.10 MIL-1-23413 (inserts)	ER-8193 ER-5356 ER-5554 ER-5556 ER-5654 MIL-5356
A-238	Aluminum alloy (bare electrode, rod and insert)	
	ANSI A5.10 AWS A5.10 MIL-I-23413 (inserts)	4043 ER-4043 MIL-4043
A-24B	Aluminum alloy (bare electrode and rod)	
	AWS A5.10	ER-2319
A-31B	Copper alloy (bare electrode and rod)	
	AWS A5.7	ER Cu
A-32A	Copper alloy (silicon bronze covered electrode)	
	AWS A5.6	E CuSi
A-32B	Copper alloy (silicon bronze bare electrode and rod)	
	MIL-E-23765/3-1	MIL-CuSi
A-33A	Copper-tin alloy (covered electrode)	
	AWS A5.6E	CuSn-A E CuSn-C
A-33B	Copper-tin alloy (phosphor bronze) (bare electrode and rod)	
	MIL-E-23765/3	MIL-CuSn-C
A-34A	Copper nickel (covered electrode)	
	MIL-E-22200/4	MIL-CuNi (70/30)
A-34B	Copper nickel (bare electrode, rod and insert)	
	MIL-E-21562	MIL-EN67 L5 MIL-RN67

See footnotes at end of table.

TABLE II. Grouping of filler materials (welding). L1J - Continued

Group	Applicable document	Filler material type
A-35B	Copper-zinc alloy (bare rod)	
	AWS A5.27	RB CuZn-A RB CuZn-B RB CuZn-C RB CuZn-D
A-36.6	Copper-aluminum alloy (aluminum bronze) (bare electrode and rod)	
	MIL-E-23765/3	Type CuAl-A2
A-37A	Copper-aluminum alloy (aluminum bronze) (covered electrode)	
	MIL-E-278	MIL-ECuAl-A MIL-ECuAl-B MIL-ECuAl-C MIL-ECuAl-D MIL-ECuAl-E
A-37B	Copper-aluminum-nickel alloys (NiAl and MnNiAl bronze) (bare electrode and rod)	
	MIL-E-23765/3	MIL-CuNiAl MIL-CuMnNiAl
A-38B	Surfacing alloys (bare rod) (metal powder)	
	MIL-R-17131	MIL-RNiCr-B MIL-RNiCr-C MIL-PNiCr-B-2 (powder) MIL-PNiCr-C-2 (powder)
A-39A	Surfacing alloys (covered electrode)	
	AWS A5.13	ECoCr-A ECoCr-C
A-39B	Surfacing alloys (bare rod) (metal powder)	
	MIL-R-17131	MIL-RCoCr-A MIL-RCoCr-C MIL-PCoCr-E-1 (powder) MIL-PCoCr-E-2 (powder)
A-41A	Nickel (covered electrode)	
	MIL-E-22200/3	MIL-4N11
A-41B	Nickel (bare electrode, rod and insert)	
	MIL-E-21562	MIL-EN61 L5J MIL-RN61

See footnotes at end of table.

TABLE II. Grouping of filler materials (welding). L1J - Continued

Group	Applicable document	Filler material type
A-42A	Nickel base alloys (covered electrodes)	
	MIL-E-22200/3	MIL-9N10
A-42B	Nickel base alloys (bare electrode, rod and insert)	
	MIL-E-21562	MIL-EN60 L5J MIL-RN60
A-43A	MIL-1-23413 (insert)	MIL-60
	Nickel base alloys (covered electrode)	
A-43B	MIL-E-22200/3	MIL-1N12 MIL-3N12 MIL-4N12 MIL-4N1A MIL-8N12 MIL-8N12H
	Nickel base alloys (bare electrode, rod and inserts)	
A-44A	MIL-E-21562	MIL-EN62 L5J MIL-RN62 MIL-EN82 L5J MIL-EN82H MIL-RN82 MIL-RN82H MIL-EN6A MIL-RN6A MIL-EN625 L5J MIL-RN625
	MIL-1-23413 (inserts)	MIL-62 MIL-82 MIL-82H
A-51B	Nickel-cobalt alloys (covered electrodes)	
	MIL-E-22200/3	MIL-3N1B MIL-3N1C MIL-4N1W MIL-3N1N MIL-3N1L
A-53B	Titanium-unalloyed (bare electrode)	
	AWS 5.16	ER-Ti-1 ER-Ti-2 ER-Ti-3
A-53B	Titanium base alloys (bare electrode)	
	AWS 5.16	ER Ti-6Al-4V ER Ti-6Al-4V-1

- L1J If filler material of similar chemistry and mechanical properties not listed under an A-group is to be used, it may be considered as a part of a group upon approval.
- L2J Separate procedure qualification required, see 4.2.5 and 4.7.2.
- L3J Flux-wire combination shall be used as indicated (that is, MIL A-1 wire qualified with MIL-FL flux is also qualified for MIL-F3 flux). Other flux-wire combinations shall require separate procedure qualification tests.
- L4J Procedure qualification limited to 1T of test plate thickness for production groove welds. Overlay production use limited to 1/2T of qualification test plate (see 4.4.1.9).
- L5J To be used with neutral flux when used with the submerged arc process. A neutral flux is defined as being one that does not readily oxidize the alloying elements or add significant alloy to the weld.
- L6J Deposition technique using ECoCr-A must yield a surface hardness of Rc35 minimum.
- L7J Use in any position other than that specified for qualification testing in MIL-E-24403/2 for this electrode shall require separate qualification and NAVSEA approval.
- L8J Use of any shielding gas other than that specified for qualification testing in MIL-E-24403/2 for this electrode shall require separate qualification and NAVSEA approval.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L1J L2J L7J

Category	Base material L3J		Filler material L11J	Qualified for categories L4J
	A	B		
Ferritic materials/shielded metal arc process L5J L14J				
1	S-11B	S-11B	A-5A (MIL-14018 only)	1 through 6, 13, 17 through 19 and 24
2	S-11B	S-11A-2	A-5A (MIL-1401 or 12018)	2 through 6, 13, 17 through 19 and 24
3	S-11B	S-11D	A-5A (MIL-14018 or 12018)	3 through 6, 13, 17 through 19 and 24
4	S-11B	S-11A-1	A-5A (MIL-14018, 12018, or 10018)	4 through 6, 13, 17 through 19 and 24
5	S-11B	S-11C	A-5A (MIL-14018, 12018, or 10018)	5, 6, 13, 17 through 19 and 24

See footnotes at end of table.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L<sub>1</sub>L<sub>2</sub>L<sub>7</sub> - Continued

Category	Base material L <sub>3</sub>		Filler material L <sub>11</sub>	Qualified for categories L <sub>4</sub>
	A	B		
Ferritic materials/shielded metal arc process (continued)				
6	S-11B	S-2 S-1	A-5A or the A-3A or A-2A electrodes specifically permitted by MIL-STD-1681	6, 13, 17 through 19 and 24
7	S-11A-2	S-11A-2	A-5A (MIL-12018 only)	7 through 19 and 24
8	S-11A-2	S-11D	A-5A (MIL-12018 only)	8, 11 through 19 and 24
9	S-11A-2	S-11A-1	A-5A (MIL-12018 or 10018)	9 through 13, 15 through 19 and 24
10	S-11A-1	S-11A-1	A-5A (MIL-12018 only)	10, 11, 13, 16 through 19 and 24
11	S-11A-1	S-11D	A-5A (MIL-12018 or 10018)	11 through 13, 15 through 19 and 24
12	S-11A-2 S-11A-A	S-11C	A-5A (MIL-12018 or 10018)	12, 13, 16 through 19 and 24
13	S-11A-2 S-11A-1	S-2 S-1	L <sub>10</sub> -A-5A (MIL-12018) or 10018); or A-3A or A-2A electrodes specifically permitted by MIL-STD-1688 or MIL-STD-1689	13, 17 through 19 and 24
14	S-11D	S-11D	A-5A (MIL-12018 only)	14 through 19 and 24
15	S-11D	S-11C	A-5A (MIL-12018 or 10018)	15 through 19 and 24
16	S-11C	S-11C	A-5A (MIL-10018)	16 through 19 and 24

See footnotes at end of table.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L<sub>1</sub>L<sub>2</sub>L<sub>7</sub> - Continued

Category	Base material L <sub>3</sub>		Filler material L <sub>11</sub>	Qualified for categories L <sub>4</sub>
	A	B		
Ferritic materials/shielded metal arc process (continued)				
17	S-11D	S-2	L <sub>10</sub> A-5A (MIL-12018 or 10018); or A-3A or A-2A electrodes specifically permitted by MIL-STD-1689	17 through 19 and 24
	S-11C	S-1		
18	S-2	S-2	L <sub>10</sub> A-3A or A-2A (MIL-7018A1 or 7018 or 7016)	18, 19 and 24
19	S-2	S-1	L <sub>10</sub> A-3A or A-2A (MIL-7018A1 or 7018 or 7016)	19 and 24
20	S-3A	S-3A	L <sub>10</sub> A-3A or A-2A (MIL-7018A1)	20 through 24
21	S-3A	S-3 S-1	L <sub>10</sub> A-3A or A-2A (MIL-7018A1 or 7018 or 7016)	21 through 24
22	S-3	S-3	L <sub>10</sub> A-3A or A-2A (MIL-7018A1 or 7018 or 7016)	22 through 24
23	S-3	S-1	L <sub>10</sub> A-3A or A-2A (MIL-7018A1 or 7018 or 7016)	23 and 24
24	S-1	S-1	A-2A	24
25	S-5	S-5	L <sub>10</sub> A-7A-1 or A-6A	25 through 29
26	S-5	S-4	L <sub>10</sub> A-7A-1 or A-6A	26 through 29
27	S-5	S-3	L <sub>10</sub> A-6A or A-3A or A-2A (MIL-7018A1 or 7018 or 7016)	27 and 29
28	S-4	S-4	A-6A	28 and 29

See footnotes at end of table.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L<sub>1</sub>L<sub>2</sub>L<sub>7</sub> - Continued

Category	Base material L <sub>3</sub>		Filler material L <sub>11</sub>	Qualified for categories L <sub>4</sub>
	A	B		
Ferritic materials/shielded metal arc process (continued)				
29	S-4	S-3	L <sub>10</sub> A-6A or A-3A or A-2A (MIL-7018A1 or 7018 or 7016)	29
		S-1		
30	S-6	S-6	A-7A-2 (MIL-410XX only)	30
31	S-6	S-6	A-7A-2 (MIL-410 NiMo XX only)	31 through 33
32	S-6	S-6A	A-7A-2 (MIL-410 NiMo XX only)	32 and 33
33	S-6A	S-6A	A-7A-2 (MIL-410 NiMo XX only)	33
Ferritic materials/gas tungsten-arc, gas metal arc and plasma-arc processes				
1	S-11B	S-11B	A-5B (MIL-140S-1 only)	1 through 6, 13, 17 through 19 and 24
2	S-11B	S-11A-2	A-5B (MIL-140S-1 or 120S-1)	2 through 6, 13, 17 through 19 and 24
3	S-11B	S-11D	A-5B (MIL-140S-1 or 120S-1)	3 through 6, 13, 17 through 19 and 24
4	S-11B	S-11A-1	A-5B (MIL-140S-1 or 120S-1 or 100S-1)	4 through 6, 13, 17 through 19 and 24
5	S-11B	S-11C	A-5B	5, 6, 13, 17 through 19 and 24
6	S-11B	S-2 S-1	L <sub>10</sub> A-5B; or A-3B or A-2B types specifically permitted by MIL-STD-1681	6, 13, 17 through 19 and 24
7	S-11A-2	S-11-A-2	A-5B (MIL-I-120S-1 only)	7 through 19 and 24

See footnotes at end of table.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L<sub>1</sub>L<sub>2</sub>L<sub>7</sub> - Continued

Category	Base material L <sub>3</sub>		Filler material L <sub>11</sub>	Qualified for categories L <sub>4</sub>
	A	B		
Ferritic materials/gas tungsten-arc, gas metal arc and plasma-arc processes (continued)				
8	S-11A-2	S-11D	A-5B (MIL-120S-1 only)	8, 11 through 19 and 24
9	S-11A-2	S-11A-1	A-5B (MIL-120S-1 or 100S-1)	9 through 13, 15 through 19 and 24
10	S-11A-1	S-11A-1	A-5B (MIL-100S-1 only)	10, 11, 13, 16 through 19 and 24
11	S-11A-1	S-11D	A-5B (MIL-120S-1 or 100S-1)	11 through 13, 15 through 19 and 24
12	S-11A-2	S-11C	A-5B (MIL-120S-1 or 100S-1)	12, 13, 16 through 19 and 24
	S-11A-1			
13	S-11A-2	S-2	L <sub>10</sub> -A-5B (other than MIL-140S types); or A-2B types specifically permitted by MIL-STD-1688 or MIL-STD-1689	13, 17 through 19 and 24
	S-11A-1	S-1		
14	S-11D	S-11D	A-5B (MIL-120S-1 only)	14 through 19 and 24
15	S-11D	S-11C	A-5B (MIL-120S-1 or 100S-1)	15 through 19 and 24
16	S-11C	S-11C	A-5B (MIL-100S-1 only)	16 through 19 and 24
17	S-11D	S-2	L <sub>10</sub> -A-5B (other than MIL-140S types); or A-3B or A-2B types specifically permitted by MIL-STD-1689	17 through 19 and 24
	S-11C	S-1		

See footnotes at end of table.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L<sub>1</sub>L<sub>2</sub>L<sub>7</sub> - Continued

Category	Base material L <sub>3</sub>		Filler material L <sub>11</sub>	Qualified for categories L <sub>4</sub>
	A	B		
Ferritic materials/gas tungsten-arc, gas metal arc and plasma-arc processes (continued)				
18	S-2	S-2	L <sub>10</sub> A-3B or A-2B	18, 19 and 24
19	S-2	S-1	L <sub>10</sub> A-3B or A-2B	19 and 24
20	S-3A	S-3A	L <sub>10</sub> A-3B or A-2B	20 through 24
21	S-3A	S-3 S-1	L <sub>10</sub> A-3B or A-2B	21 through 24
22	S-3	S-3	L <sub>10</sub> A-3B or A-2B	22 through 24
23	S-3	S-1	L <sub>10</sub> A-3B or A-2B	23 and 24
24	S-1	S-1	A-2B	24
25	S-5	S-5	L <sub>10</sub> A-7B-1 or A-6B	25 through 29
26	S-5	S-4	L <sub>10</sub> A-7B-1 or A-6B	26 through 29
27	S-5	S-3 S-1	L <sub>10</sub> A-7B-1 or A-6B or A-3B or A-2B	27 and 29
28	S-4	S-4	A-6B	28 and 29
29	S-4	S-3	L <sub>10</sub> A-6B or A-3B or A-B	29
30	S-6	S-6	A-7B-2 (MIL-410 only)	30
31	S-6	S-6	A-7B-2 (MIL-410 NiMo only)	31 through 33
32	S-6	S-6A	A-7-2 (MIL-410 NiMo only)	32 and 33
33	S-6A	S-6A	A-7B-2 (MIL-410 NiMo only)	33

See footnotes at end of table.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L<sub>1</sub>L<sub>2</sub>L<sub>7</sub> - Continued

Category	Base material L <sub>3</sub>		Filler material L <sub>11</sub>	Qualified for categories L <sub>4</sub>
	A	B		
Ferritic materials/Submerged-arc process				
1	S-11A-2	S-11A-2	A-5C (MIL-120S-1 wire and 1F flux)	1 through 13 and 18
2	S-11A-2	S-11D	A-5C (MIL-120S-1 wire and 1F flux)	2, 5 through 13 and 18
3	S-11A-2	S-11A-1	A-5C (MIL-120S-1 wire and 1F flux or 100S-1 wire and 1F flux)	3 through 7, 9 through 13 and 18
4	S-11A-1	S-11A-1	A-5C (MIL-100S-1 wire and 1F flux)	4, 5, 7, 10 through 13 and 18
5	S-11A-1	S-11D	A-5C (MIL-120S-1 wire and 1F flux or 100S-1 wire and 1F flux)	5 through 7, 10 through 13 and 18
6	S-11A-2	S-11C	A-5C (MIL-120S-1 wire and 1F flux or 100S-1 wire and 1F flux)	6, 7, 10 through 13
	S-11A-1			and 18
7	S-11A-2 S-11A-1	S-2 S-1	L <sub>10</sub> -A-5C (MIL-120S-1 wire and 1F flux or 100S-1 wire and 1F flux) or A-3C or A-2C wire and flux specifically permitted by MIL-STD-1688 or MIL-STD-1689	7, 11 through 13 and 18
8	S-11D	S-11D	A-5C (MIL-120S-1 wire and 1F flux)	8 through 11 and 18
9	S-11D	S-11C	A-5C (MIL-120S-1 wire and 1F flux or 100S-1 wire and 1F flux)	9 through 13 and 18

See footnotes at end of table.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L<sub>1</sub>L<sub>2</sub>L<sub>7</sub> - Continued

Category	Base material L <sub>3</sub>		Filler material L <sub>11</sub>	Qualified for categories L <sub>4</sub>
	A	B		
Ferritic materials/Submerged-arc process - Continued				
10	S-11C	S-11C	A-5C (MIL-100S-1 wire and 1F flux)	10 through 13 and 18
11	S-11D S-11C	S-2 S-1	L <sub>10</sub> -A-5C (MIL-120S-1 wire and 1F flux or 100S-1 wire and 1F flux) or A-3C or A-2C wire and flux specifically permitted by MIL-STD-1689	11 through 13 and 18
12	S-2	S-21	L <sub>12</sub> -A-2C	12, 13 and 18
13	S-2	S-1	A-2C Unless qualified by category 12, see note L <sub>12</sub>	13 and 18
14	S-3A	S-3A	A-3C	14 through 17
15	S-3A	S-3 S-1	A-3C	15 through 17 (qualification with A-2C qualifies categories 15 through 18 with A-2C)
16	S-3	S-3	A-3C	16 through 17 (qualification with A-2C qualifies categories 16 through 18 with A-2C)
17	S-3	S-1	A-3C	17 (qualification with A-2C qualifies categories 17 and 18 with A-2C)

See footnotes at end of table.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L<sub>1</sub>L<sub>2</sub>L<sub>7</sub> - Continued

Category	Base material L <sub>3</sub>		Filler material L <sub>11</sub>	Qualified for categories L <sub>4</sub>
	A	B		
<b>Ferritic materials/Submerged-arc process - Continued</b>				
L <sub>13</sub> L <sub>18</sub>	S-1	S-1	A-2C	18
19	S-6	S-6	A-7B-2 (MIL-410 NiMo only) L <sub>9</sub>	19 through 21
20	S-6	S-6A	A-7B-2 (MIL-410 NiMo only) L <sub>9</sub>	20 and 21
21	S-6A	S-6A	A-7B-2 (MIL-410 NiMo only) L <sub>9</sub>	21
<b>Ferritic materials/flux cored-arc process</b>				
1	S-11A-1	S-11A-1	A-5D	1 through 7 and 12
2	S-11A-1	S-11C	A-5D	2 through 7 and 12
3	S-11A-1	S-2 S-1	L <sub>10</sub> -A-5D; or A-2D or 3D electrodes specifically permitted by MIL-STD-1688 or MIL-STD-1689	3, 5 through 7 and 12
4	S-11C	S-11C	A-5D	4 through 7 and 12
5	S-11C S-1	S-2	L <sub>10</sub> -A-5D; or A-2D or A3D electrodes specifically permitted by MIL-STD-1689	5 through 7 and 12
6	S-2	S-2	L <sub>10</sub> -A-2D or 3D	6, 7, and 12
7	S-2	S-1	L <sub>10</sub> -A-2D or 3D	7 and 12
8	S-3A	S-3A	A-3D	8 through 12
9	S-3A	S-3 S-1	L <sub>10</sub> -A-2D or 3D	9 through 12
10	S-3	S-3	L <sub>10</sub> -A-2D or A-3D	10 through 12
11	S-3	S-1	L <sub>10</sub> -A-2D or A-3D	11 and 12

