

Standard Operating Procedure <b>Brazing Performance Qualification</b>	SOP No. 7.008
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DCR No.: 11004  
Revision No.: 2

**Effective:** 3-06-12  
**Supersedes:** 7-25-97  
**Revision Date:** 7-12-11  
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- 1 Purpose
  - 1.1 To establish a standard procedure for the qualification of all Therma brazers.
- 2 Scope
  - 2.1 This procedure applies to all Therma brazers performing brazing procedures, as described in SOP 5.013.
- 3 Responsibility
  - 3.1 The Therma quality control manager (QCM) shall administer this procedure and verify that brazer on the job has satisfied the criteria herein.
  - 3.2 The Therma quality control Examiner (QCE) is responsible for ensuring brazer is performing tasks.
- 4 Reference
  - 4.1 ASME code section IX, part QB Brazing.
- 5 Procedures
  - 5.1 QCE shall review the customer's specification for brazer qualifications.
  - 5.2 QCE shall verify that the brazer is capable of following the brazing procedure in SOP 5.013.
  - 5.3 QCM shall verify that the brazer has satisfied the criteria and document finding on form FN 5.013.2 (Performance Qualification Record).
  - 5.4 QCM shall issue a certification to the brazer.

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## 6 Review and Approval

6.1 No approval is necessary.

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## Document Approval

  
 Process Systems Manager

3-6-12  
 Date

  
 Field Operation Manager

3-6-12  
 Date

  
 Engineering Manager

3/06/12  
 Date

  
 Quality Assurance Manager

3/6/12  
 Date

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