

Standard Operating Procedure Automatic GTAW Welder Qualification	SOP No. 7.009
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- 1 Purpose
 - 1.1 To establish a standard procedure for welder qualification executing gas tungsten arc welding (GTAW).
- 2 Scope
 - 2.1 This procedure applies to all welders performing GTAW welds, using AMI Model 107 & 207 GTAW orbital welding machines (or similar from other manufacturers).
- 3 Responsibility
 - 3.1 The Therma Quality Control Examiner (QCE) shall administer this procedure and verify that the welders on the job have satisfied the criteria herein.
 - 3.2 The Therma general foreman (GF) is responsible for ensuring certified welder is performing tasks.
- 4 Procedures
 - 4.1 Review the customer's specifications for welder qualifications and coordinate with the GF to perform a GTAW weld certification.
 - 4.2 Verify the welder is able to develop a weld program/schedule suitable for high purity piping systems and hook ups within one hour.
 - 4.3 Inspect weld for compliance as specified in SOP 7.005 (GTAW Weld Inspection). Document findings on Form FN 5.005.1 (Weld & Coupon Log).
 - 4.4 Document weld program/schedule on Form FN 5.024.2 for 107 orbital machines.
 - 4.5 Document weld program/schedule on Form FN 5.024.1 for 207 orbital machines.
 - 4.6 Qualify per written procedures in Form FN 5.005.2 (Weld Procedure Specification).

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4.7 Archive coupon.

4.8 Notify the GF of findings.

5 Review and Approval

5.1 The QCE shall witness the welding procedure, and certify the welding performance. The QCE will then inform the GF of the results.

5.2 When the welder passes the certification test, the GF shall submit the results to the general contractor (owner's representative).

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Document Approval

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3/06/12
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