See footnotes at end of table.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L<sub>1</sub>L<sub>2</sub>L<sub>7</sub> - Continued

Category	Base material L <sub>3</sub>		Filler material L <sub>11</sub>	Qualified for categories L <sub>4</sub>
	A	B		
Ferritic materials/flux cored-arc process - Continued				
12	S-1	S-1	A-2D	12
Austenitic stainless steel to ferritic materials/shielded metal-arc				
1	S-8	S-11B S-11A S-11D S-11C	A-8A (MIL-309 or MIL-310 types only)	1 and 4
2	S-8	S-5 L <sub>13</sub> S-4	A-8A (MIL-309 or MIL-310 types only)	2 and 4
3	S-8	S-3/3A L <sub>13</sub>	A-8A (MIL-309 or MIL-310 types only)	3 and 4
4	S-8	S-2 S-1	A-8A (MIL-309 or MIL-310 types only)	4 and 1
Austenitic stainless steel to ferritic materials/gas tungsten-arc, gas metal-arc and plasma-arc				
1	S-8	S-11B S-11A S-11D S-11C	A-8B (MIL-309 or MIL-310 types only)	1 and 4
2	S-8	S-5 L <sub>13</sub> S-4	A-8B (MIL-309 or MIL-310 types only)	2 and 4
3	S-8	S-3/3A L <sub>13</sub>	A-8B (MIL-309 or MIL-310 types only)	3 and 4
4	S-8	S-2 S-1	A-8B (MIL-309 or MIL-310 types only)	4 and 1

See footnotes at end of table.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L<sub>1</sub>L<sub>2</sub>L<sub>7</sub> - Continued

Category	Base material L <sub>3</sub>		Filler material L <sub>11</sub>	Qualified for categories L <sub>4</sub>
	A	B		
Austenitic stainless steel to ferritic materials/submerged arc				
1	S-8	S-11B S-11A S-11D S-11C	A-8B (MIL-309 or MIL-310 types with neutral flux only)	1 and 4
2	S-8	S-5 L <sub>13</sub> S-4	A-8B (MIL-309 or MIL-310 types only)	2 and 4
3	S-8	S-3/3A L <sub>13</sub>	A-8B (MIL-309 or 310 types only) with neutral flux	3 and 4
4	S-8	S-2 S-1	A-8B (MIL-309 or MIL-310 only) with neutral flux	4 and 1
Copper-nickel and nickel base alloys/shielded metal-arc L <sub>15</sub>				
1	S-34	S-34	A-34A	1 through 6
2	S-34	S-43	A-43A or A-42A	2 through 6
3	S-34	S-42	A-42A or A-34A	2 through 6
4	S-42	S-42	A-42A	3 through 6
5	S-42	S-43	A-43A or A-42A	5 and 6
6 L <sub>15</sub>	S-43	S-43	A-43A	6
Copper-nickel and nickel base alloys/gas metal arc, gas tungsten and plasma-arc L <sub>15</sub>				
1	S-34	S-34	A-34B	1 through 6
2	S-34	S-43	A-43B or A-42B	2 through 6
3	S-34	S-42	A-42B or A-34B	2 through 6
4	S-42	S-42	A-42B	3 through 6
5	S-42	S-43	A-43B or A-42B	5 and 6
6	S-43	S-43	A-43B	6

See footnotes at end of table.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L<sub>1</sub>L<sub>2</sub>L<sub>7</sub> - Continued

Category	Base material L <sub>3</sub>		Filler material L <sub>11</sub>	Qualified for categories L <sub>4</sub>
	A	B		
Copper nickel and nickel base alloys to ferritic material/shielded metal-arc				
1	S-34 S-42 S-43	S-11B S-11A S-11D S-11C	A-42A or A-43A L <sub>9</sub>	1 and 4
2	S-34 S-42 S-43	S-5 L <sub>13</sub> S-4	A-42A or A-43A	2 and 4
3	S-34 S-42 S-43	S-3 S-3A L <sub>13</sub>	A-42A or A-43A L <sub>9</sub>	3 and 4
4	S-34 S-42 S-43	S-2 S-1	A-42A or A-43A L <sub>9</sub>	4 and 1
Copper nickel and nickel base alloys to ferritic materials/gas tungsten-arc, gas metal-arc, plasma-arc.				
1	S-34 S-42 S-43	S-11B S-11A S-11D S-11C	A-42B or A-43B L <sub>9</sub>	1 and 4
2	S-34 S-42 S-43	S-5 L <sub>13</sub> S-4	A-42B or A-43B L <sub>9</sub>	2 and 4
3	S-34 S-42 S-43	S-3 S-3A L <sub>13</sub>	A-42B or A-43B L <sub>9</sub>	3 and 4
4	S-34 S-42 S-43	S-2 S-1	A-42B or A-43B L <sub>9</sub>	4 and 1
Copper-nickel and nickel base alloy to austenitic materials/ shielded metal-arc				
1	S-34	S-8	A-43A	1 through 3
2	S-42	S-8	A-43A	2 through 3
3	S-43	S-8	A-43A	3

See footnotes at end of table.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L<sub>1</sub>L<sub>2</sub>L<sub>7</sub> - Continued

Category	Base material L <sub>3</sub>		Filler material L <sub>11</sub>	Qualified for categories L <sub>4</sub>
	A	B		
Copper nickel and nickel base alloys to austenitic materials/gas metal-arc, gas tungsten-arc and plasma-arc				
1	S-34	S-8	A-43B	1 through 3
2	S-42	S-8	A-43B	2 through 3
3	S-43	S-8	A-43B	3
Brass and bronze alloys/shielded metal arc				
1	S-32 S-37A	S-32 S-37A	A-37A	1
Brass and bronze alloys/gas metal-arc, gas tungsten-arc and plasma-arc L <sub>8</sub>				
1	S-32 S-35 S-36A S-37A S-37B	S-32 S-35 S-36A S-37A S-37B	A-36B A-37B	1
2	S-36B	S-36B S-32 S-35 S-36A S-37A S-37B	A-37B	1 and 2
3	S-33	S-33 S-32 S-36A S-37A S-37B	A-32B	2
4	S-38	S-38 S-39 S-32 S-33 S-35 S-36A S-37A S-37B	A-32B A-33B	3

See footnotes at end of table.

TABLE III. Grouping of base/filler materials for welding procedure cross-qualification. L<sub>1</sub>L<sub>2</sub>L<sub>7</sub> - Continued

Category	Base material L <sub>3</sub>		Filler material L <sub>11</sub>	Qualified for categories L <sub>4</sub>
	A	B		
Brass and bronze alloys/oxy-acet.				
1	S-32 S-37A	S-32 S-37A	A-35B	1
Aluminum materials/gas metal-arc, gas tungsten-arc and plasma-arc				
2	S-22 S-25	S-22 S-25	A-22B or A-23B	1 through 3 L <sub>6</sub>
2	S-26	S-26 S-25 S-22 S-21	A-23	2 through 3 L <sub>6</sub>
3	S-21	S-21 S-22 S-25 S-26	A-21B	3 L <sub>6</sub>

L<sub>1</sub> See 4.7 for limitations on applications for qualification coverage.

L<sub>2</sub> Procedure qualification for any base material-filler material combination within a material group or within the limits specified in this table shall constitute approval for repairing, buildup, or overlay other than cladding for corrosion resistance.

L<sub>3</sub> Procedure qualification with any material listed in column A with any material listed in column B qualifies all the material combinations in that category. For example, under category 6 for ferritic material/shielded metal-arc, qualification of S-11B to S-1 or S-2, also qualifies S-11A2 or S-11A1 to S-1 or S-2 (category 13) and also categories 17, 18, 19 and 24.

L<sub>4</sub> Qualification on one material within an S-group qualifies for welding all materials in that S-group except as follows: For groups S-4 and S-5, qualification for all materials within these groups applies only when these materials are welded in the annealed or normalized and tempered conditions. When any one of these base materials are welded in a quenched and tempered condition, separate qualification is required. However, qualification using any one of these materials in the quenched and tempered condition shall also qualify for welding all of the materials in the S-group in the annealed or normalized and tempered condition.

L<sub>5</sub> The split of S-11A into S-11A-1 (HY-80) and S-11A-2 (HY-100) applies only to this table for purposes of weld procedure cross qualification.

L<sub>6</sub> For groups S-21, S-22, and S-25, qualification covers only the qualified temper and those of lower strength.

L<sub>7</sub> Base metal/filler metal combinations not listed in table III require separate procedure qualification.

L<sub>8</sub> If the S-36A material is to be post-weld temper-annealed, A37B filler materials shall be used.



- L9J Filler materials A-43A and A-43B apply only for S-43 base materials to materials in column B.
- L10J The higher number A-group material qualifies the lower number A groups material but not vice-versa.
- L11J In all instances where A-5A, B or C filler materials are listed, the higher strength materials are only qualified when the original qualification was performed using the same (or higher) strength filler material. For example, under shield metal-arc, category 4, use of MIL-12018 would qualify MIL-12018 and MIL-10018 in category 5 but not MIL-14018.
- L12J Separate qualification of this category is required when the base material and filler material both have toughness requirements and thickness exceeds 1/2-inch.
- L13J The higher number S-group material in column B of this category qualifies the lower number S-group but not vice-versa. For this purpose S-3A is higher than S-3.
- L14J MIL-11018 of MIL-E-22200/1 qualifies MIL-10018 and vice-versa.
- L15J S-43, UNS number N06625 type material requires separate qualification.

TABLE IV. Welding procedure qualification position limitation. L1J L4J L5J L6J

Forms of base material qualified	Positions to be qualified (grooves and fillets)	Positions used during qualification (see figure 1)	
		Using plate (weld-axis)	Using pipe
Plate, castings, and forgings,	All positions	Vertical	Horizontal-fixed pipe (5G) L2J L3J
	Flat and vertical	Vertical	Horizontal-fixed pipe
	Flat and horizontal	Horizontal	Vertical-fixed pipe (2G)
	Flat and overhead	Overhead	Horizontal-fixed pipe
	Flat	Flat	Horizontal-rolled pipe (1G)
	Horizontal fillets only		

See footnotes at end of table.

TABLE IV. Welding procedure qualification position limitation. L<sub>1</sub> L<sub>4</sub> L<sub>5</sub> L<sub>6</sub> - Continued

Forms of base material qualified	Positions to be qualified (grooves and fillets)	Positions used during qualification (see figure 1)	
		Using plate (weld-axis)	Using pipe
Pipe	All positions	Vertical L <sub>2</sub>	Horizontal-fixed pipe L <sub>3</sub>
	Horizontal-fixed pipe and horizontal-rolled pipe	Vertical	Horizontal-fixed pipe
	Vertical-fixed pipe and horizontal-rolled pipe	Horizontal	Vertical-fixed pipe
	Horizontal-rolled pipe	Flat	Horizontal-rolled pipe

- L<sub>1</sub>J Automatic pipe welding qualification shall be performed on pipe or other cylindrically shaped material forms listed in table IV.
- L<sub>2</sub>J For semi-automatic gas metal-arc welding using the pulsed spray-arc or short circuiting-arc process the horizontal position for plate and the vertical-fixed position for pipe must be run to qualify for all positions. However, only non-destructive testing as specified for level no. II qualification shall be required for the horizontal plate and the vertical-fixed position pipe.
- L<sub>3</sub>J The 45 degree inclined position (6G) may be substituted for horizontal fixed pipe position.
- L<sub>4</sub>J When welding in the vertical plane, in either plate or horizontal fixed pipe, welding shall be in the up direction, (except in automatic pipe welding where direction of rotation, required by the procedure, shall be qualified).
- L<sub>5</sub>J See table II note 7.
- L<sub>6</sub>J
  - (a) Except as specified below, the addition of other welding positions than already qualified for weld surfacing for corrosion resistant and hardsurface applications. Qualification in the horizontal, vertical, or overhead position shall qualify also for the flat position. Qualification in the horizontal fixed position, 5G, shall qualify for the flat, vertical, and overhead positions. Qualification in the horizontal, vertical, and overhead positions shall qualify for all positions. Qualification in the inclined fixed position, 6G, shall qualify for all positions.
  - (b) For tube-to-tubesheet welding, a change in the position, 6G, shall qualify for all positions.
  - (c) An activity who does production welding in a particular orientation may make the tests in this particular orientation. Such qualifications are valid only for the position actually tested, except that an angular deviation of plus or minus 15 degrees is permitted in the inclination of the weld axis and the rotation of the weld face.

	Arc-welding <sup>L1</sup>				Fuel gas welding
	Manual	Semi-automatic	Automatic <sup>L3</sup> and machine		
Base, material <sup>L5</sup> Specification and type or class or chemical analysis, thickness, and condition	X	X	X	X	
Filler material Specification, type or chemical analysis, diameter, wire or powder	X	X	X	X	
Flux Specification, size, type	-	X	X	X	
Base material cleaning	X	X	X	X	
Applicable joint designs (reference or sketches)	X	X	X	X	
Process	X	X	X	X	
Machine, model or type	-	X	X	-	
Electrical characteristics <sup>L6</sup> current, arc voltage range, polarity	X <sup>L2</sup>	X	X	-	
Travel speed	- <sup>L6</sup>	- <sup>L6</sup>	X	X	
Position (including progression vertical up or down)	X	X	X	X	
Torch type	X <sup>L4</sup>	X	X	Torch tip size only	
Torch shielding gases Type and flow rates	X <sup>L4</sup>	X	X	-	
Purge gases Type and flow rates	X	X	X	-	
Postheat treatments	X	X	X	X	
Preheat and interpass temperature limits	X	X	X	X	
Torch oscillation (amplitude, and frequency and dwell)	-	-	X	-	
Torch position (relative off-set form	-	-	X	-	

vertical center-line in horizontal-rolled position)				
Electrode lead or trail angle (wire feed angle)	-	-	X	-
Gas cup size	X (GTAW only)	X	X	-

See footnotes at top of next page.

L1J The following shall also be specified as essential elements:

- (a) Details of current slope, if used.
- (b) For the gas tungsten arc process, detailed description of pulsed welding current, if used, including all pulsed current and voltage parameters which can be varied by adjustment of pulsed power supply controls; manufacturer and model number of pulsed power supply.
- (c) For the gas metal arc process, a description of pulsed welding, if used, including current, average voltage, peak pulse voltage and pulse frequency.
- (d) For semi-automatic welding, filler metal feed rate, except when feed rate is controlled by amperage and amperage is set by the welder.
- (e) Trade name (that is, manufacturer and manufacturer's designation) and generic description of ceramic or non-metallic backing material, if used.
- (f) For hot wire feed, the hot wire amperage and voltage.
- (g) For automatic and machine welding; (1) filler material feed rate; (2) type of arc length or voltage control; (3) for gas metal-arc and flux cored-arc, the gas cup to work distance and contact tube to work distance; and (4) for submerged arc welding, the contact tube to work distance.
- (h) For S-51 and S-53 materials trailing shield description, composition and flow rates; also inspection and detailed acceptance criteria for color of each weld bead.

L2J Except for arc voltage.

L3J For all automatic welding, the machine settings which control voltage, current, timing, travel speed, filler material feed rate and where applicable torch oscillation (including dwell, frequency and amplitude) shall be recorded for each procedure to be used. For automatic pipe welding, the setting for each pipe size to be welded in production shall be required.

L4J For plasma-arc process and gas tungsten-arc process.

L5J See base material restriction in table VII, note 2. The welding procedure shall specify this restriction for each specific material affected.

L6J Heat input requirements shall be specified for base materials with toughness requirements. Combination limits of amperage, voltage and travel speed shall be specified for the ranges of each parameter. Equivalent means of limiting heat input (for example, nomographs or for shielded metal-arc, bead length methods) are permissible. Simple reference to a formula is unacceptable.

TABLE VI. Welding procedure qualification material thickness limits.  
 L<sub>1</sub>J, L<sub>2</sub>J, L<sub>4</sub>J, L<sub>7</sub>J, L<sub>8</sub>J, L<sub>9</sub>J

Pipe L <sub>3</sub> J	
Test material thickness (T)	Thickness (T) qualified
1/8 inch to and including 3/8 inch	0.058 inch to 2T L <sub>6</sub> J
Over 3/8 inch	1/8 inch to unlimited
Other L <sub>5</sub> J	
Less than 3/4 inch	T or 1/8 inch (whichever is less) to 2T
3/4 inch and greater but less than 3 inches	3/16 inch to 2T
3 inches or greater	3/16 inch to unlimited

- L<sub>1</sub>J When qualifying pipe using plate test assemblies, the test material thickness and qualified thickness limits specified for pipe shall govern. When qualifying plate using pipe test assemblies, the test material thickness and qualified thickness limits specified for plate shall govern.
- L<sub>2</sub>J T-nominal thickness. For clarification, the thickness limits (T) are as follows:
  - (a) Butt joint: T is the nominal thickness of the pipe or plate. For materials of different thicknesses, T is the nominal thickness of the thinner member.
  - (b) Fillet and socket joint: T is the thickness of the throat of the welded joint.
  - (c) Full penetration tee joint: T is the thickness of the web member.
  - (d) Pipe boss and partial penetration tee or butt joint: T is the depth of the groove. If the weld from the second side overlaps that of the first side, T is the thickness of the web member or the butt joint member.
  - (e) Hull penetration: T is the thickness of the hull plate.
  - (f) Weld deposited pads and repairs: T is the depth of weld deposit; however, there is no lower thickness limit.
- L<sub>3</sub>J Not applicable to root layer qualification (see 4.4.1.5) or to autogenous welds (see 4.4.7).
- L<sub>4</sub>J The maximum thickness qualified shall be 1.10 times the thickness of the test assembly for any of the following conditions:
  - (a) When the weldment requires quenching and tempering.
  - (b) When single pass welding is used.
  - (c) When weld pass thickness is greater than 1/2 inch.
  - (d) When welding pipe using an automatic process.
  - (e) When the short circuiting mode of gas metal-arc welding is used.
- L<sub>5</sub>J Other includes all material other than pipe (such as structural plate, shapes and castings).

- L6J Thickness qualified may be extended below 0.058 inch by welding a test assembly of the production thickness (less than 0.058 inch). For socket and fillet seal weld qualifications performed on pipe with wall thickness in the range of 0.058 to 3/16 inch the minimum wall thickness qualified shall be 10 percent below the pipe wall thickness welded.
- L7J If more than one process is used in a single joint, the processes shall be used in welding the qualification test assembly, unless the processes have been previously qualified and no changes specified in 4.7 have been made. For multiple processes the qualified thickness of each process shall not be additive in determining the maximum thickness of the production joint to be welded. One or more processes may be deleted from a production joint qualified by a combination of processes provided each remaining process has been qualified within the limits specified by 4.4 and 4.7 for each of the processes to be used in the production joint. Similarly, more than one process may be used in a single production joint provided each process has been qualified either separately or in combination with other processes. However, the root layers up to a thickness of 3/16 inch shall be deposited with the same process used in the qualification of the root layers. A change in sequence of the processes used does not require requalification.
- L8J When the production application is for thicknesses of 1/2 inch and greater and the material is one requiring impact testing (such as S-11 materials), the qualification test assembly shall be of sufficient thickness and size to permit preparation of impact test specimens (see (see table VII, note 2).
- L9J Where qualification is performed on a base material without toughness requirements and cross qualification is permitted for materials having toughness requirements, welding of the materials with toughness requirements shall be limited to material thicknesses less than 1/2 inch when greater thicknesses are otherwise qualified.

TABLE VII. Welding procedure qualification assembly test requirements.

