

DEPARTMENT OF THE NAVY

OFFICER IN CHARGE OF CONSTRUCTION
RESIDENT OFFICER IN CHARGE OF CONSTRUCTION
NAVAL FACILITIES ENGINEERING COMMAND CONTRACTS
CAMP LEJEUNE, NORTH CAROLINA 28542

N62470-82-C-4669 JAX/W/JLD/se1 29 April 1985

AS-764 BoilER.

Northeast Construction Company
P. O. Box 548
Jacksonville, NC 28541-0548

Re: Contract N62470-82-C-4669, Upgrade BSQ's AS-702 and AS-704, MCAS(H),

New River, Jacksonville, NC

Gentlemen:

Your submittal number 9C is returned herein. Please provide this office with original signatures on these documents. This may be in the form of copied documents with original signatures for certification.

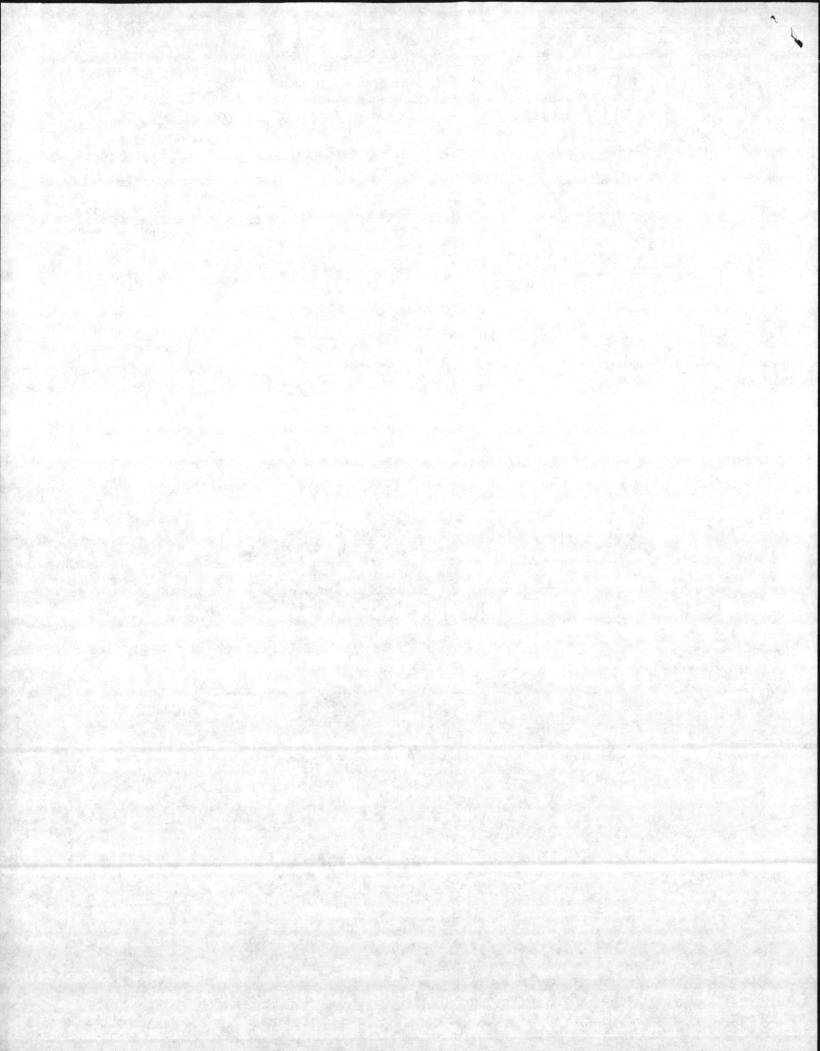
Sincerely yours,

J. L. DAVIS LT, CEC, USN

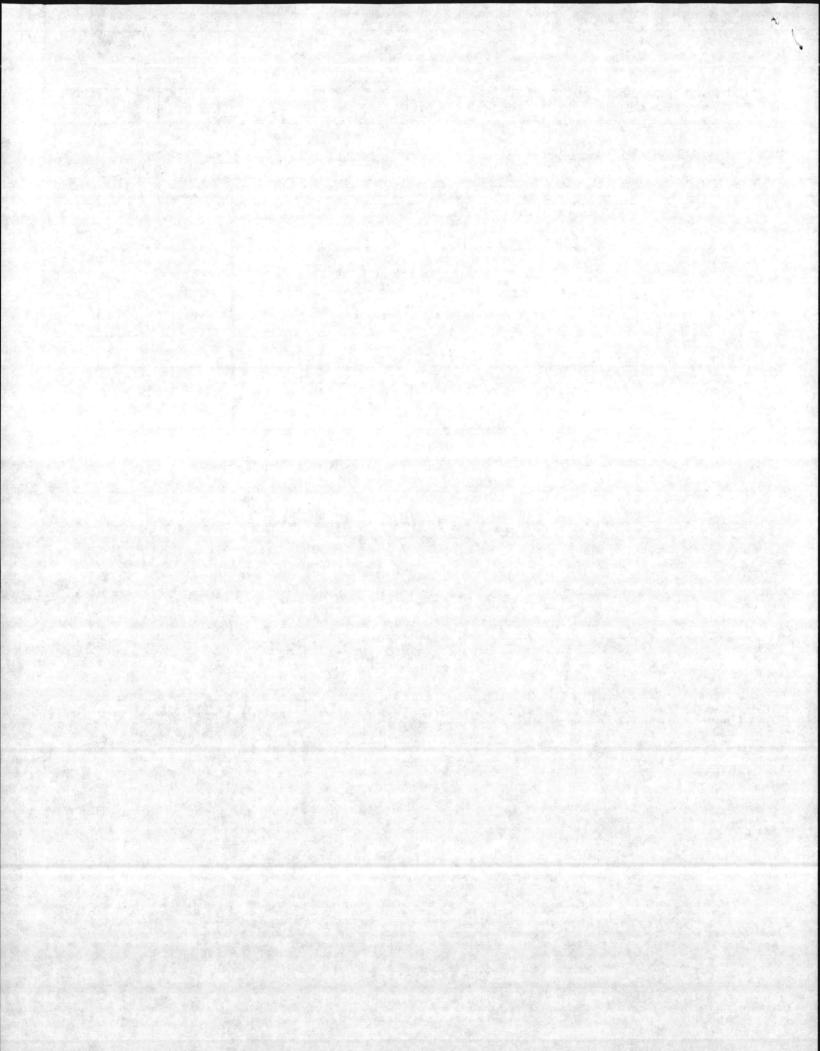
Resident Officer in Charge of Construction

Copy to:

