

QUALITY REMARK: PD

QUALITY REQUIREMENT NUMBER 168

A CERTIFIED ELECTRON BEAM WELD SCHEDULE ON FORM GT-7262, A 10X (MIN. MAGNIFICATION) PHOTOGRAPH OF A SECTION WELDED IN ACCORDANCE WITH THIS SCHEDULE AND THE SAMPLE OF THE DEVELOPED WELD ARE REQUIRED. THE SKETCH PORTION OF THE GT-7262 FORM AND PROCESS SHEETS MUST BE FILLED OUT SHOWING EXACTLY HOW THE COMPONENTS WILL BE ASSEMBLED AND WELDED. A GT-7262 IS REQUIRED FOR EACH JOINT. UPON RECEIPT OF THE APPROVED GT-7262, PARTS MAY BE WELDED. THE REQUIREMENTS SHOWN ON GT-7262 (BACKER) APPLY TO THIS ORDER.

X-RAYS AND TECHNIQUE CHARTS ARE REQUIRED FOR ALL E.B. WELDS (EXCEPT FOR GEARS WHERE ULTRASONICS ARE REQUIRED BY DRAWING AND CLASS "C" WELDS) ON THE FIRST PART AND MUST BE EVALUATED, EVEN THOUGH RADIOGRAPHIC INSPECTION IS NOT A DRAWING REQUIREMENT. THE RADIOGRAPHIC QUALITY PLAN FOR ALL E.B. WELD JOINTS (REQUIRED BY DRAWING AND NOT REQUIRED BY DRAWING) SHALL INCLUDE:

1. RADIOGRAPHIC QUALITY PLAN ON FORM GT 4024.
2. SAMPLE X-RAY FILMS OF THE JOINT "TACK WELDED ONLY" SHOWING THE NON-FUSED JOINT AS A SHARP BLACK LINE, AS WELL AS THE JOINT AFTER E.B. WELDING.
3. FORM GT-7262 SHALL BE SENT TO X-RAY SOURCE AND MUST ACCOMPANY GT-4024 WHEN SUBMITTED.

PARTS WILL BE HELD PENDING APPROVAL OF THE PLAN.