Destructive testing L1J L2J L3J L4J L5J L14J L15J					Nondestructive testing L15J L16J L19J L21J			
Material types	S number group	Tensile L6J	Guided bends L7J	Macro-etch L8J L13J	Radio-graphic	Liquid penetrant	Magnetic particle	Ultra sonic L20J
Carbon-steel	S-1	2	3	-	X	-	X	X
Quenched and tempered carbon-steel	S-2 S-3/3A S-4	2 2 2	3 3 3	- - -	X X X	- - -	X X X	X X X
Alloy steel	S-5	2	3	-	X	-	X	X
High alloy steels	S-6 S-6A S-7 S-8	2 2 2 2	3 3 3 3	- - - -	X X X X	- - - X	X X X -	X X X X
Quenched and tempered alloy steel	S-11A S-11B	2 2	3 3 L9J	- -	X X	- -	X X	X X

Age harden-	S-11C	2	2	-	X	-	X	X
ing alloy steels								

See footnotes at end of table.

TABLE VII. Welding procedure qualification assembly test requirements. - Continued

Material types	S number group	Destructive testing <sup>L1</sup> <sup>L2 L3 L4 L5 L14 L15</sup>				Nondestructive testing <sup>L15 L16 L19 L21</sup>			
		Tensile <sup>L6</sup>	Guided bends <sup>L7</sup>	Macro-etch <sup>L8 L13</sup>	Radio-graphic	Liquid penetrant	Magnetic particle	Ultra sonic <sup>L20</sup>	
Aluminum and aluminum base alloys	S-21	2	3	-	X	X	-	-	
	S-22	2	3	-	X	X	-	-	
	S-25	2	3	-	X	X	-	-	
	S-26	2	-	2	X	X	-	-	
Copper and copper base alloys	S-31	2	3	-	X	X	-	-	
	S-32	2	-	2	X	X	-	-	
	S-33	2	-	2	X	X	-	-	
	S-34	2	3	-	X	X	-	-	
	S-35	2	-	2	X	X	-	-	
	S-36A	2	3	-	X	X	-	-	
	S-36B	2	-	2	X	X	-	-	
	S-37A	2	-	2	X	X	-	-	
	S-37B	2	-	2	X	X	-	-	
	S-38	2	-	2	X	X	-	-	
Nickel and nickel base alloys	S-39	2	3	-	X	X	-	-	
	S-42	2	3	-	X	X	-	-	
	S-43	2	3	-	X	X	-	-	
Titanium and titanium alloys	S-51	2	3 <sup>L17</sup>	2	X	X	-	-	
	S-53	2	3 <sup>L17</sup>	2	X	X	-	-	
Dissimilar metals	-	2	1 <sup>L10</sup>	2	X	X	-	-	
Weld/clad-ding, corrosion-resistant <sup>L11</sup>	-	-	2	2	-	X	-	-	
Hardfacing, wear resisting <sup>L12</sup>	-	-	-	3	-	X	-	-	
Manual tube-to-header welds <sup>L18</sup>	-	-	-	12 <sup>L18</sup>	-	X	X	-	

<sup>L1</sup> The mechanical properties of test weldments for cast materials shall meet the minimum requirements of the applicable base material specification, except when the base material is shown, by actual testing, to have lower values. In this case these lower values may be used to evaluate and accept the mechanical property test results of the

weldment, provided:

- (a) The actual tensile properties of the weldment are equal to at least 90 percent of the values in the applicable base material specification.
- (b) The bend angle of the test weldment specimen is equal to or greater than that attained with the base metal test specimen.

L2J Charpy impact tests shall be performed under any of the following conditions:

- (a) For production welding of 1/2 inch and over in material thickness when both the base metal specification and the filler metal specification have impact requirements (except when the production application is for weld cladding).
- (b) For production welding of 1/2 inch material thickness in bi-metallic joints where both base metals and the filler metal specifications have impact requirements.

Where qualification was performed on base material without specified toughness requirements and cross qualification is permitted for materials having toughness requirements, welding of materials with toughness requirements shall be limited to 1/2-inch thickness.

L3J See 4.4.7.1 and 4.4.9.1.

L4J When required for the testing of specimens taken from thick test assemblies, the reduced section tensile specimens and the side bend specimens shall be cut into multiple specimens as permitted by AWS B4.0.

L5J When Charpy impact tests are required by note 2 above, sets of five impact specimens shall be prepared from the weld metal, sets of three impact specimens shall be prepared from the heat affected zone (HAZ) of each base metal and sets of three impact specimens shall be prepared from the non-affected area of each base metal. Base material and HAZ impact test data is not required for S-11 (HY-80/100 or HY-130 or HSLA-80/100 only) or S-1 (MIL-S-22698 only) materials. When more than one set of specimens for the weld metal is required each set shall represent a different weld depth level with one set taken from the test assembly midthickness. When double beveled butt weld test assemblies are employed, weld metal impact specimens shall be removed from each side of the joint (that is, at least two specimens from each side). Specimens shall be prepared as specified below:

Thickness	Minimum sets of specimens			Minimum no. of specimens		
	Weld	HAZ	B.M.	Weld	HAZ	B.M.
1/2 to 2 inch incl.	1	1	1	5	3	3
Over 2 to 4 inch incl.	2	1	1	10	3	3
Over 4 inches	3	1	1	15	3	3

Base metal and HAZ specimens shall be prepared in accordance with figure 24.

L6J Tensile tests shall be transverse weld tensile specimens (round or reduced section). For S-11 materials welded to themselves or to each other and S-51 and S-53 base materials welded to themselves or to each other which are 3/4 inch and over in thickness, tensile tests shall include two transverse weld tensiles and two all weld tensiles; when double bevel butt weld test assemblies are employed, one all weld metal tensile specimen shall be removed from each side.

- L7J When side bends are required for a given material and the test thickness is less than 3/4 inch, two root bends and two face bends may be tested in lieu of side bends. If the procedure is for full penetration pipe butt joints welded from one side without backing rings or preplaced inserts, root bends with the root surface in the as welded condition (that is, no machining, grinding, and so forth) are required when the root is welded without the addition of filler metal or without internal inert gas purge.
- L8J Acceptance standards shall be as specified in 4.5.2.6.
- L9J Use a 3T bend for S-11B base material.
- L10J See 4.4.3.
- L11J Liquid penetrant inspection required (see 4.4.2.1) prior to destructive testing. Chemical testing for corrosion-resistance shall be performed only when specified in the applicable fabrication document.
- L12J Hardness testing is required for hardfacing for wear resistance as specified in 4.4.2.2.
- L13J To perform qualification for root layer deposition and for depositing previously qualified fill procedures on root layers, in accordance with 4.4.1.4, four macro-etch specimens shall be examined and shall meet the requirements of 4.5.2.6 in lieu of radiographic, tensile and bend tests. If the procedure is for full penetration pipe butt joints welded from one side without backing rings or preplaced inserts, root bends with the root surface in the as welded condition (that is, no machining, grinding, and so forth) are required (in addition to the macro-etch specimens) when the root is welded without the addition of filler metal or without internal inert gas purge.
- L14J Dynamic tear testing as specified in ASTM E 604 may be substituted for Charpy V-notch when the material specification (base or filler) provides for dynamic tear testing.
- L15J Only visual and liquid penetrant examination of the weld surface and two macro-etch specimens in accordance with 4.5.2.6 shall be required where test assembly thickness is 0.058 inch or less.
- L16J Visual inspection of all test assemblies shall be performed prior to other nondestructive testing.
- L17J Bend tests shall meet the requirements of the applicable material specification. Unless otherwise authorized by NAVSEA, a bend radius of 8T shall be used for those specifications not requiring bend tests.
- L18J See 4.4.9.
- L19J Inspect 100 percent of weld when radiographic or ultrasonic inspection is specified.
- L20J Ultrasonic inspection shall be performed on material 1 inch thick and greater in accordance with 4.5.
- L21J Use of the gas metal arc-short arc process for groove weld qualification of any material shall require UT inspection of the test assembly in addition to all other tests and inspections. Where thickness is below that allowed by MIL-STD-271 for normal UT inspection, six transverse macro-specimens shall be substituted for UT inspection.

TABLE VIII. Grouping of filler metals and process combinations for welder or welding operator (performance qualification).<sup>L1</sup>

Category <sup>L2</sup>	Filler metal group <sup>L5</sup>	Category for which tests qualify welder <sup>L3</sup>	
		Shielded metal arc	
1	A-5A	1 through 3	
2	A-2A, 3A, 4A, 6A, 7A1, 7A2	2 and 3	
3	A-1A	3	
4	A-8A, A-43A	4	
5	A-34A, 41A, 42A, 43A	5	
Category <sup>L2</sup>	Filler metal group <sup>L5</sup>	Gas metal-arc <sup>L6</sup>	Gas tungsten-arc, plasma-arc <sup>L6</sup>
1	A-5B	1 through 2	1 through 2
2	A-1B, 2B, 3B, 6B, 7B	2	2
3	A-8B, A-43B, A-7B-2	3	3
4	A-34B, 41B, 42B, 43B	4	4
5	A-31B, 32B, 33B, 35B, 36B, 37B	5	5
6 <sup>L4</sup>	A-21B, 22B, 23B, 24B	6	6
Category <sup>L2</sup>	Filler metal group <sup>L5</sup>	Submerged-arc <sup>L6</sup>	
1	A-5C	1 through 4	
2	A-2C, A-3C	1 through 4	
3	A-8B	1 through 4	
4	A-34B, A-41B, A-42B, A-43B	1 through 4	
5	A-7B-2	1 and 5	
Category <sup>L2</sup>	Filler metal group <sup>L5</sup>	Flux-cored-arc <sup>L6</sup>	
1	A-5D	1 and 2	
2	A-2D	1 and 2	

<sup>L1</sup> For hard surfacing, a welder qualified on test number 9 with any hard surfacing filler metal is qualified to hard surface using any filler metal within the limit of the welding process used for qualification.

<sup>L2</sup> See 5.2.5.

<sup>L3</sup> Welder and welding operator qualification within the filler metal categories shown in table VIII may be applied for welding similar, as well as dissimilar base metal combinations with qualified welding procedures.

<sup>L4</sup> On S-21 through S-26 base material.

<sup>L5</sup> See table II.

<sup>L6</sup> For automatic machine welding a welding operator qualified to weld with one qualified procedure is also qualified to weld in accordance with other qualified procedures, using the same welding process and equipment.

TABLE IX. Performance qualification - position limitations. L<sub>1</sub> L<sub>6</sub> L<sub>9</sub> L<sub>11</sub>

		Position and type weld qualified L <sub>1</sub> L <sub>4</sub> L <sub>7</sub> L <sub>8</sub> L <sub>9</sub> L <sub>10</sub>			
Qualification test		Groove		Fillet	
Weld	Position	Plate and pipe over 24 inches od	Pipe	Plate and pipe	
Plate - groove L <sub>3</sub>	1G	F	F L <sub>2</sub>	F	
	2G	F, H	F L <sub>2</sub>	F, H	
	3G	F, V	F L <sub>2</sub>	F, H, V	
	4G	F, O	F L <sub>2</sub>	F, H, O	
	3G and 4G	F, V, O	F L <sub>2</sub>	A11 L <sub>5</sub>	
	2G, 3G, and 4G	All	F L <sub>2</sub>	All	
Plate - fillet	1F	...	...	F L <sub>2</sub>	
	2F	...	...	F, H L <sub>2</sub>	
	3F	...	...	F, H, V L <sub>2</sub>	
	4F	...	...	F, H, O L <sub>2</sub>	
	3F and 4F	...	...	A11 L <sub>2</sub>	
Pipe - groove	1G	F	F	F	
	2G	F, H	F, H	F, H	
	5G	F, V, O	F, V, O	All	
	6G	All	All	All	
	2G and 5G	All	All	All	
Pipe - Fillet	1F	...	...	F	
	2F	...	...	F, H	
	2FR	...	...	F, H	
	4F	...	...	F, H, O	
	5F	...	...	All	

L<sub>1</sub> Positions of welding as shown on figure 1.

F = Flat

H = Horizontal

V = Vertical

O = Overhead

L<sub>2</sub> Pipe 2-7/8 inch od and over.

L<sub>3</sub> Including weld surfacing.

L<sub>4</sub> Including seal welds.

L<sub>5</sub> Where the gas metal-arc welding process is to be qualified in all positions the horizontal position is also required.

L<sub>6</sub> In special cases when production welding is to be done in a particular orientation intermediate to those shown on figure 1, the welder qualification may, if the organization desires, be made in an intermediate position with the limitation that the qualification shall be valid for the actual position tested with an angle tolerance of plus 15 degrees in incline to 0 degrees on the flat or horizontal axis.

- L7J Socket welds and tube-to-tubesheet welds excluded.
- L8J See 5.3.5 for qualification tests for socket welds, tube-to-tubesheet welds and seal welds other than edge or fillet type. See 5.3.6 for qualification tests for internal tube-to-header welds in boiler components.
- L9J The plasma-arc process, using the keyhole technique, must be for each position of welding to be used in production.
- L10J Qualification on plate with an automatic welding process shall qualify that process on pipe over 24 inches od.
- L11J When qualifying for welding in the vertical plane in either plate or horizontal fixed-pipe, welding shall be in the up direction. Welding vertical down shall require a separate qualification test (see 4.7.6 and 4.8) except that automatic, 50 position pipe qualification employing 360 degree uninterrupted progression qualifies such progression for the passes involved.

TABLE X. Performance qualification test limitations. L7J L12J

Form of base material qualified	Thickness of base material to be qualified	Required qualification test assembly
Plate		
Castings, forgings and shapes	0.058 inch and greater L1J	Test no. 1 or 2 L9J (figures 12 or 14)
Pipe L2J L3J L4J L5J L6J	0.058 inch to 2T L1J	Test no. 3 or 5 L9J (figures 15 and 22)
	0.058 inch or greater	Test no. 4 or 6 L9J (figures 15 or 22)
Pipe or plate	All thicknesses	Test no. 8 L8J (figure 16 for track and fillet welds)
Pipe or plate	All thicknesses	Test no. 9 (figure 17 for weld surfacing only)
Pipe or plate L10J	See footnote L11J	Test no. 10 (figure 26)

- L1J Performance qualification for thicknesses under 0.058 inch may be accomplished by welding a thinner test piece similar to test number 1, 3 or 5, as applicable, using a qualified -thickness range of T to 2T where T is the test plate thickness. Also, performance qualification can be accomplished on thicknesses 0.058 inch or greater but less than the specified qualification test assembly thickness and the qualification range will be 0.058 inch to 2T. The minimum thickness shall be 10 percent below the nominal pipe wall thickness welded for socket and fillet seal weld qualifications performed with manual or semiautomatic processes on pipe with wall thickness in the range 0.058 to 3/16 inch.

- L<sub>2</sub>] Welders qualified to either test numbers 3, 4 or the fill portions of test number 5, 6 or 10 shall be considered qualified to weld (with the process employed) all types of pipe joints except for the root, or root plus one layer in preplaced filler metal insert root butt joints and full penetration butt joints welded from one side with no backing ring or preplaced insert.
- L<sub>3</sub>] A welder or welding operator may perform only part of the preplace filler metal insert or other root performance qualification test, that is, just the root, root plus one layer or subsequent layers, but he shall be qualified only for that part of the insert joint he actually made during qualification testing. Qualifications for welding the root only or root plus one layer are not subject to the thickness limitations of this table.
- L<sub>4</sub>] Qualification test numbers 3 or 4 will qualify for root connections, fillets, bosses, and partial penetration welds except for the insert root or insert .root plus one layer of preplaced filler metal insert root butt joints and all full penetration butt joints welded from one side with no backing ring or preplaced insert. See 5.3.5 for limitations.
- L<sub>5</sub>] Qualification test numbers 5 or 6, that is, insert root and fill portions, will qualify for use of the processes employed for all joint types, except for full penetration butt joints welded from one side with no backing ring or preplaced insert.
- L<sub>6</sub>] Qualification on a pipe test shall qualify the same thickness for plate welding.
- L<sub>7</sub>] Qualified welders are also qualified as tack and fillet welders.
- L<sub>8</sub>] Welders qualified on test number 8 are qualified as tack and fillet welders.
- L<sub>9</sub>] For full penetration butt joints welded from one side with no backing or preplaced insert, the weld joint design used for performance qualification shall be that used for procedure qualification.
- L<sub>10</sub>] Performance qualification test, no. 10 plasma-arc welding, keyhole technique, will qualify other processes used for the remainder of the weld for all joint types, except for full penetration butt joints, welded from one side with a root gap and no backing ring or with a preplaced insert.
- L<sub>11</sub>] Qualification with joint-A, figure 26, qualifies plasma-arc, keyhole technique welds on plate up to 1/4 inch thickness for square butt joints and up to 3/16 inch land for groove welds. Maximum plate thickness qualified with joint-B will depend on accessibility of plasma arc torch into weld groove. Weld groove, can be modified to use a compound angle to permit plasma-arc welding in plate thicknesses greater than 3/4 inch.
- L<sub>12</sub>] See 5.3.5 for tube-to-tubesheet welds, seal welds and socket welds. See 5.3.6 for internal tube-to-header welds for boiler components.

TABLE XI. Performance qualification test evaluation requirements.

Test assembly	Evaluation requirements L <sub>1</sub> L <sub>2</sub> L <sub>3</sub> L <sub>4</sub> L <sub>5</sub> L <sub>6</sub>
Test no. 1 or 2A or 2B (figures 12 and 14)	Radiography or bend tests
Test no. 3 or 3B (figure 15 or 13)	Radiography or bend tests L <sub>7</sub>
Test no. 4 (figure 15)	Radiography of bend tests L <sub>7</sub>
Test no. 5) (figure 22)	Radiography L <sub>7</sub>
Test no. 6 (figure 22)	Radiography L <sub>7</sub>
Test no. 8 (figure 16)	Break test
Test no. 10 (figure 25)	Radiography or bend tests L <sub>7</sub>
Automatic/machine pipe assembly	(a) Butt: radiography L <sub>7</sub> (b) Fillets: PT and two macro-etch specimens
Automatic/machine plate assembly	Radiography
Manual tube-to-header weld L <sub>8</sub> (figure 25)	Dye penetrant or magnetic particle and macro-etch examinations
Weld surfacing test no. 9 (figure 17)	Macro-etch examination and dye penetrant
Special weld	As proposed in procedure qualification submittal
Pipe socket welds	See 5.3.5
Tube-to-tubesheet welds, seal welds	

L<sub>1</sub>J Visual evaluation shall be made on each test assembly. For titanium and titanium alloy welds see 5.4.1.1.

L<sub>2</sub>J Ultrasonic inspection, when performed and evaluated in accordance with NAVSEA 0900-006-3010 for welds in plate and MIL-STD-271 for welds in pipe may be substituted for radiographic inspection. Class I acceptance standards from NAVSEA 0900-006-3010 shall be used.

L<sub>3</sub>J See 5.2.5.

L<sub>4</sub>J Radiography of pipe shall be 360 degrees. Radiography of plates shall be the entire length, except that 1 inch on each end of the weld will not be evaluated. Acceptance criteria shall be in accordance with NAVSEA 0900-0,93-9000, class 1.

- L5J Use of the gas metal arc-short arc process for groove weld qualification of any material shall require UT inspection of the test assembly in addition to all other tests and inspections. Where thickness is below that allowed by MIL-STD-271 for normal UT inspection, six transverse macro-specimens shall be substituted for UT inspection.
- L6J When the qualification test consists of root layer only or root plus one layer, four macro-etc specimens shall be evaluated to the requirements of 4.5.2.6 in lieu of radiography or bend tests. When joint is welded without addition of filler metal or without internal purge, root bends as described in note 7 are also required.
- L7J When the qualification is for joints welded from one side without backing rings or preplaced inserts, root bends with the root surface in the as welded condition (no machining, grinding, and so forth) are required when the root is welded without the addition of filler metal or without internal inert gas purge.
- L8J See 5.3.6.