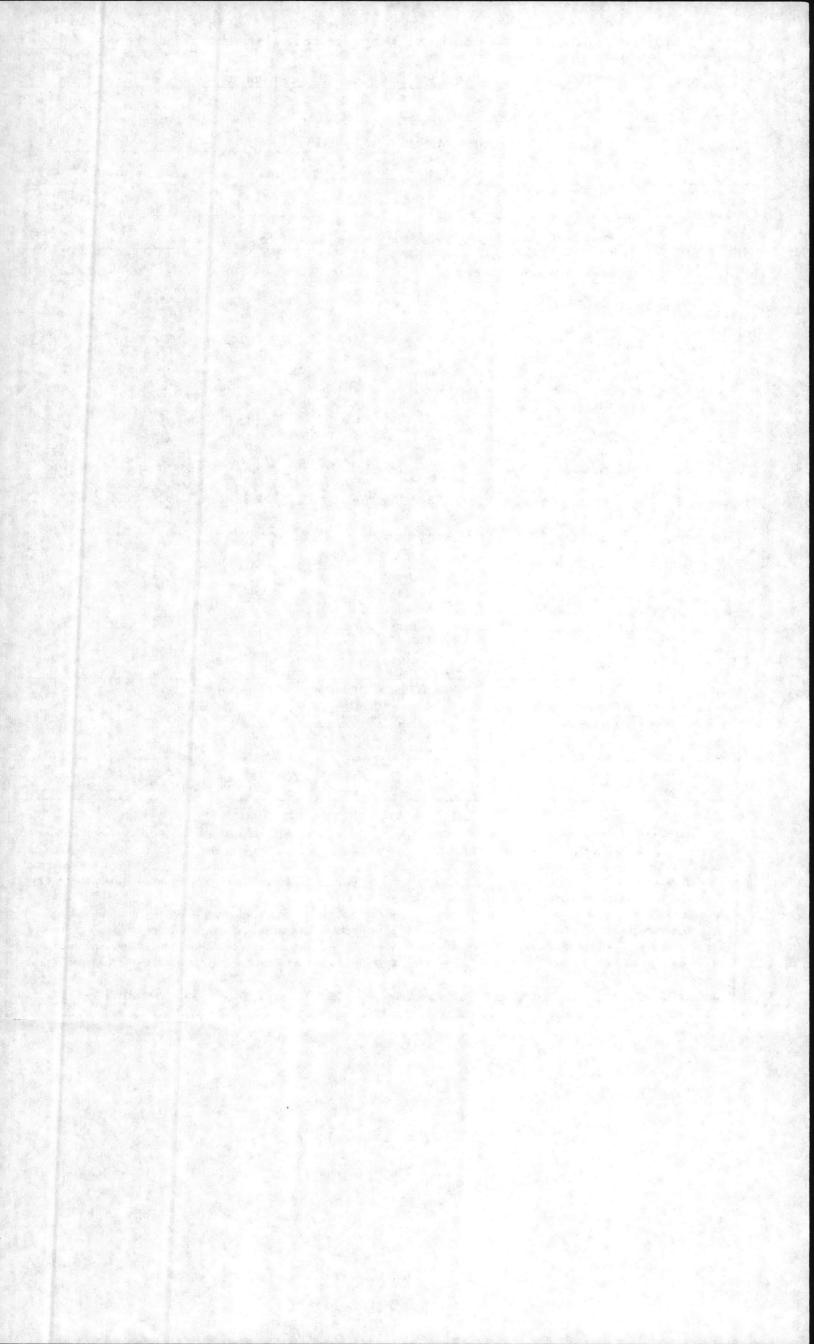
BMO (Attn: Mr. Tom Lanier)



CC	INTRACTOR'S SU	JBMITTAL TRANSMITTAL	CONTRACT NO	TRANSMI	TTAL NO	DATE
LAI	NTDIV NORFOLK 4-43	55/3 (Rev. 11-80)	N62470-82-C-4669	9	С	4/17/85
	M CONTRACTOR		PROJECT TITLE AND LOCATION		A A	
ro	Northeast Cons ROICC Bldg 1005, Ca	atruction Company amp Lejeune, NC 28542	Upgrade BSQ's A	S-702 River	and AS-	-704 onville, N.C.
-	, , , , , , , , , , , , , , , , , , ,	CONTRACTOR USE ONLY		72 - 12		WER USE ONLY
	L Contractor Approved	*List only one specification division ist only one of the following categories on ear and indicate which is being subm	ch transmittal form.	Carlo	A-Appro D-Disar AN-App	oproved proved as noted eipt acknowledged. ments
ITEM NO.	PROJ. SPEC. SECT. & PARA. and/or PROJ. DWG. NO.	ITEM IDENTIFI (Type, size, model no., N brochure nu	Alg. name, dwg. or	NO. OF COPIES	ACTION CODES	REVIEWER'S INITIALS CODE AND DATE
1	Section 1565 Para 2.16	Form R-1, Report of Weld	ded Repair to Boiler	4		
				194		
OP	Y OF TRANSMITTAL AND SUI	BMITTALS TO ROICC	CONTRACTOR REPRESENTATIVE (S	ignjude)	2	
			Lawrence Green,	Jr.,	Ni/ce P	resident
ATI	E RECEIVED BY REVIEWER	FROM (Reviewer)	to			
	tractor calls attention	d with action indicated. Approval of an item docto and supports the deviation.				
R	ES TO DICC (2) ANTDIV (1) E (1)	DATE	SIGNATURE			



