Welding/Hot Work - Work Completion Job Site Inspection Attributes

Welding Shop Supervisor or Work Leader shall:

- Certify that work performed meets the workmanship and/or visual inspection criteria of NNSY P9505-6 (TP 601, latest revision) using Normal Supervisory Controls (NSC).
- Ensure that NSCs require that the supervisor/work leader has assigned qualified personnel to do the task, the qualified personnel reported the task complete, and that the workmanship and/or VT inspections required by the TWD have been accomplished satisfactorily. The individual making the NSC signature does not have to have performed the work or be formally qualified in workmanship or VT inspection programs.

General Weld Visual Inspection:

The welding shop supervisor or work leader shall certify that work performed meets the workmanship and/or visual inspection criteria. The welding shop supervisor or work leader shall personally inspect the job site prior to certifying the work is complete using the attributes below as a guide:

☐ _____ Slag, porosity, spatter, and undercut shall not be present in finished weldments as specified in TP 601

☐ _____ All welds shall be the correct size and contour (if applicable)

☐ _____ Completed welds and 1/2 inch of adjacent base material shall comply with the inspection requirements of TP 601

☐ _____ Tack welds shall be made using approved filler materials and shall be deposited with the requirements of P9100-1

☐ _____ Arc strikes will be removed and when in excess of 1/32-inch depth shall be repaired per requirements listed in TP 601

☐ _____ All arc strikes, including discoloration that occur after final heat treatment in OSS/HSS with certain alloy contents shall have removal of the heat affected zone verified as required by TP 601

☐ _____ Removal sites of welds and welded attachments shall be ground flush

☐ _____ Austenitic or nonferrous weld attachments sites on pressure hulls shall be verified with an enchant to ensure all material is removed as specified in TP 601

WJHR Completeness:

☐ _____ Review any/all WJHR sheets for accuracy and completeness to ensure all data entered is correct and appropriate signatures made

NDTs:

☐ _____ Ensure all required weld NDTs have been satisfactorily completed and documented

Hot Work Site Restoration :

☐ _____ Check the entire area for any damage caused by the hot work operation

☐ _____ Remove all temporary services required for the hot work operation

☐ _____ Ensure all materials used to protect ship's equipment have been removed and area cleaned of all trade debris