TABLE XII. Material combinations and brazing alloy requirements. L4J

Material (P-no.)						
Material (P-no.)	P-101 L2J	P-102 L3J	P-107 L2J	P-108 L1J	P-110 L2J	P-111 L3J
P-101 L2J	F-101	F-102	F-101	F-101	F-101	F-101
P-102 L3J	F-102	F-102	F-102	F-102	F-102	F-102
P-107 L2J	F-101	F-102	F-101 or F-103	F-101 or F-103	F-101	F-101
P-108 L1J	F-101	F-102	F-101 or F-103	F-101 or F-103	F-101	F-101
P-110 L2J	F-101	F-102	F-101	F-101	F-101	F-101
P-101 L3J	F-101	F-102	F-101	F-101	F-101	F-101

- L1J Aluminum bronze materials require special aluminum bronze brazing flux as specified in O-F-499, type A (Handy and Harman Special Flux Type A-1 or equivalent).
- L2J Flux shall conform to type A or B or equivalent of O-F-499.
- L3J Grade V alloy shall be used for any brazed joint where one or both of the metals joined is stainless steel.
- L4J F-103 brazing alloys shall not be used on ferrous alloys, nickel base alloys or stainless steel.

TABLE XIII. Grouping or base materials for brazing procedure and performance qualification<sup>L1</sup>

Group	Specifications	Type of material
P-101	Ferrous alloys with chromium content less than 0.90 percent	
	MIL-S-24093 MIL-P-24691/1 MIL-S-22698 WW-P-404	Carbon steel Carbon steel Carbon steel Carbon steel
P-102	Ferrous alloys with chromium content 0.90 percent or greater	
	MIL-P-24691/3 MIL-S-23195 MIL-T-23226 QQ-S-763 QQ-S-766	Type 304, 316, 321 and 347 Type 304 and 347 Type 304 and 347 Class 304, 316, 321 and 347 Class 304, 316, 321 and 347
P-107	Copper alloys with aluminum content less than 0.50 percent	
	MIL-T-15005 MIL-C-15726 MIL-T-16420 MIL-T-20168 MIL-T-20219 MIL-T-24107 QQ-B-626 QQ-B-637 QQ-B-639 QQ-B-728 (class A) QQ-B-750 (comp. A and D) MIL-T-24107 WW-T-799 QQ-C-390 (alloys 903 and 922)	Copper nickel Copper nickel Copper nickel Brass Brass Copper Brass Naval brass Naval brass Manganese bronze Phosphorous bronze Copper Copper Tin bronze
P-108	Copper alloys with aluminum content 0.50 percent or greater	
	QQ-C-390 MIL-B-24480 MIL-B-24480 QQ-C-450 QQ-C-390 QQ-C-450 QQ-B-728 (class B) QQ-C-465	Aluminum bronze Nickel aluminum bronze Nickel aluminum bronze Nickel aluminum bronze Aluminum bronze Copper aluminum alloy Manganese bronze Copper aluminum alloys 606, 614, 630, and 642

See footnote at end of table.

TABLE XIII. Grouping or base materials for brazing procedure and performance qualification<sup>L1J</sup>

Group	Specifications	Type of material
P-110	Nickel alloys with chromium content less than 1 percent	
	MIL-T-1368	Nickel copper
	MIL-N-17163	Nickel copper
	MIL-T-23520	Nickel copper
	QQ-N-281	Nickel copper
	QQ-N- 88 (comps. A and E)	Nickel copper
P-111	Nickel alloys with chromium content 1 percent or greater	
	MIL-B-15382	Nickel chromium iron
	MIL-T-23227	Nickel chromium iron
	MIL-N-23228	Nickel chromium iron
	MIL-N-23229	Nickel chromium iron
	MIL-N-24114	Nickel chromium iron

<sup>L1J</sup> For purposes of qualification, alloys classified under identical ASME P-numbers or alloys having similar chemical compositions may be included in the categories listed above when approved.

TABLE XIV. Groupings of brazing alloys for procedure and performance qualification.<sup>L1J</sup>

Group	Specification	Alloy classification	AWS classification
F-101	QQ-B-654	Grade IV Grade VII	BAg-1a BAg-1
F-102	QQ-B-654	Grade I Grade II Grade V Grade VIII	BAg-5 BAg-3 BAg-2
F-103	QQ-B-654	Grade III	BCuP-5
	QQ-B-650	FS B CuP-2 FS B CuP-3 FS B CuP-4	BCuP-2 BCuP-3 BCuP-4

<sup>L1J</sup> If brazing alloys of similar chemistry and mechanical properties not listed under a F-number group are to be used, they may be considered as a group upon approval.

TABLE XV. Type and number of test specimens required and range of thickness qualified (brazing procedure qualification).

Thickness $t$ , of test sample as brazed (in)	$t$ to $3/8$	Over $3/8$ to $3/4$	Over $3/4$
Range of thickness of materials qualified by test, inches	$1/2t$ to $2t$	$3/8$ to $2t$	$3/4$ to $2t$
Type and number of tests required			
Reduced section tension	2	2	2
Peel <sup>L1</sup> J	2	2	2

<sup>L1</sup>J Ultrasonic testing may be used in lieu of peel testing.

TABLE XVI. Axial load and torque values for procedure qualification. <sup>L1</sup>J <sup>L2</sup>J

Stud size	Carbon steel					
	UNC, NC class 2A			UNF, NF class 2A		
	Minor dia.	Axial load, lbs	Torque in-lbs	Minor dia.	Axial load, lbs	Torque in-lbs
10	0.1379	745	15	0.1508	895	20
1/4	.1876	1380	39	.2052	1655	51
5/16	.2431	2320	85	.2603	2660	104
3/8	.2970	3465	154	.3228	4090	190
7/16	.3485	4770	249	.3749	5520	310
1/2	.4041	6410	389	.4374	7515	493
5/8	.5119	10298	790	.5554	12115	1009
3/4	.6255	15365	1442	.6718	17725	1786
7/8	.7368	21320	2356	.7858	24250	2858
1	.8646	28020	3550	.8960	31525	4237
1-1/8	.9475	35255	5011	1.0210	40935	6269
1-1/4	1.0725	45178	7268	1.1460	51570	8865

See footnotes at end of table.

TABLE XVI. Axial load and torque values for procedure qualification. <sup>L1</sup> <sup>L2</sup>

Corrosion resistant steel						
UNC, NC class 2A				UNF, NF class 2A		
Stud size	Minor dia.	Axial load, lbs	Torque in-lbs	Minor dia.	Axial load, lbs	Torque in-lbs
10	0.1379	1192	25	0.1508	1432	32
1/4	.1876	2208	62	.2052	2648	82
5/16	.2431	3712	135	.2603	4256	166
3/8	.2970	5544	247	.3228	6544	316
7/16	.3485	7632	399	.3749	8832	496
1/2	.4041	10256	622	.4374	12024	789
5/8	.5119	16464	1264	.5554	19384	1615
3/4	.6255	24584	2307	.6718	28360	2858
7/8	.7368	34112	3770	.7858	38800	4573
1	.8646	44832	5680	.8960	50440	6779
Aluminum (5000 series)						
UNC, NC class 2A				UNF, NF class 2A		
Stud size	Minor dia.	Axial load, lbs	Torque in-lbs	Minor dia.	Axial load, lbs	Torque in-lbs
10	0.1379	522	11	0.1508	627	14
1/4	.1876	966	27	.2052	1159	36
5/16	.2431	1624	59	.2603	1862	73
3/8	.2970	2426	108	.3228	2863	139
7/16	.3485	3339	175	.3749	3864	217
1/2	.4041	4487	272	.4374	5261	345

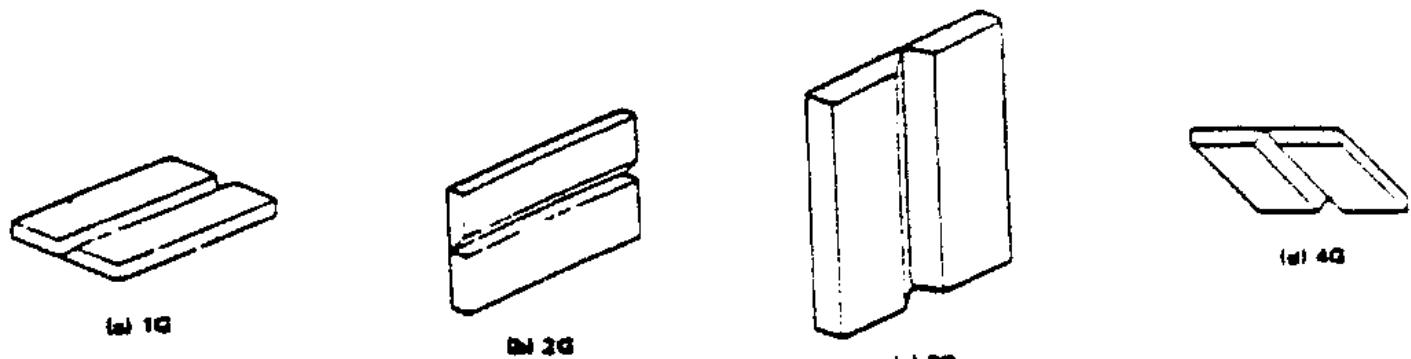
<sup>L1</sup> Torque calculated using minimum thread diameter (root of threads) and following tensile strengths:

Carbon steel	50,000 lb/in
CRES	80,000 lb/in
Aluminum	35,000 lb./in

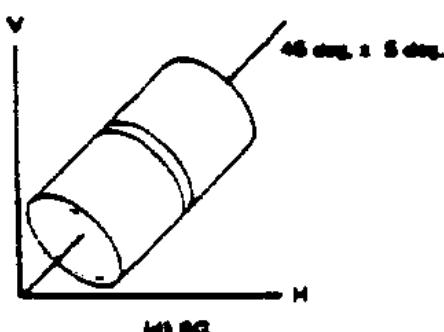
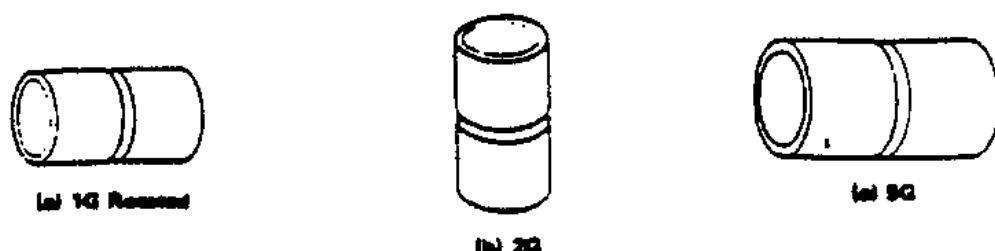
Use of studs having minimum diameters other than those listed or of

materials not listed will require calculation of appropriate torque based on actual diameter and minimum required tensile strength for the stud and stud material involved. Such calculations shall be submitted with the procedure qualification data.

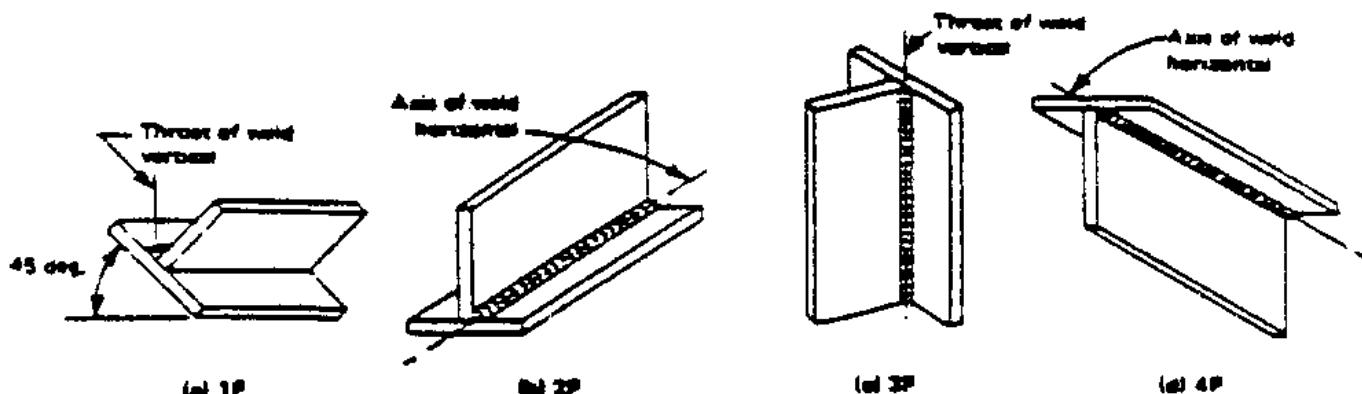
- L2-J If austenitic corrosion resistant steel studs are welded to carbon steel plate, the torque values for carbon steel studs may be used.



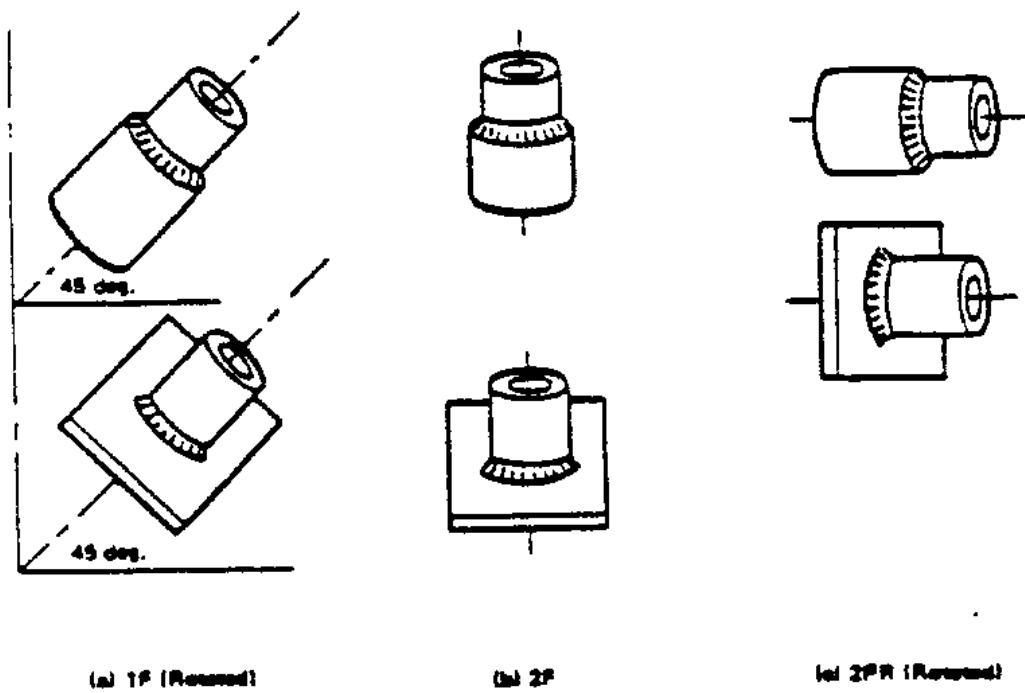
GROOVE WELDS IN PLATE - TEST POSITIONS



GROOVE WELDS IN PIPE - TEST POSITIONS



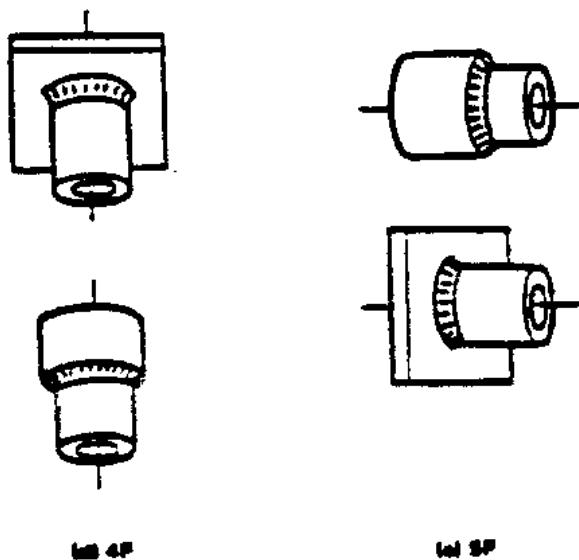
FILLET WELDS IN PLATE - TEST POSITIONS



(a) 1F (Reversed)

(b) 2F

(c) 2FR (Reversed)



(f) 4F

(g) 5F

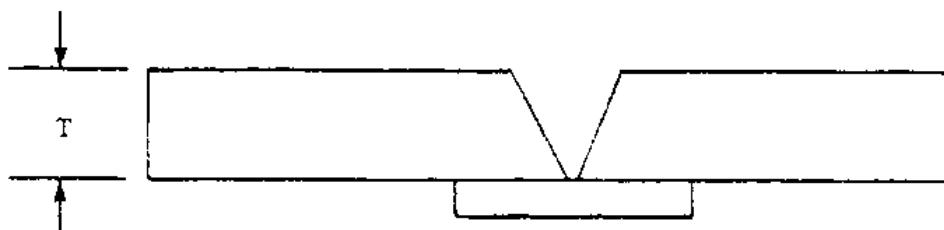
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### FILLET WELDS IN PIPE - TEST POSITIONS

NOTE: Rotation of the weld face plus or minus 15 degrees about the axis of the weld from the orientation shown does not change the classification of the welding position.

FIGURE 1. Positions of welding. - Continued

Discard				
Reduced Section				4/
Side bend				
Charpy impact				5/
			All weld tensile	4/
Charpy Impact				5/
Side bend				
			All weld tensile	4/
Charpy impact				5/
Side bend				
Reduced Section				4/
Discard				

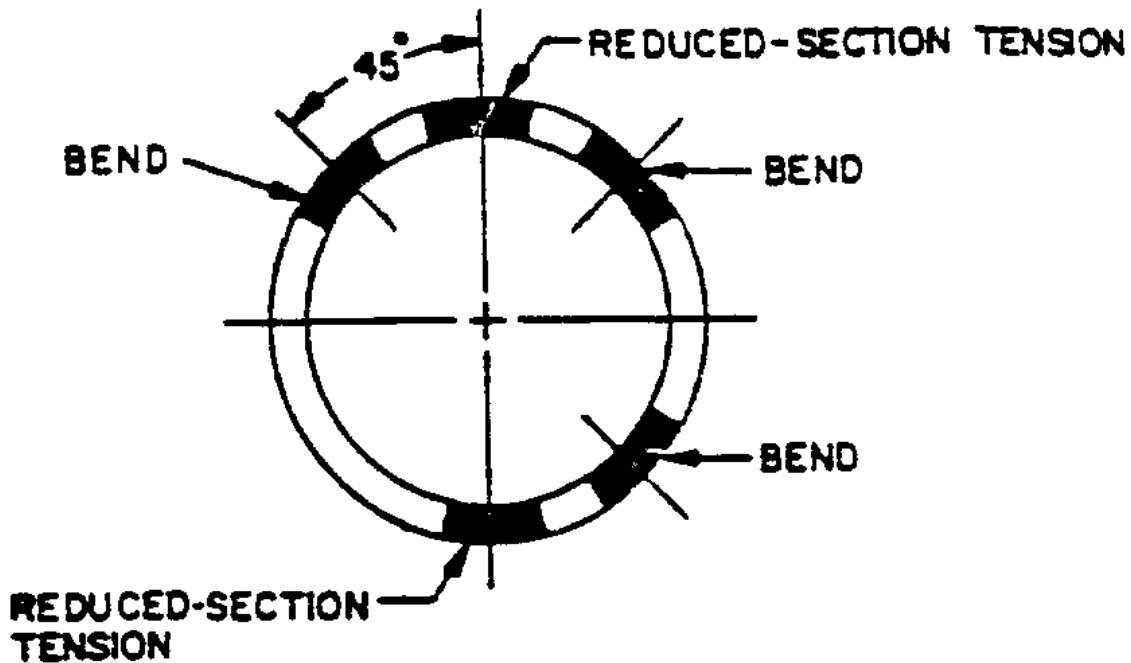


SH 9310

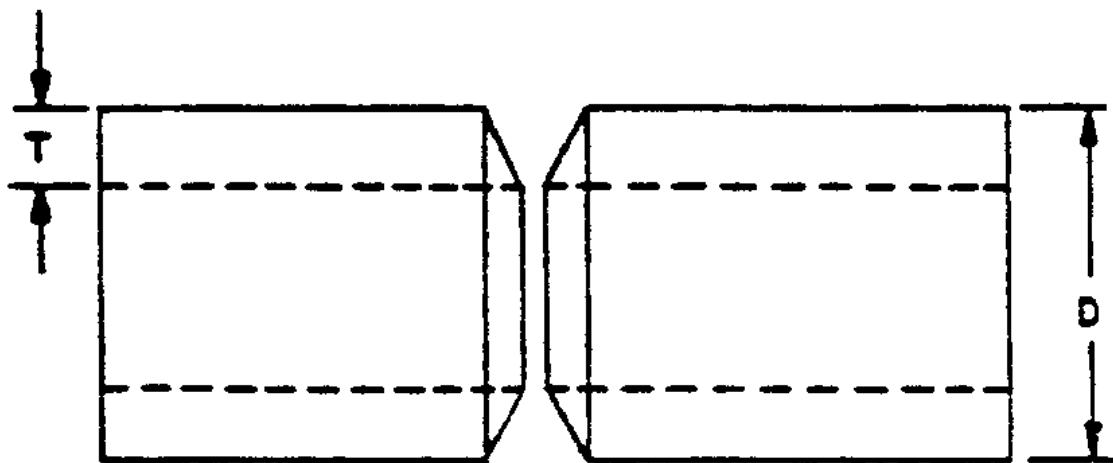
NOTES:

1. Joint design (see 4.4.1.3).
2. Test assembly material (see 4.4.1.1).
3. Test assembly size (see 4.4.1.2).
4. Tensile specimen requirements are specified in footnote 6 of table VII.
5. When HAZ toughness testing is required a straight wall joint design is preferred. Material for specimen shall be removed as indicated. See figure 24 for preparation of HAZ Charpy impact specimens.