	Inspection Code	Copy to Tents
Work done by A & M Company, Inc. P. O. Box 3147 Wi	Imington, NC	
Owner Burnham Corp. Lancaster, PA		MAR : 7 1985
Location of Installation Marine Corps Air Station - New River, NC		
Unit Identification Boiler Name of Manufacturer Burn	ham Corpi	للأسلأ فالاستاب
Boiler Pressure Vessell Identifying Nos 15660 15660 IMag: Serial No. (National Board No. (Jurisdii Lon)	B-1	1984
Description of Work Repair Leak in Fillet Weld from Water Jacket	to Base Plate	Year Bodti
1) Dress Weld suitable for Repair		
2) Repair Weld		
3) 11 UKOS ATIC TEST PLREDILMED B	y land	Y HEAT 16
PREMARKS Attached are Manufacturer's Partial Data Reports properly identified and significant		rot Appending 45 ps
items of this report	0	1 -0 . 10 1
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and Chuck Steed of Humphry Heat & Con Con	d. moual	4 mapsolis -
weld upon and famition hydrastat	in tool	x 45 PS1.
Charles Barrien		
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Name (partition of the control of th		
CERTIFICATE OF COMPLIANCE	Design	
CERTIFICATE OF COMPLIANCE We certify that the statements made in this report are correct and that all	Design	conformity
We certify that the statements made in this report are correct and that all material, construction, and workmanship on this Repair The National Board Inspection Code		conform to
CERTIFICATE OF COMPLIANCE We certify that the statements made in this report are correct and that all material, construction, and workmanship on this Repair The National Board Inspection Code Date 3/18/85 Signed A & M Company, Inc.		conform to
CERTIFICATE OF COMPLIANCE We certify that the statements made in this report are correct and that all material, construction, and workmanship on this Repair The National Board Inspection Code Date 3/18/85 Signed A & M Company, Inc. Physical Repair Alteration Organization in the part of the	Funda D. J.	Llist minimis talians
CERTIFICATE OF COMPLIANCE We certify that the statements made in this report are correct and that all material, construction, and workmanship on this Repair The National Board Inspection Code Date 3/16/85 Signed A & M Company, Inc. Page Alteration Organization Our Certificate of Authorization No R487 to use the R1R!!		Llist minimi taliens
