

Standard

vision acuity of 20/40, or better. Vision examination of all inspection personnel is required every three years or less if necessary to demonstrate adequacy.

Prior to welding, inspection shall include the following:

- a. Review of welding drawings and welding procedure specifications.
- b. Assuring that welding materials and consumables are in accordance with specifications.
- c. Checking and identifying as-received materials against specifications.
- d. Checking storage of filler material.
- e. Checking welding equipment.
- f. Checking weld joint preparations.
- g. Checking for base metal discontinuities.
- h. Establishing a plan for the recording of results.

Visual inspection during welding by the weld operator shall include:

- a. Quality of weld root bead.
- b. Joint root preparation, such as slag removal, prior to welding the second side.
- c. Preheat and interpass temperatures.
- d. Sequence of weld passes.
- e. Subsequent layers for apparent weld quality.
- f. Cleaning between passes (use of a wire brush and chipping hammer to remove slag).
- g. Conformance with the applicable procedure, i.e., voltage, amperage, heat input, and/or speed.

The following items shall be inspected on at least 10% of all assemblies after welding to determine the quality of the welds:

- a. Geometric imperfections. The fillet weld faces shall be slightly convex, concave, or flat, as shown in Figure 6.2.3(a) A and B. Weld profiles exhibited in Figure 6.2.3(a) C are unacceptable. Figure 6.2.3(a) D and E

Commentary

testing (while very costly) is good, and ultrasonic testing is poor in detecting volumetric discontinuities, such as porosity. Ultrasonic testing is good for detecting planar discontinuities, such as incomplete sidewall fusion, while radiographic testing can miss such discontinuities unless oriented parallel or near parallel to the radiation direction.

Visual inspection for cracks in welds and base metal and other discontinuities should be aided by a strong light, magnifier, or other such devices, as may be found to be helpful.

Size, length, and contour of welds should be measured with suitable weld-size gauges. Groove welds should be measured for proper reinforcement on both sides of the joint. Quality control should compare the welds with three-dimensional "workmanship samples" available from AWS. These are actual welded samples, or plastic replicas of welded samples, that depict actual weld conditions.

Standard C 116 Manual

Chao Zhang



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The American Catalogue ,1911 American national trade bibliography **Ductile-iron Pipe and Fittings** American Water Works Association, 2003 Provides practical information about the design and installation of ductile iron pressure piping systems for water utilities The 12 chapters outlines the procedure for calculating pipe wall thickness and class and describes the types of joints fittings valves linings and corrosion protection a *Department Of Defense Index of Specifications and Standards Alphabetical Listing Part I September 2005* , *General Design Standards* United States. Bureau of Reclamation, 1992 **Publishers' Weekly** ,1898 **An Index of U.S. Voluntary Engineering Standards** United States. National Bureau of Standards, 1971 **The Publishers Weekly** ,1899

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