FIGURE 7 Typical welding procedure qualification test plate and recommended locations for removal of test specimens.



SUGGESTED ORDER OF REMOVAL OF  
TRANSVERSE TEST SPECIMENS FROM WELDED PIPE

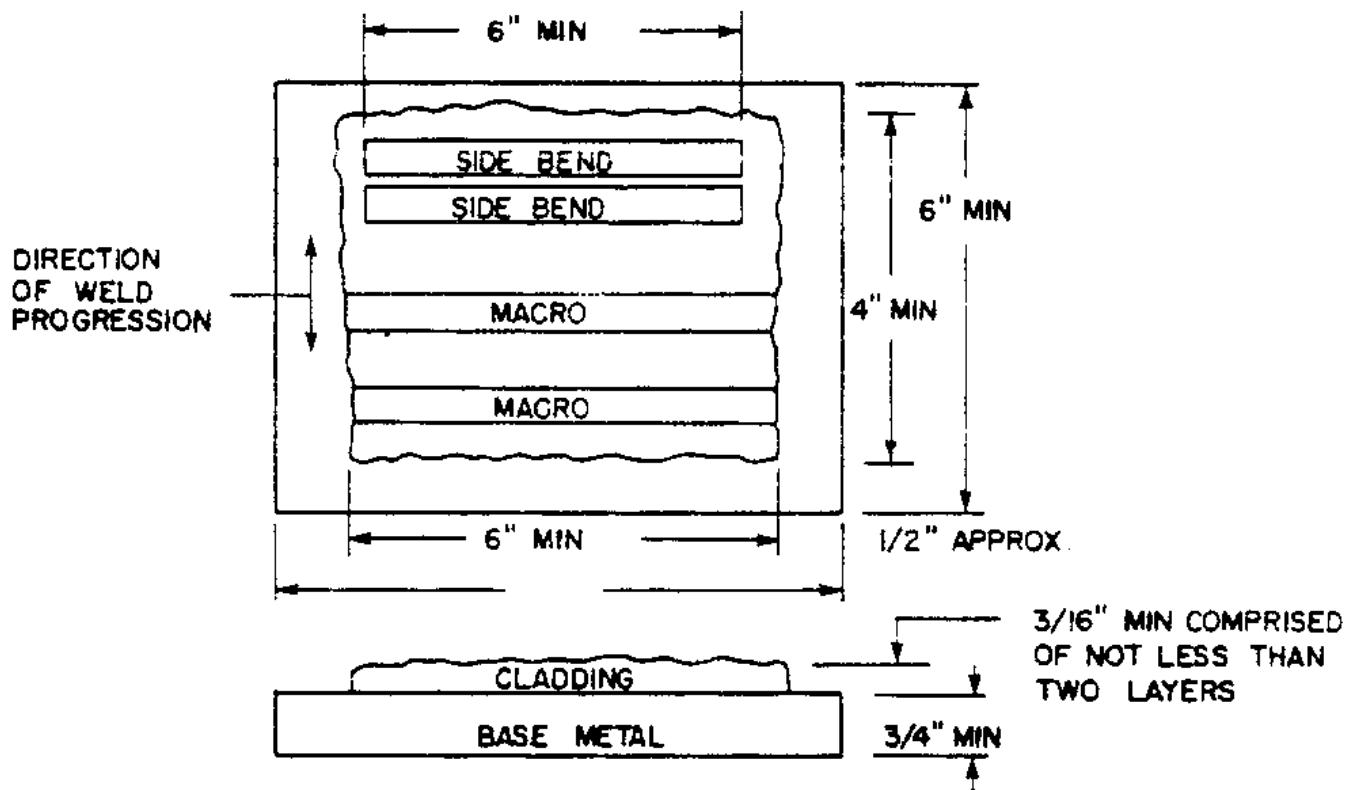


SH 9311

NOTES:

1. Diameter (d) (see 4.4.1.2).
2. Joint design (see 4.4.1.3).
3. Test assembly material (see 4.4.1.1).

FIGURE 3. Typical welding procedure qualification pipe test assembly.

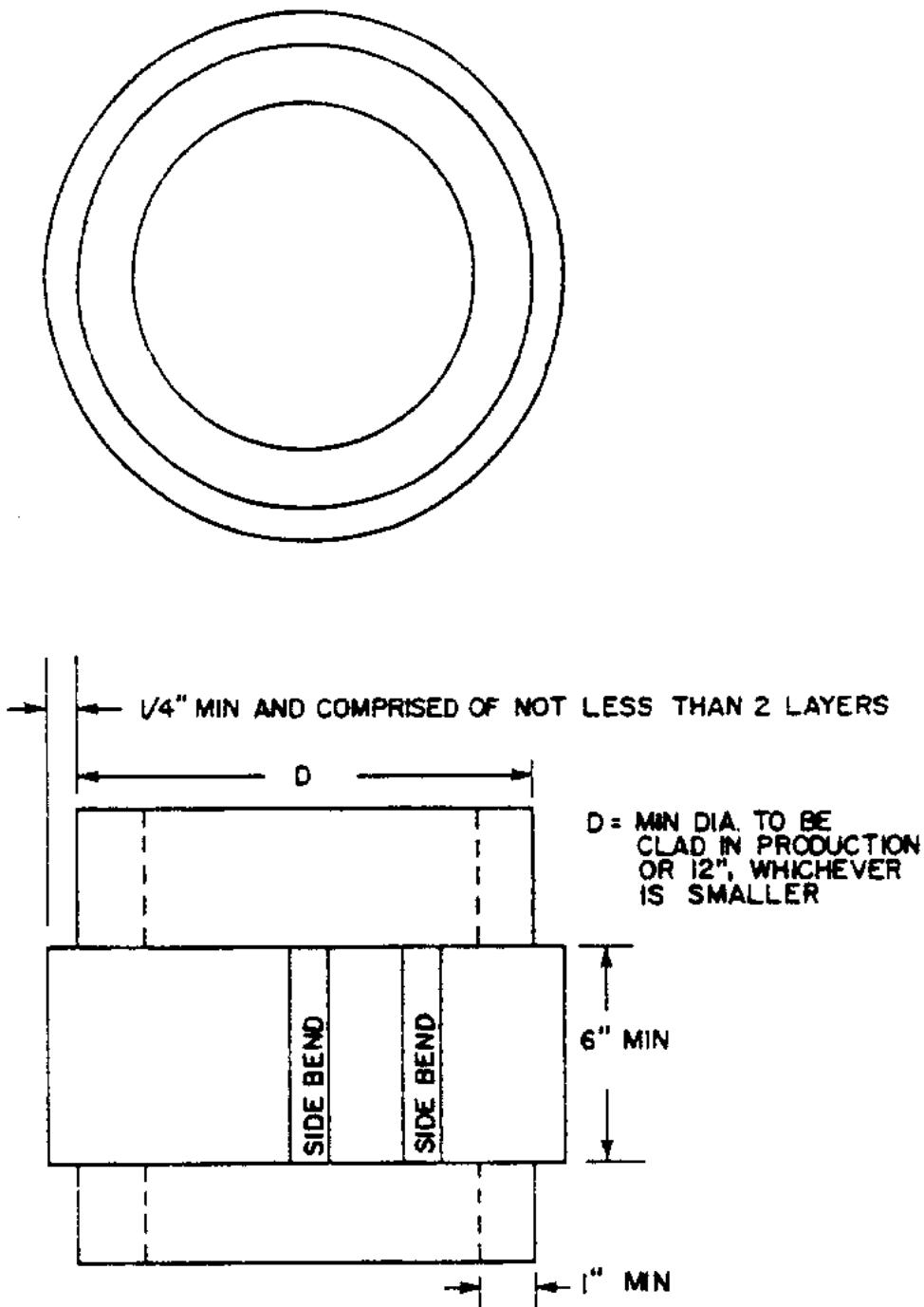


SH 9312

NOTES:

1. The surface of the weld cladding shall be machined and liquid penetrant inspected as required in 4.4.2.1 prior to removal of macro specimens and side bends.
2. Macro-examination and side bending shall be in accordance with table VII and 4.4.2.1.
3. For manual GTAW, clad weld, area may be reduced to 2 by 3 inches by two layers thick.

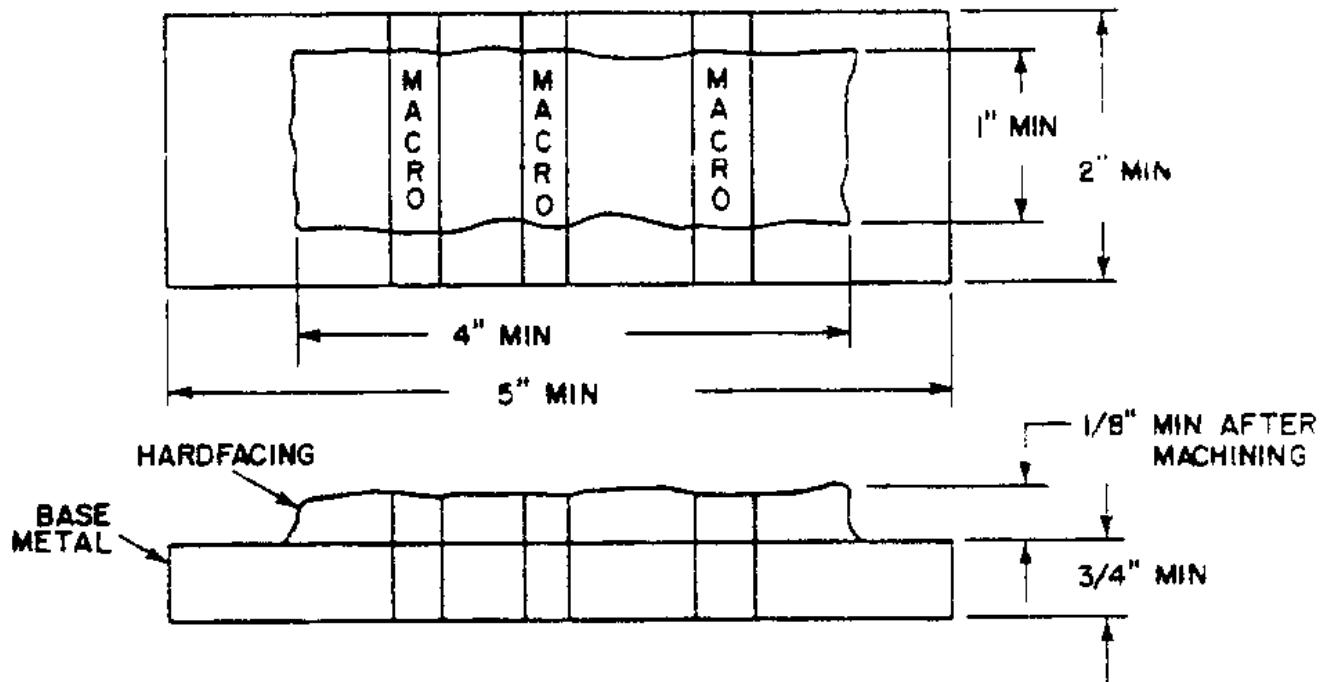
FIGURE 4. Test assembly for qualification of cladding for corrosion-resistance except for circumferential welding applications on shafting.



NOTES:

1. The surface of the cladding shall be machined and liquid-penetrant inspected as required in 4.4.2.1 prior to removal of macro specimens and side bends.
2. Macro-examination and side bending shall be in accordance with table VII and 4.4.2.1.

FIGURE 5. Test assembly for procedure qualification of cladding for circumferential welding of shafting.

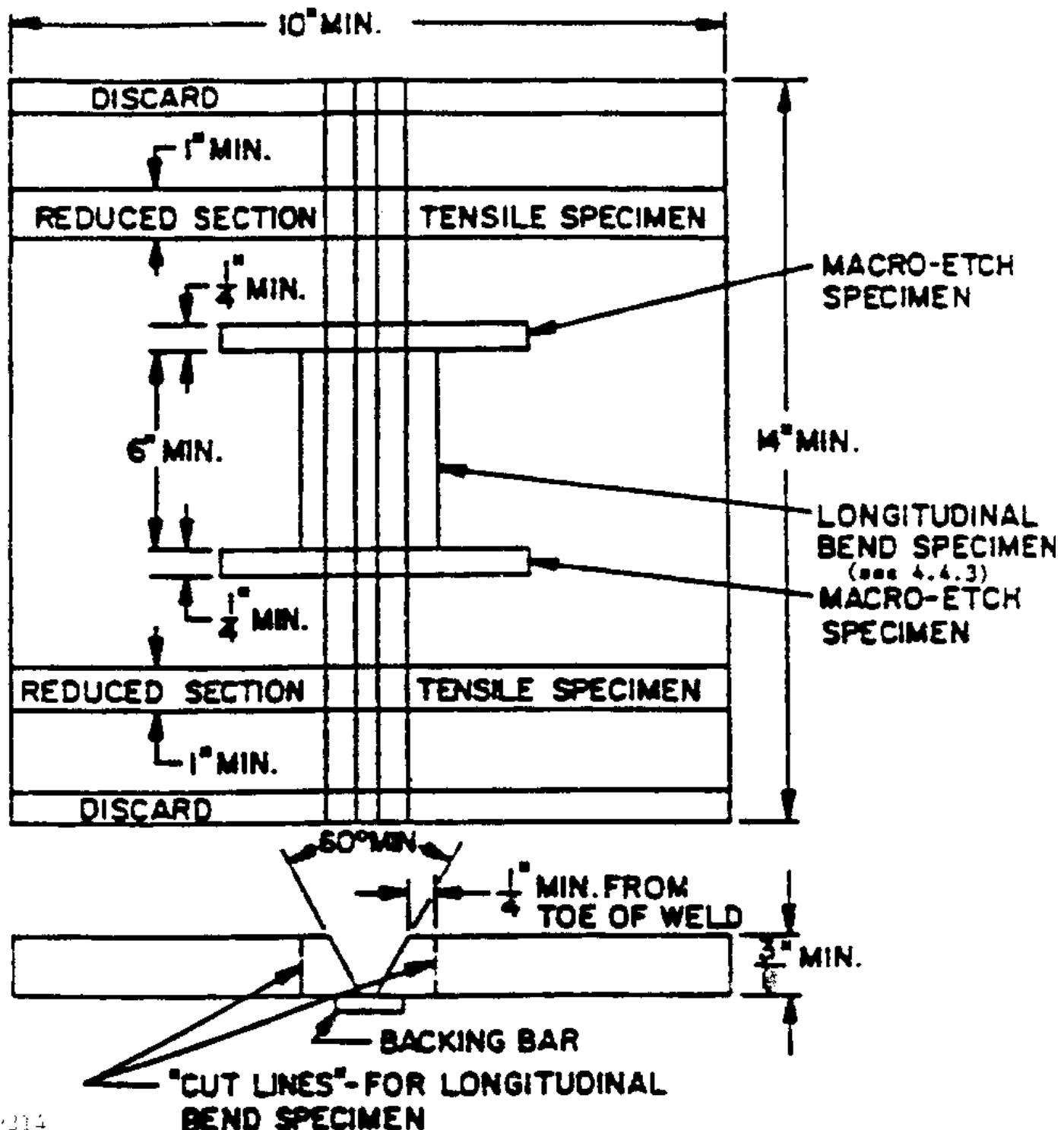


SH 9313

NOTES:

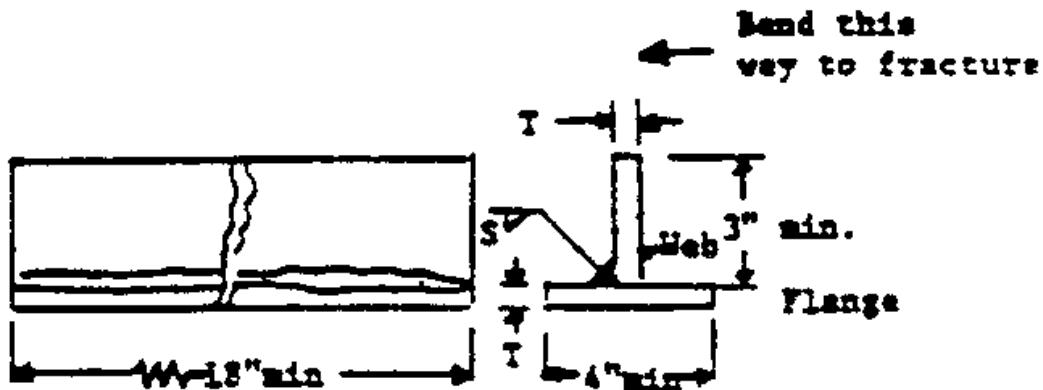
1. Macro-specimen shall be made after other testing is completed.
2. Hardness testing shall require at least 5 random readings (averaged).
3. Testing requirements shall be as specified in table VII and 4.4.2.2.
4. The surface of the hardfacing shall be machined and liquid penetrant inspected as required in 4.4.2.2.

**FIGURE 6. Procedure qualification test plate for hardfacing.**



SH 4214

**FIGURE 7.** Typical location of test specimens from dissimilar metal welded test plate.



T = Maximum thickness to be used in production or  $3/8$  inch, whichever is lesser

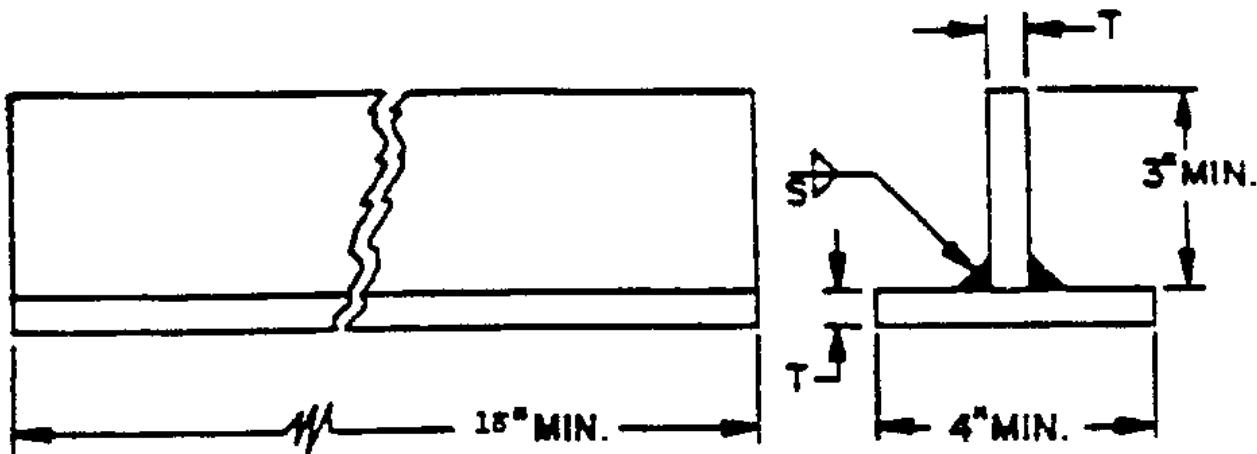
S = Maximum size single pass fillet to be used in production

SH 13203116

NOTES:

1. Positions qualified shall be in accordance with table IV.
2. Test assembly may be cut into shorter lengths after welding to facilitate testing.

FIGURE 8. Test assembly for welding bare surfaces.



**T= MAXIMUM THICKNESS TO BE USED IN PRODUCTION, OR 3/8 INCH, WHICHEVER IS THE LESSER.**

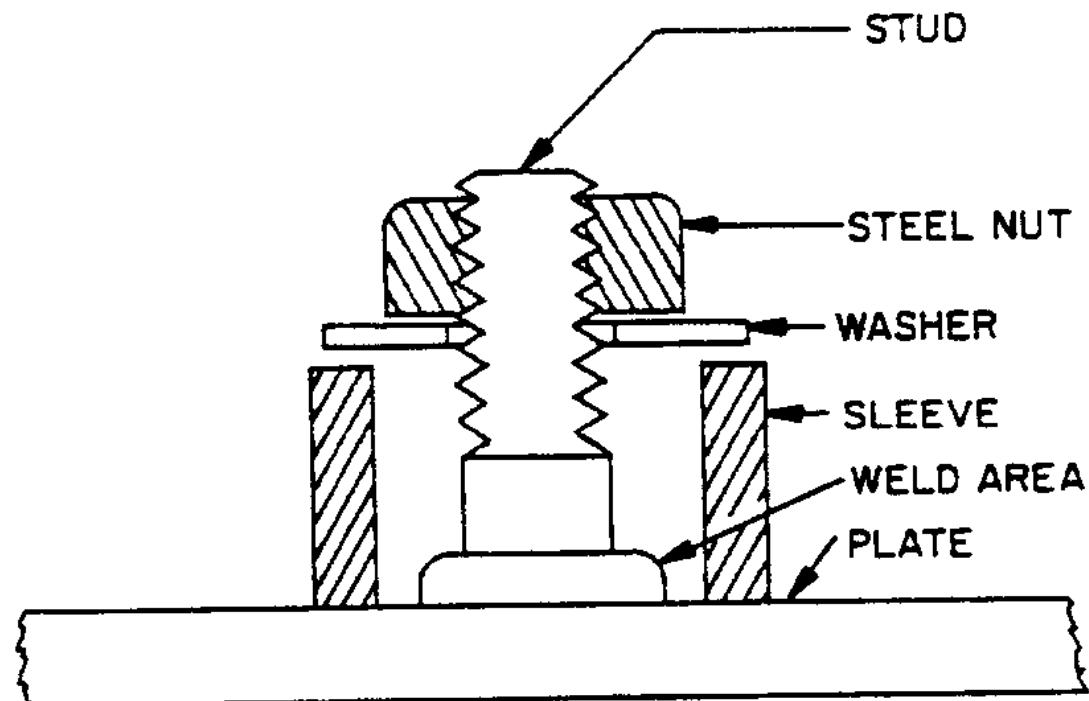
**S= MAXIMUM SIZE SINGLE PASS FILLET TO BE USED IN PRODUCTION.**

SH 9315

NOTES:

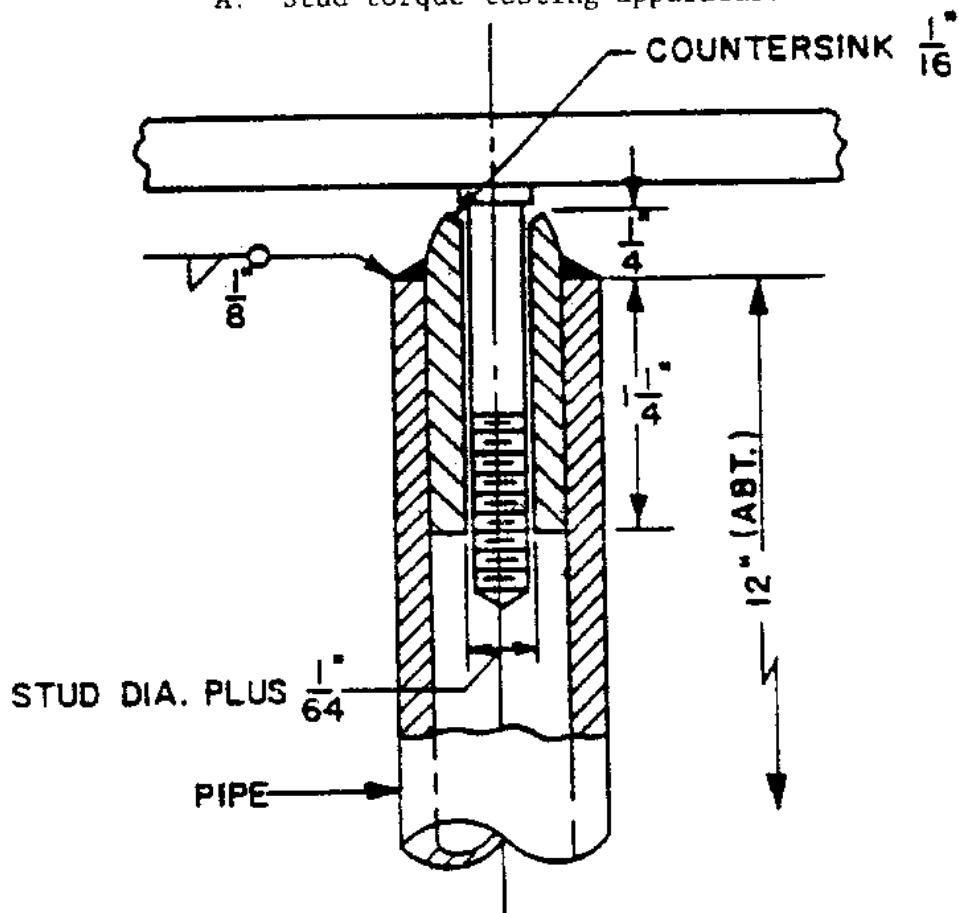
1. Plating shall be either ordinary or higher strength steel as specified in MIL-S-22698 which qualifies the procedure for use on these materials.
2. Plating shall be primer-coated to maximum thickness which will be applied in production.
3. Plate shall be welded in the horizontal position and shall qualify for all positions.
4. Remove first side weld by gouging or mechanical means and fracture second side weld. Test assembly may be cut into shorter lengths after welding to facilitate fracturing for examination.

FIGURE 10 - Test Assembly for welding with ERW Method and dimensions.



SH 9320

A. Stud torque testing apparatus.



SH 9320

B. Device for bending welded studs.



DATE: \_\_\_\_\_

WELDING PROCEDURE QUALIFICATION DATA

WELDING PROCESS \_\_\_\_\_

PLATE PIPE CASTING OTHER

NOTE: SPECIFY OTHER \_\_\_\_\_

FILLER METAL: (1) GOVT SPEC. \_\_\_\_\_

(2) MIL-TYPE \_\_\_\_\_

(3) DIAMETER \_\_\_\_\_

(MAX SIZES TO BE  
USED IN PRODUCTION)

BASE MAT'L: (1) SPEC. \_\_\_\_\_

(2) GRADE OR CLASS \_\_\_\_\_

(3) THICKNESS \_\_\_\_\_

(4) GROUP NO. (S-NO.) \_\_\_\_\_

JOINT DESIGN: \_\_\_\_\_

METHOD OF EDGE PREPARATION: \_\_\_\_\_

WELDING POSITION: \_\_\_\_\_

POWER SOURCE (FOR INFO ONLY) \_\_\_\_\_

(REF. NO. OR SKETCH) \_\_\_\_\_

SKETCH OF JOINT \_\_\_\_\_

ARC VOLTAGE RANGE:

(SEE NOTE 1) \_\_\_\_\_

WELDING CURRENT

RANGE: \_\_\_\_\_

(SEE NOTE 1) \_\_\_\_\_

TRAVEL SPEED RANGE (IPM): \_\_\_\_\_

FLUX: (1) GOVT SPEC. \_\_\_\_\_

TORCH GAS: \_\_\_\_\_

(2) MIL-TYPE \_\_\_\_\_

TORCH TIP SIZE (OXY-FULL): \_\_\_\_\_

(3) SIZE \_\_\_\_\_

CUP SIZE: \_\_\_\_\_

SHIELDING GAS: (1) COMPOSITION: \_\_\_\_\_

(2) FLOW RATE RANGE: \_\_\_\_\_

PURGE GAS: (1) COMPOSITION: \_\_\_\_\_

(2) FLOW RATE RANGE: \_\_\_\_\_

MINIMUM PREHEAT TEMPERATURE: \_\_\_\_\_

MAXIMUM INTERPASS TEMPERATURE: \_\_\_\_\_

POST-WELD HEAT TREATMENT/TEMPERATURE: \_\_\_\_\_

TIME: \_\_\_\_\_

WELDER/WELDING OPERATOR: \_\_\_\_\_

NONDESTRUCTIVE TEST RESULTS

APPLICABLE ACCEPTANCE STANDARD

\*DESTRUCTIVE TEST RESULTS:

BEND

TEST

M.T. \_\_\_\_\_

U.T.S. \_\_\_\_\_

V.S. \_\_\_\_\_

P.T. \_\_\_\_\_

EL. \_\_\_\_\_

M.T. \_\_\_\_\_

\_\_\_\_\_

U.T. \_\_\_\_\_

\_\_\_\_\_

VISUAL

BASE MATERIAL

WELD METAL TESTS

TRANS. \_\_\_\_\_

LONG. \_\_\_\_\_

\*CHARPY IMPACT TEST SHALL BE PERFORMED ON WELD AND RECORDED WHEN REQUIRED BY  
TABLE VII, FOOTNOTE 2

TEST APPROVED BY: \_\_\_\_\_

AT LABORATORY: \_\_\_\_\_

DATE OF CERTIFICATION: \_\_\_\_\_

VERIFIED BY: \_\_\_\_\_

(QUALIFYING ACTIVITY)

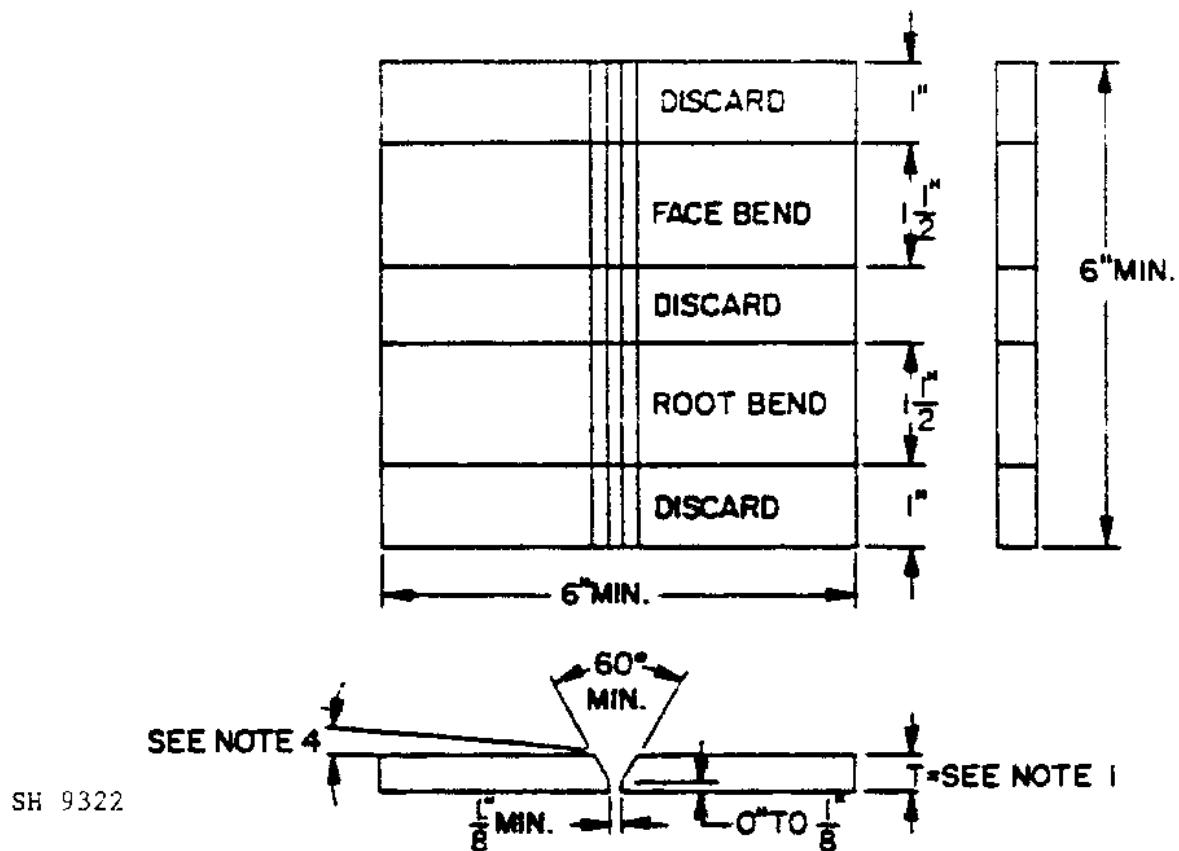
APPROVED BY: \_\_\_\_\_

(AUTHORIZED REPRESENTATIVE)

NOTES:

1. In processes where amperage controls, arc voltages will be recorded for information only; and where voltage controls, amperage will be recorded for information only.
2. Any of the above items not applicable should be so indicated by "N/A".

FIGURE 11. Sample for reporting qualification data.



NOTES:

1. Performance qualification assembly thickness and thickness range qualified shall be as follows:

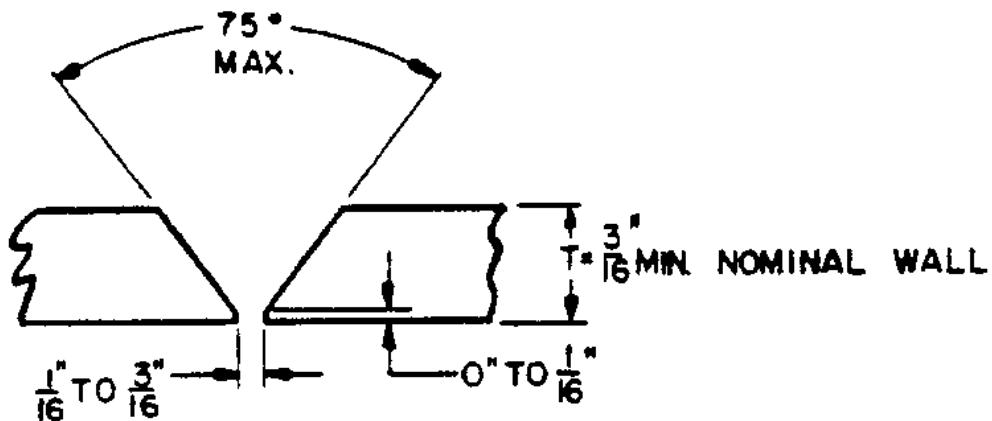
Test no.	Test assembly thickness (T)	Thickness range qualified to weld
2A	Max thickness to be welded in production	1/16 inch to "T"
2B	3/8 inch	1/16 inch to unlimited

2. Weld shall be made with the maximum size welding rod suitable for position of test plate.
3. Joint shall be welded from one side only and joints welded in the vertical position shall be welded upwards.
4. Plates shall not be more than 5 degrees out of parallel after welding.
5. Reinforcement shall be removed flush prior to destructive testing. Undercutting shall not be removed. No repair welding from the root side shall be permitted.
6. Two guided-bend test specimens shall be removed from the test plate if nondestructive testing is not employed.
7. Bend specimens may be machined or oxygen-cut from the plate.
8. Edges of bend specimens shall be broken to a radius of T/6 maximum.

FIGURE 12 Performance qualification test nos. 2A and 2B for fuel gas welding (plate).

Fuel Gas Welding (Plate).]

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SH 9323

Qualification range limitation: 1/16 inch to 3/16 inch pipe wall

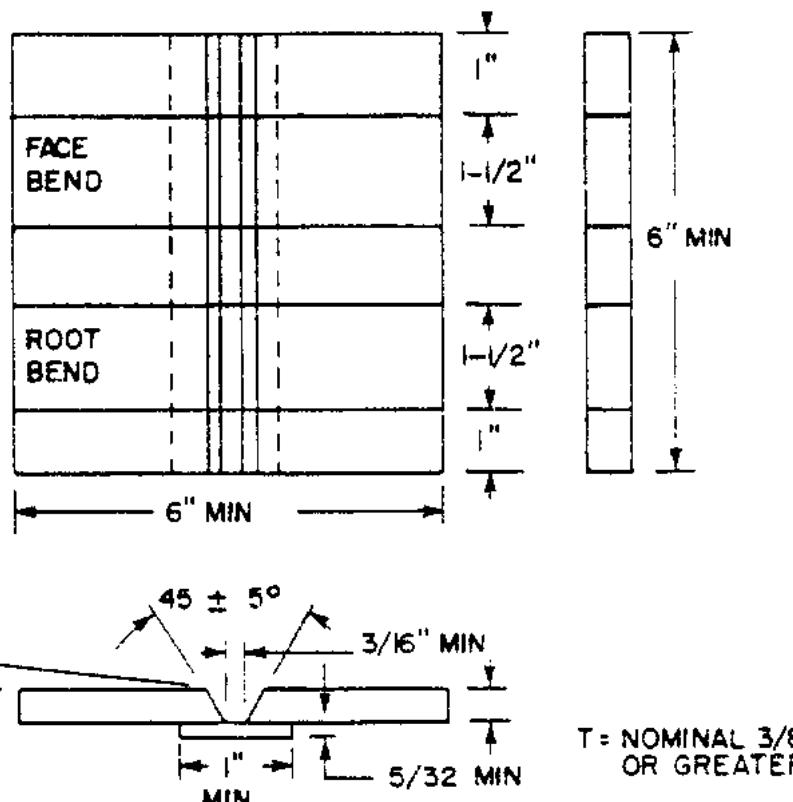
NOTES:

1. The joint design of an applicable, qualified welding procedure shall be employed.
2. Space restrictions may be omitted when welders are to weld piping without space restriction (see figure 21). This limitation shall be entered in the qualification records.
3. The weld shall be made with the maximum size welding rod suitable for the position and thickness of the test assembly.
4. Mark pipe to ensure correct location of specimens or orientation for radiography.
5. Weld reinforcement and backing ring, when used, may be removed prior to testing. Undercutting shall not be removed. When nondestructive testing is not employed for qualification evaluation, bend testing shall be conducted as follows:
  - (a) Horizontal-fixed position pipe.
    - (1) Face bends from the 45 degree and 225 degree positions (see figure 21).
    - (2) Root bends from the 135 degree and 315 degree positions (see figure 21).
  - (b) Vertical-fixed position pipe.
    - (1) Face bend from the 225 degree position (see figure 21).
    - (2) Root bend from the 135 degree position (see figure 21).
6. Minimum nominal wall thickness is used to indicate that the dimension is the minimum thickness based on the minimum pipe wall thickness allowed by the material specification. For example, 3/16 inch minimum nominal wall thickness would allow the use of any pipe wall considered 3/16 inch nominal even if the actual measured thickness was less than 0.187 inch, but in considering the 2T maximum of the qualified thickness range, the welder would be qualified to 3/8 inch nominal pipe wall.

FIGURE 13. Performance qualification test no. 3B for fuel gas welding (pipe).

Welding (Pipe).]

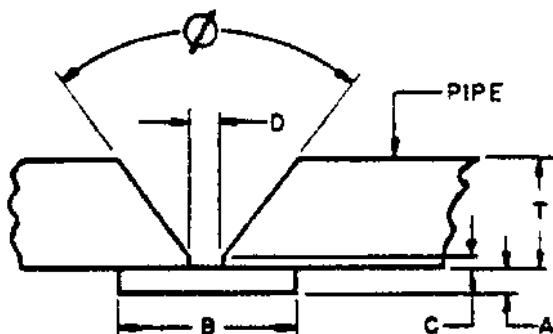
111



NOTES:

1. Weld shall be made with a maximum size electrode or filler material rod suitable for position of test plate.
2. Plates shall not be more than 5 degrees out of parallel after welding.
3. Weld reinforcement and backing strip may be removed flush prior to destructive testing. Undercutting shall not be removed. No repair welding shall be permitted on the backing strip side.
4. Two guided-bend test specimens shall be removed from the test plate if nondestructive testing is not employed.
5. In lieu of the joint design shown above, any applicable joint design from MIL-STD-22 or from an approved procedure may be employed. If this is done, the test shall be recorded as test no. 1. The welder shall be considered qualified to the extent specified for the standard test no. 1 joint.
6. Performance qualification for smaller thicknesses may be accomplished by using test plates less than 3/8 inch nominal thickness. In this case the qualified thickness range shall be T to 2T where T is test plate thickness. The joint design of an applicable approved welding procedure shall be used and shall be noted on the welder qualification record. All testing shall be in accordance with this figure, 5.3 and 5.4. The welder shall be considered qualified to the extent specified for the standard test no. 1 joint except for the thickness limitations. The test may be designated as test no. 1A.
7. The bevel angle may be shifted from the vertical centerline of the joint plus or minus 22-1/2 degrees.

FIGURE 14. Performance qualification test no. 1 for arc welding.



SH 13203122

TEST	$\theta$	A	B	C	D	T (min)
3	$75 \pm 5'$	Note 7	Note 7	0 to $1/16$ max	$5/16$	$3/16$ min (nom wall thickness)
4	$75 \pm 5'$	Note 7	Note 7	0 to $1/16$ max	$5/16$	$3/8$ min (nom wall thickness)

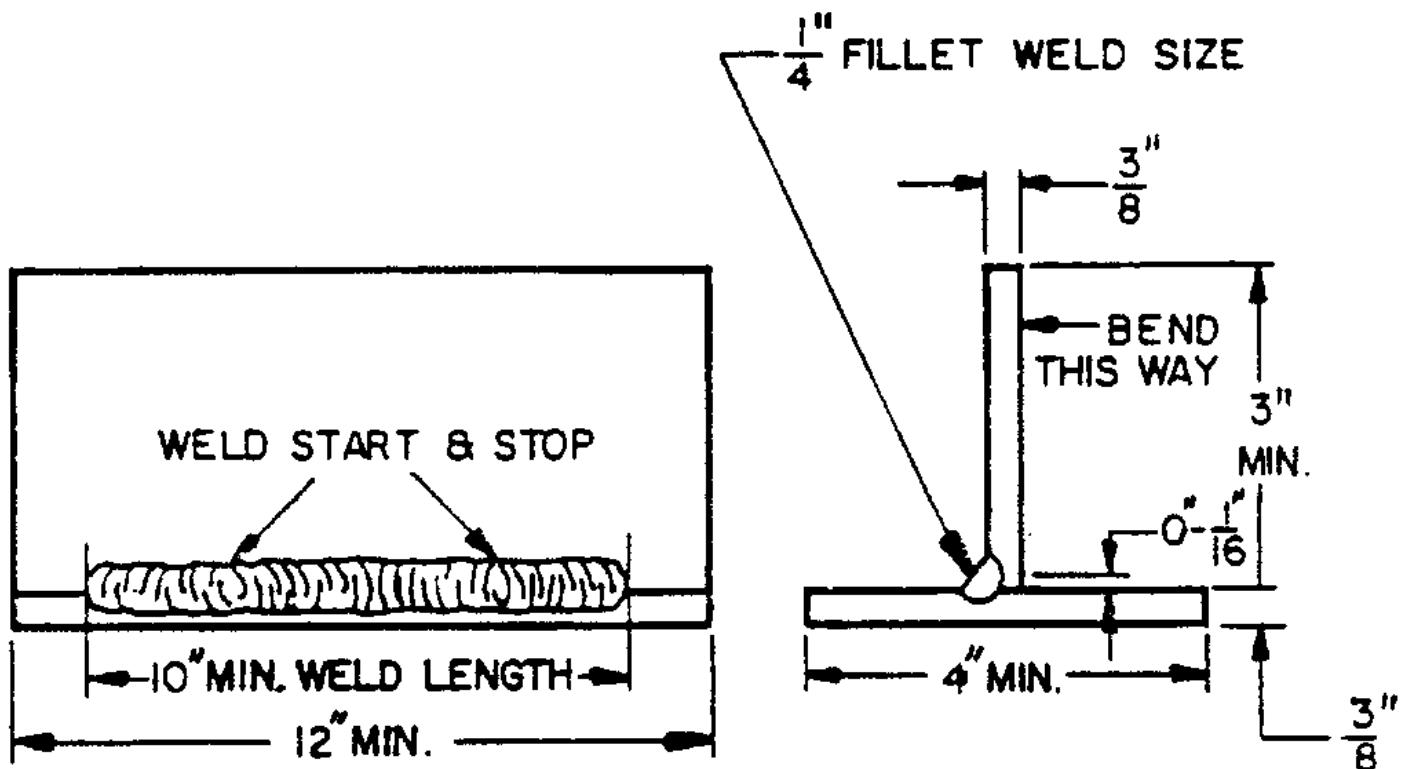
NOTES:

1. In lieu of the joint design shown above, any applicable joint design from MIL-STD-22 or from an approved welding procedure may be employed. If this is done, the test shall still be recorded as test nos. 3 and 4. The welder shall be considered qualified to the extent specified for the standard test nos. 3 and 4 joint.
2. Space restrictions may be omitted when welders are to weld piping without space restrictions (see figure 21). This limitation shall be entered in the qualification records.
3. The weld shall be made with the maximum size electrode or welding rod suitable for the position and thickness of the test assembly.
4. Mark pipe to ensure correct location of specimens or orientation for radiography.
5. Weld reinforcement and backing ring may be removed flush prior to testing. Undercutting shall not be removed. When nondestructive testing is not employed for qualification evaluation, bend testing shall be conducted as follows:
  - (a) Horizontal-fixed position pipe.
    - (1) Face bend from the 45 degree and 225 degree positions (see figure 21).
    - (2) Root bends from the 135 degree and 315 degree positions (see figure 21).
  - (b) Vertical-fixed position pipe.
    - (1) Face bend from the 225 degree position (see figure 21).
    - (2) Root bend from the 135 degree position (see figure 21).
6. Minimum (nominal wall thickness) is used to indicate that the dimension is a minimum thickness based on the minimum pipe wall thickness allowed by the material specification. For example,  $3/16$  inch minimum (nominal wall thickness) would allow the use of any pipe wall considered  $3/16$  inch nominal even if the actual measured thickness was less than  $0.187$  inch, but in considering the  $2T$  maximum of the qualified thickness range, the welder would be qualified to  $3/8$  inch nominal pipe wall.
7. Backing ring dimensions shall be in accordance with MIL-STD-22.

FIGURE 15. Performance qualification tests nos. 3 and 4 for arc welding (pipe).

Welding (Pipe).]

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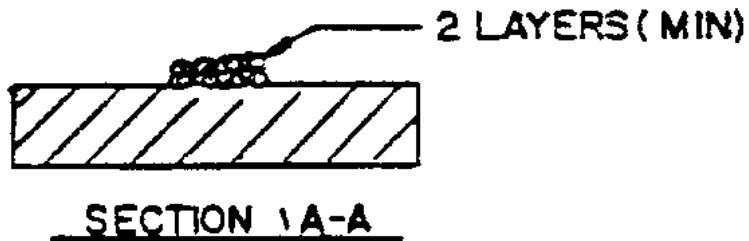
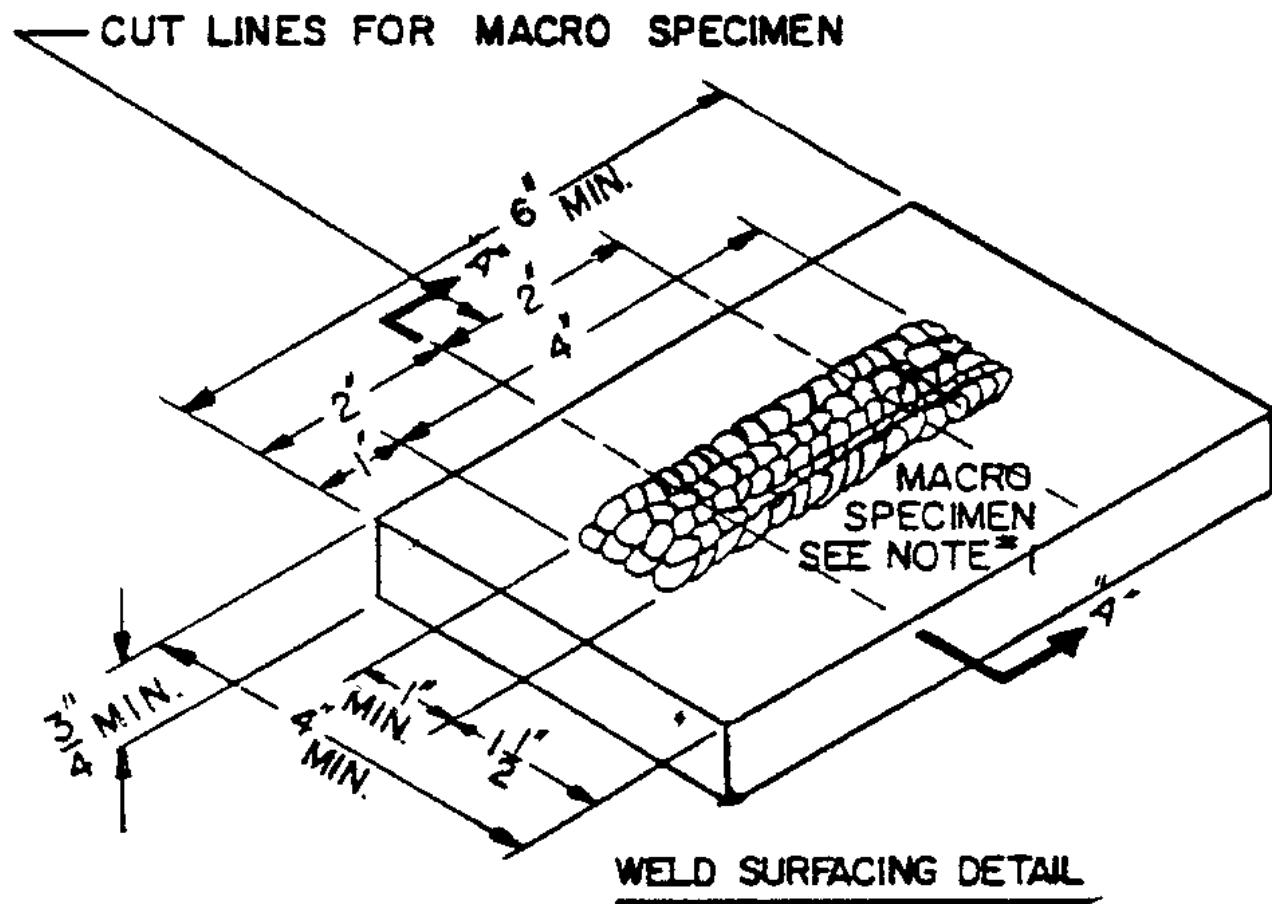
SH 9326

NOTES:

1. Weld shall be made with a maximum size of filler wire suitable for the position of the test plate.
2. Weld size specified is for single pass weld only.
3. At least one start and stop shall be included within the weld length.
4. Any base metal may be used which is weldable with the electrode to be employed in the test.

FIGURE 16. Performance qualification test no. 8 for tack welders.

Welders.]



SH 9327

NOTES:

1. Etch both faces of macro specimen.
2. Welds shall be made with the maximum size of filler metal suitable for the position of the test plate.

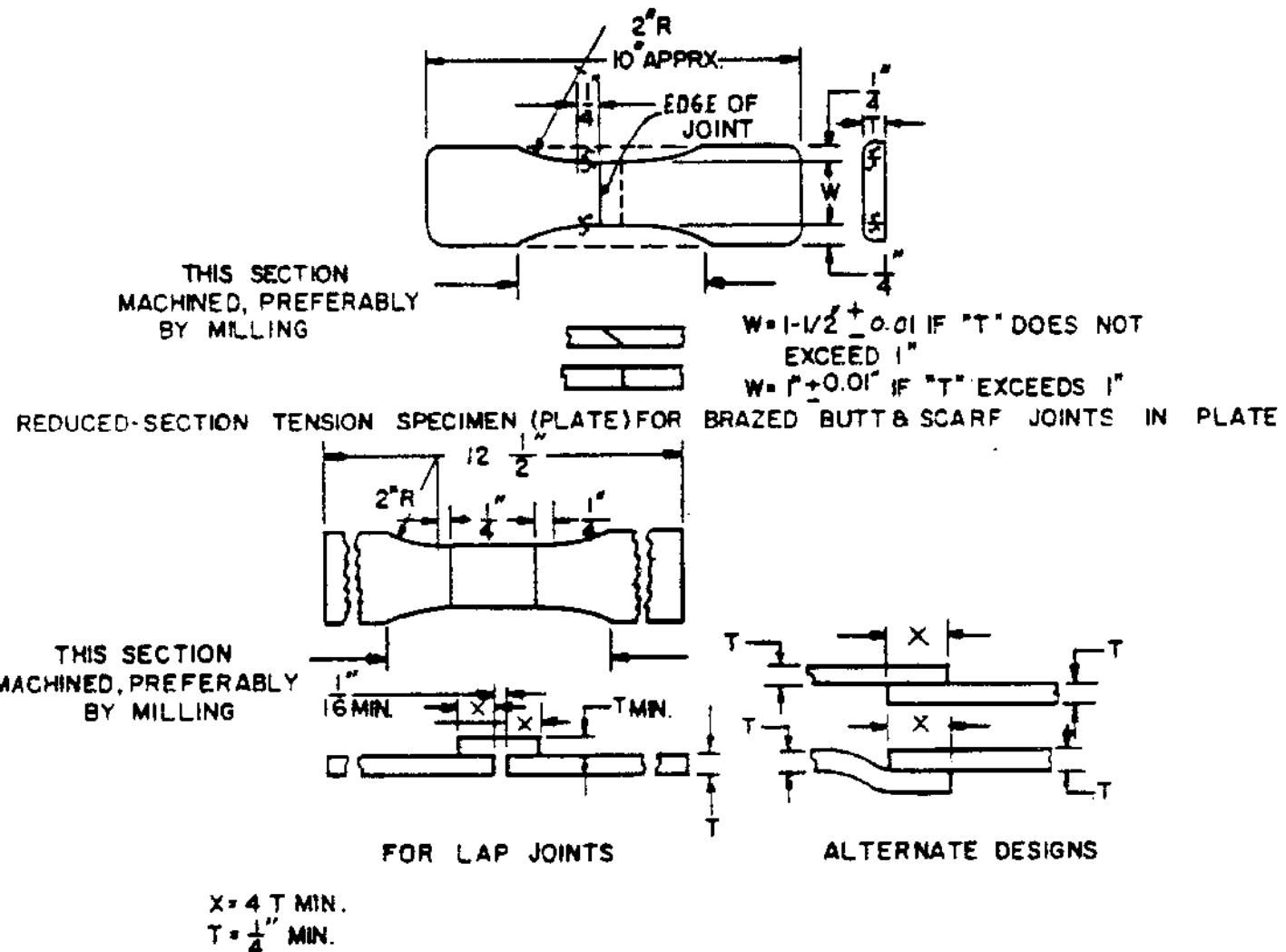
FIGURE 17. Performance qualification test no. 3 for weld surfacing.

*Surfacing.]*

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<b>TEST REQUEST</b>		Date of request
Welder or welding operator (name, clock no. or social security no.)		Vision test date: Corrective aids:
Performance qualification test no.	Welding process	
Position-plate	Base material type	
Vertical-up	Overhead	
Vertical-down	Horizontal	
Position-pipe	Flat	
Vertical-fixed	6G	
Horizontal-fixed	Restricted accessibility	
Rolled		
Filler metal type and size		
Date of test		
<b>PERFORMANCE QUALIFICATION TEST RESULTS</b>		
Qualified                      Not Qualified		
(X)	RESULTS - Satisfactory, unsatisfactory or not applicable	
	Visual examination	Dye penetrant test
	Physical	Magnetic-particle test
	Radiographic test	Ultrasonic test
	Macro exam of weld nugget	Other (describe under remarks)
Remarks (explanation of unsatisfactory)		
Fabricator certifying signature	Date	

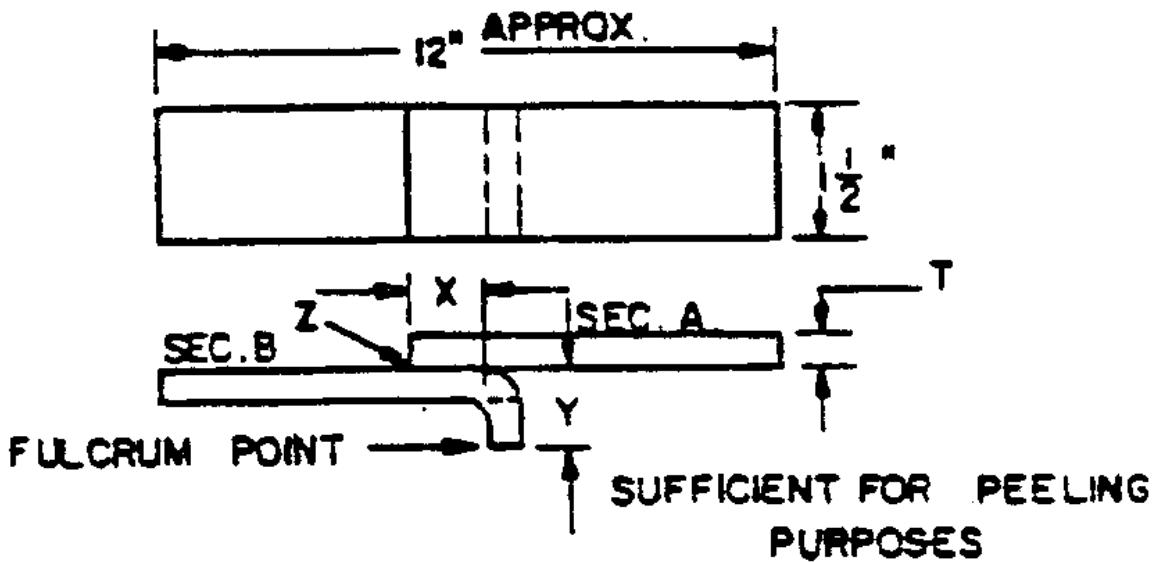
FIGURE 18. Sample performance qualification record.



SH 9329

FIGURE 19. Reduced section tension specimen (plate) for brazed lap-type joints.

Lap-Type Joints.]



### LAP JOINT PEEL SPECIMEN

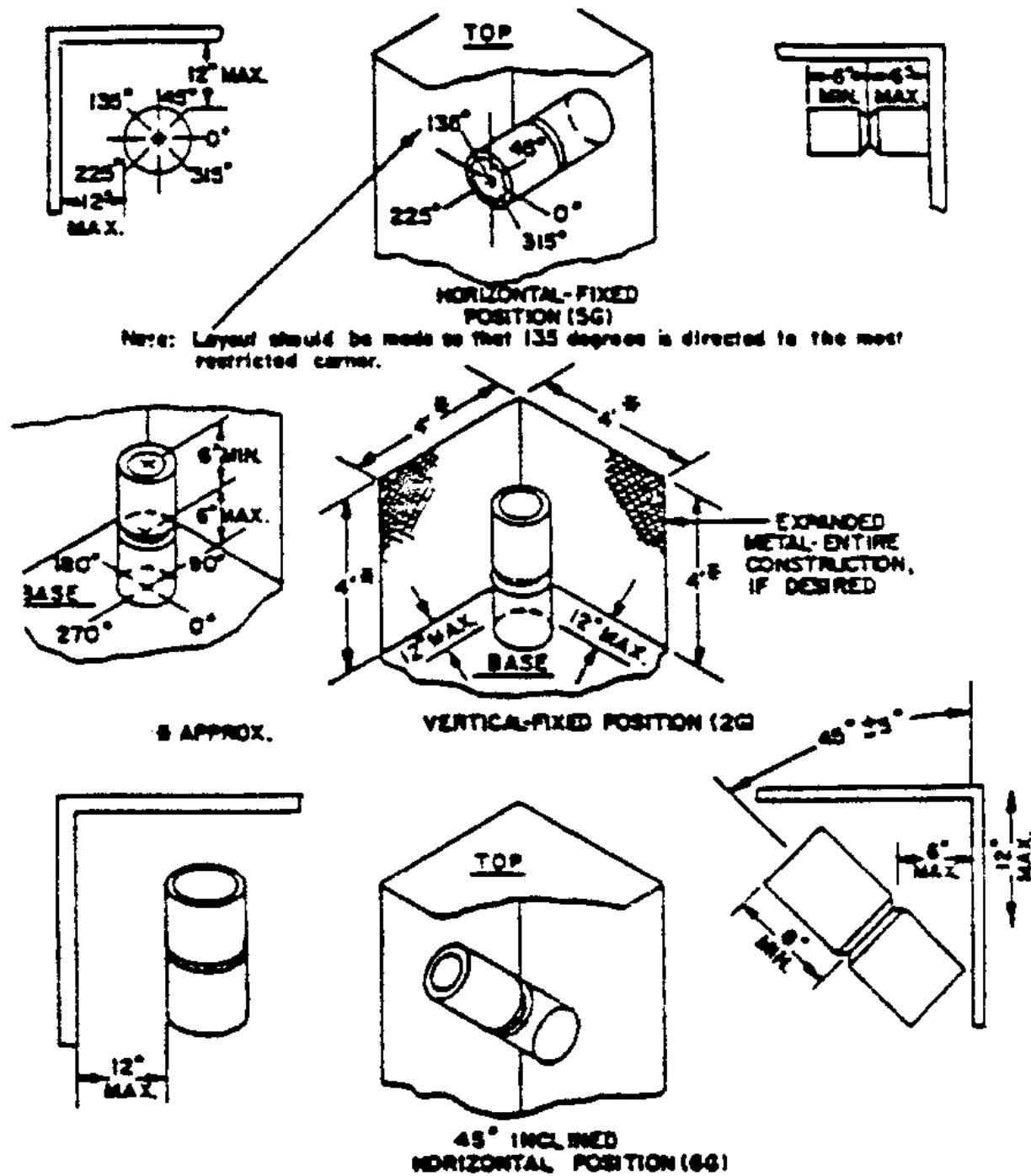
SH 9330

#### NOTES:

1. Flange Y may be omitted from section B when "peeling" is to be accomplished in a suitable tension machine.
2. Specimen shall be brazed from side marked Z.

X = 4T minimum or as required by design

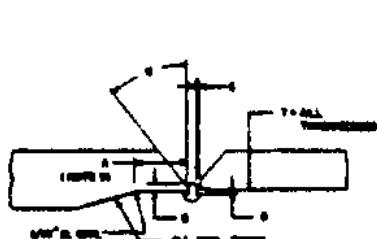
FIGURE 20. Lap joint peel specimen.



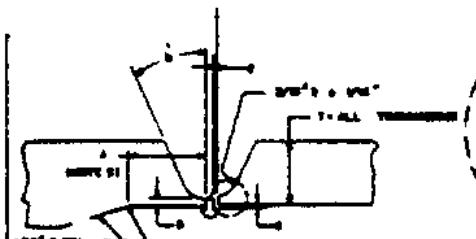
SH 13203127

FIGURE 21. Typical layout and construction for restricted accessibility qualification test assembly positions.

Accessibility Qualification Test Assembly Positions.]



TEST NO. 5



TEST NO. 6

SH 13203128

Test no.	Dim "B" 1 inch nps and below see note 9	Dim "B" above 1 inch nps see note 9	Dim "C" clearance	Dim "D" diff in dia.	$\theta$ see note 8 and 10
5	$0.010 \pm 0.005$	$0.030 \pm 0.005$	0.031 max	0.031 max	$40 \pm 5$
6	$0.010 \pm 0.003$	$0.030 \pm 0.005$	0.031 max	0.031 max	$25 \pm 3$

NOTES:

1. The maximum difference in inside of diameter of the pipes to be joined shall be 0.001 inch.
2. Welds shall be made with the maximum size electrode or welding rod for the position and pipe wall thickness.
3. Radiographic inspection shall be performed for qualification evaluation. Pipe should be marked to ensure correct orientation for radiography.
4. If consumable inserts of different shapes than shown here are to be used in production, qualification is required for each shape of insert to be used. Joint geometry and fit-up tolerance shall be as developed during procedure and qualification.
5. In lieu of the joint design shown above, any applicable joint design from MIL-STD-22 or from an approved procedure may be employed. If this is done, the test shall still be recorded as test nos. 5 and 6. The welder shall be considered qualified to the extent specified for the standard test nos. 5 and 6 joint.
6. Space restrictions may be omitted when welders are to weld piping without space restrictions (see figure 21). This limitation shall be entered in the qualification records.
7. Minimum (nominal wall thickness) is used to indicate that the dimension is the minimum thickness based on the minimum pipe wall thickness allowed by material specification. For example, 3/16 inch minimum (nominal wall thickness) would allow the use of any pipe wall considered 3/16 inch nominal even if the actual measured thickness was less than 0.187 inch, but in considering the 2T maximum of the qualified thickness range, the welder would be qualified to 3/8 inch nominal pipe wall.
8. For joints of nickel-copper materials dimension " $\theta$ " may be changed to  $47\frac{1}{2} \pm 2\frac{1}{2}$  degrees for test no. 5.
9. For joints of nickel-copper (S-42) and nickel-chromium-iron (S-43) materials dimensions "B" may be changed to  $1\frac{1}{16} \pm 1\frac{1}{64}$  inch for test no. 6.
10. For pipe to be welded in the vertical axis position,  $\theta$  on the low side of the joint may be as follows, provided the total included angle is two times the angle  $\theta$  specified in the table:
  - (a)  $30 \pm 3$  degrees for test no. 5.
  - (b)  $8 \pm 3$  degrees for test no. 6.

FIGURE 22. Performance qualification tests nos. 5 and 6 for arc welding (pipe).

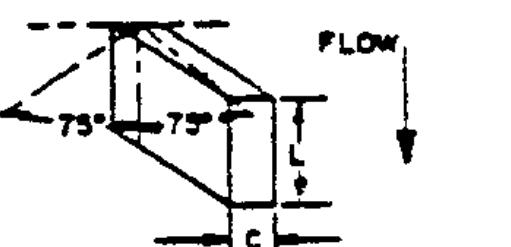
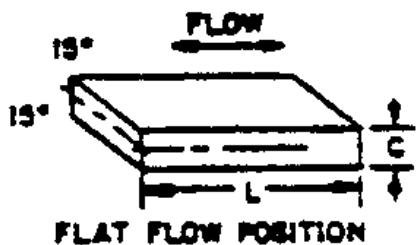
Welding (Pipe).]

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FLOW OF ALLOY THRU JOINT

C = JOINT CLEARANCE (THICKNESS)  
L = LENGTH OF LAP OR THICKNESS

TYPICAL BRAZED JOINTS  
SHOWING FLOW OF ALLOY



VERTICAL-DOWN FLOW POSITION



VERTICAL-UP FLOW POSITION



HORIZONTAL FLOW POSITION

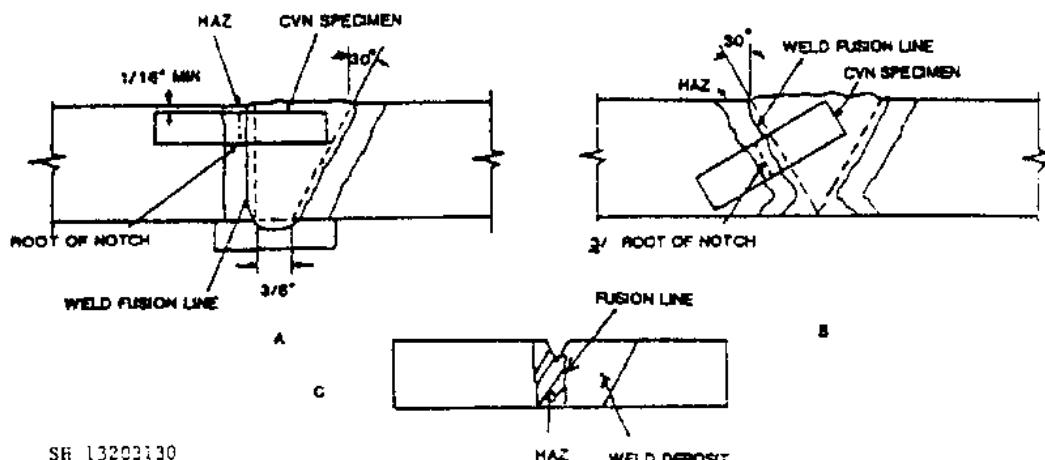


SH 13203129

FIGURE 23. Brazing positions.

FIGURE 23. Brazing positions.



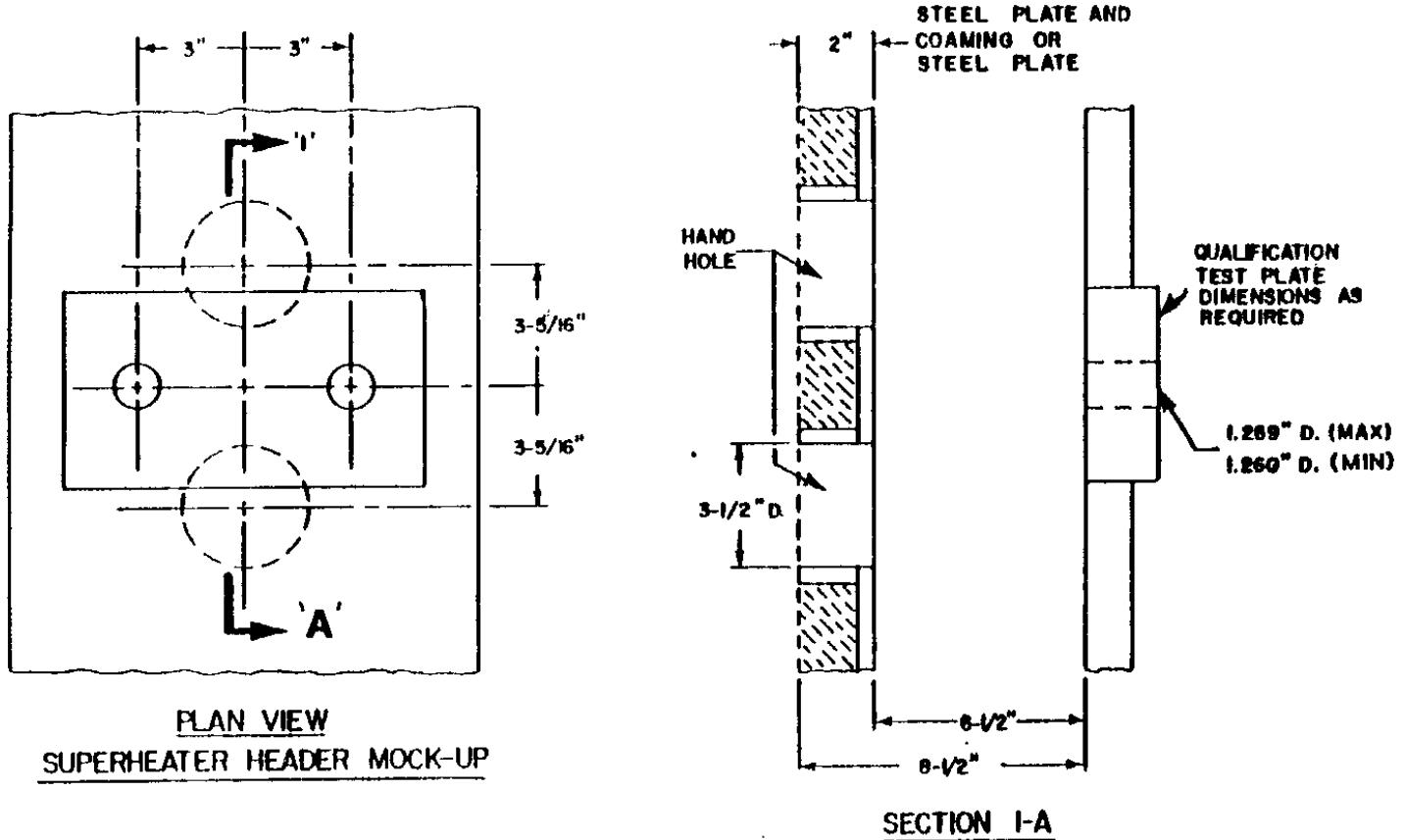


SH 13203:30

NOTES:

1. If the qualification test material is in the form of a plate or a forging, the axis of the weld shall be oriented in the direction parallel to the principal direction of rolling or forging.
2. The specimens shall be removed from a location as near as practical to a depth midway between the surface and center thickness with the closest surface of the specimen being at least 1/16 inch from the surface of the base material (see sketch A). The coupons for heat affected zone impact specimens shall be taken transverse to the axis of the weld and polished and etched to define the heat affected zone prior to machining the notch. The notch of the Charpy V-notch specimen shall then be cut approximately normal to the material surface. Unless inclined specimens are used as permitted below, a straight wall joint design similar to that shown in A shall be used for obtaining HAZ specimens. Where material thickness permits, the axis of a specimen shall be inclined to allow the root of the notch to align parallel to the fusion line as shown in B. Material at least 1-1/2 inches thick is required for a single side, 30 degree bevel weld joint.
3. Locate root of notch 0.5 to 1.5 millimeters from fusion line in the HAZ in a manner to include as much HAZ as possible in the fracture path.
4. For the comparison of heat affected zone values with base material values, Charpy V-notch specimens shall be removed from the unaffected base material at approximately the same distance from the base material surface as the heat affected zone specimens. The axis of the unaffected base material specimens shall be parallel to the axis of the heat affected zone specimens, and the axis of the notch shall be normal to the surface of the base material.
5. Testing and acceptance criteria shall be in accordance with 4.5.
6. Before testing, take photomacrographs of the side view of all CVN-HAZ specimens showing the root of the notch and the etched HAZ below the notch (see figure C). Before testing, measure the distance of the root of the notch from the fusion line and record this distance using the location reference above, along with the energy required to break the specimen. Submit these along with other qualification test data for approval.
7. CVN specimens shall be machined to dimensions and tolerances specified in ASTM A 370, figure 11, type A specimen.

FIGURE 24. Heat affected zone (HAZ) Charpy notch location.



SH 13203132

NOTE: Orientation of assembly shall be as required for the welding position specified in the welding procedure. Orientation shown is for welding in vertical headers (refer to note 8).

FIGURE 25. Mockup and orientation of assembly for procedure and performance qualification for manual welding of tube-to-header joint welds.

NOTES:

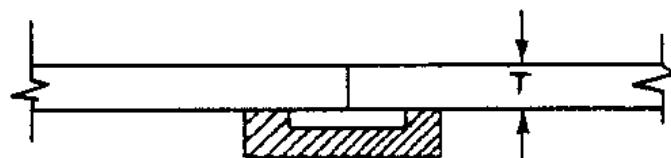
- 1 Header mock-up shall be fabricated from steel with top, bottom and all sides closed except as necessary for electrical lighting. Either pipe or plate may be used (plate shown) and thickness may be selected as necessary to achieve specified space restrictions except material thickness shall be 3/16 inch nominal, minimum. Mock-up shall be at least 18 inches wide and 30 inches long with hand holes approximately centered.
2. Header mock-up should be constructed so as to permit easy removal of test plate for nondestructive test inspection. Test plate shall be rigidly affixed in mock-up so that all welding and grinding is completed in place.
3. Insulation of hot surfaces shall simulate conditions welder will experience in production. Inside surfaces of mock-up shall not be insulated.
4. Hand hole diameter and all other dimensions are without insulation.
5. Babcock and Wilcox superheater headers provided by NAVSEA for welder qualification may be considered to meet these space restriction requirements for qualification of welding in the vertical position (that is, the tube in the horizontal-fixed position) only.
6. Except where minimum or maximum dimensions are shown, dimensional tolerances shall be plus or minus 1/16 inch.
7. More severe space restrictions than shown may be used if approved.
8. To meet the requirements of 5.3.6 for four joints either of the following may be performed:
  - (a) Under the conditions shown, the test assembly may be welded in two parts, that is, two joints followed by another two joints; or
  - (b) Additional hand holes may be added as necessary to permit welding of all four joints at once.

In any event, the space restrictions and orientation shown shall be met for all joints and two "A" joints and two "B" joints shall be completed. Additionally, for the particular stage of welding (that is, root or final) inspection/testing shall be performed on all four joints at once (that is, welding and inspection of two joints followed by welding and inspecting another two is not permissible).

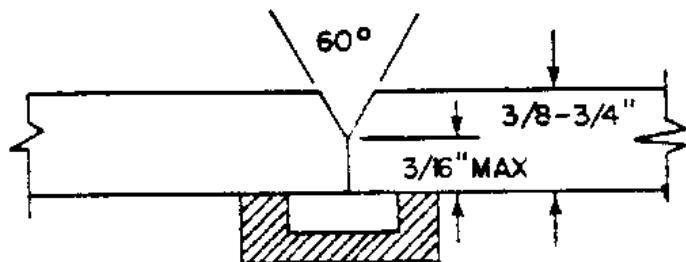
9. The orientation set by designation of "TOP" is for welding with the header mock-up positioned vertically, that is, the tube is in the horizontal fixed position.

FIGURE 25. Mockup and orientation of assembly for procedure and performance qualification for manual welding of tube-to-header joint welds. - Continued

	MANUAL	MECHANIZED
T	1/8" MAX	1/4" MAX



A. Weld joint for manual or mechanized weld



SH 13203133

B. Weld joint for mechanized weld 1/

1/ Root pass made using keyhole technique, with no added filler metal. Remainder of weld made using melt-in technique with filler wire added or using another welding process.

FIGURE 26. Performance qualification test no. 10, plasma-arc welding - keyhole technique.

APPENDIX

DATA REQUIREMENTS

10. DATA

10.1 Data requirements. When this standard is used in an acquisition which incorporates a DD Form 1423, Contract Data Requirements List (CDRL), the data requirements identified below shall be developed as specified by an approved Data Item Description (DD Form 1664) and delivered in accordance with the approved CDRL incorporated into the contract. When the provisions of DoD FAR Supplement, Part 27, Sub-Part 27.475-1 (DD Form 1423) are invoked and the DD Form 1423 is not used, the data specified below shall be delivered by the contractor in accordance with the contract or purchase order requirements. Deliverable data required by this standard are cited in the following paragraphs.

Paragraph no.	Data requirement title	Applicable DID no.	Option
4.2.3, 6.3.3	Certification/data report	UDI-A-23264	----

(Data item descriptions related to this standard, and identified in section 6 will be approved and listed as such in DoD 5010.12-L, AMSDL. Copies of data item descriptions required by the contractors in connection with specific acquisition functions should be obtained from the Naval Publications and Forms Center or as directed by the contracting officer.)

10.1.1 The data requirements of 10.1 may be waived by the contracting/ acquisition activity upon certification by the offeror that identical data were submitted by the offeror and accepted by the Government under a previous contract. This does not apply to specific data which may be required for each contract regardless of whether an identical item has been supplied previously.