CERTIFICATE OF COMPLIANCE We certify that the statements made in this report are correct and that all results material, construction, and workmanship on this Repair The National Board Inspection Code Date 3/16/85 Signed A & M Company, Inc. by Repair Alteration Originization Our Certificate of Authorization No R487 to use the R711	Symbol expires	Aug 17 19 87
CERTIFICATE OF COMPLIANCE We certify that the statements made in this report are correct and that all material, construction, and workmanship on this Repair The National Board Inspection Code Date 3/16/85 Signed A & M Company, Inc. by Repair Alteration Organization Our Certificate of Authorization No R487 to use the R487 CERTIFICATE OF INSPECTION I, the undersigned, holding a valid commission issued by The National Board of Boiler of	Symbol expires	Aug 17 19 87
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CERTIFICATE OF COMPLIANCE We certify that the statements made in this report are correct and that all material, construction, and workmanship on this Repair The National Board Inspection Code Date 3/78/85 Signed A & M Company, Inc. Repair Inc. Repair The National Board Inspection Code Date 3/78/85 Signed A & M Company, Inc. Repair Inc. Repair The National Board Inspection Dispersion of the National Board of Boiler of the Work described in this Data Report on 3/2/ 1985 and St.	Symbol expires and Pressure Vessel and employed by	Aug 17 19 87
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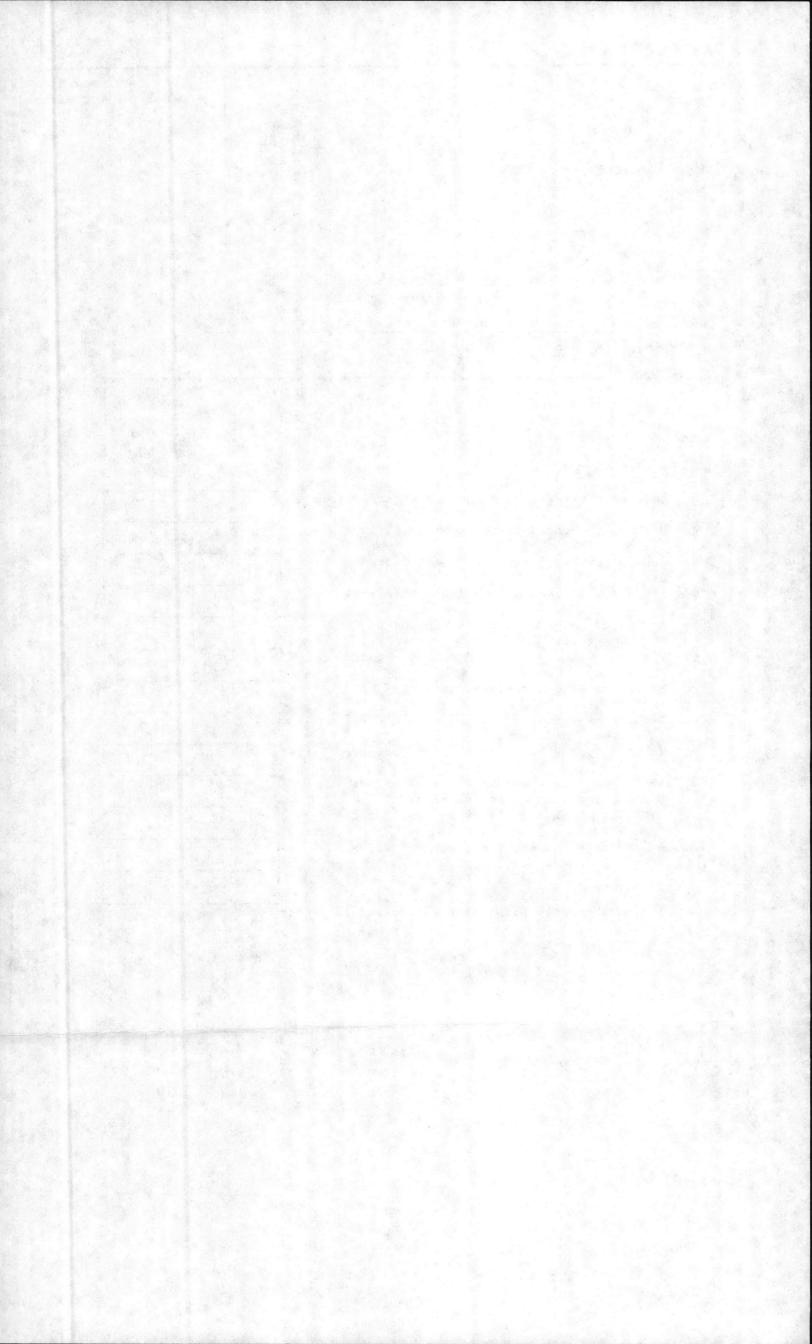


P. O. BOX 3147 WILMINGTON, N. C. 28406

PABRICATION CHECK LIST

"TRAVELER"

Job	Name: Burnham Corp. Boiler Wold Repa	ir B-	ı			
lop	Number: 47576 (NS# 15660)					
		PROJ. MGR	DATE	Q.C.M.	N.C.D.L. BOILER INSP.	A.I. HOLD
1.	Code material received and visual inspection					
2.	Mill test reports checked for compliance					
3.	Code material marked with identifiers					
4.	Materials stored in ASME segregated area					
5.	Review of job procedure with Authorized Inspector	İ				
6.	[2] [2] [2] [4] [4] [4] [4] [4] [4] [4] [4] [4] [4	- 1				12.16
7.	Proper welding materials and procedure followed W.P.S.# 2A	7	3/15	3/2		
8.	Visual inspection of all welds and N.D.E. requirements met	7.	1,:	7.		
9.	Witness hydrostatic test* Test Pressure 45	1bs . 7	1,4	to	0	
10.	ASME P-4A data forms or NB, repair form properly executed and signed	7	129	3,W	13	
11.		J.	1/20	Fiv	17	
12.	All records and forms properly filed					







A & M Company
P.O. Box 3147
Wilmington, N.C. 28406

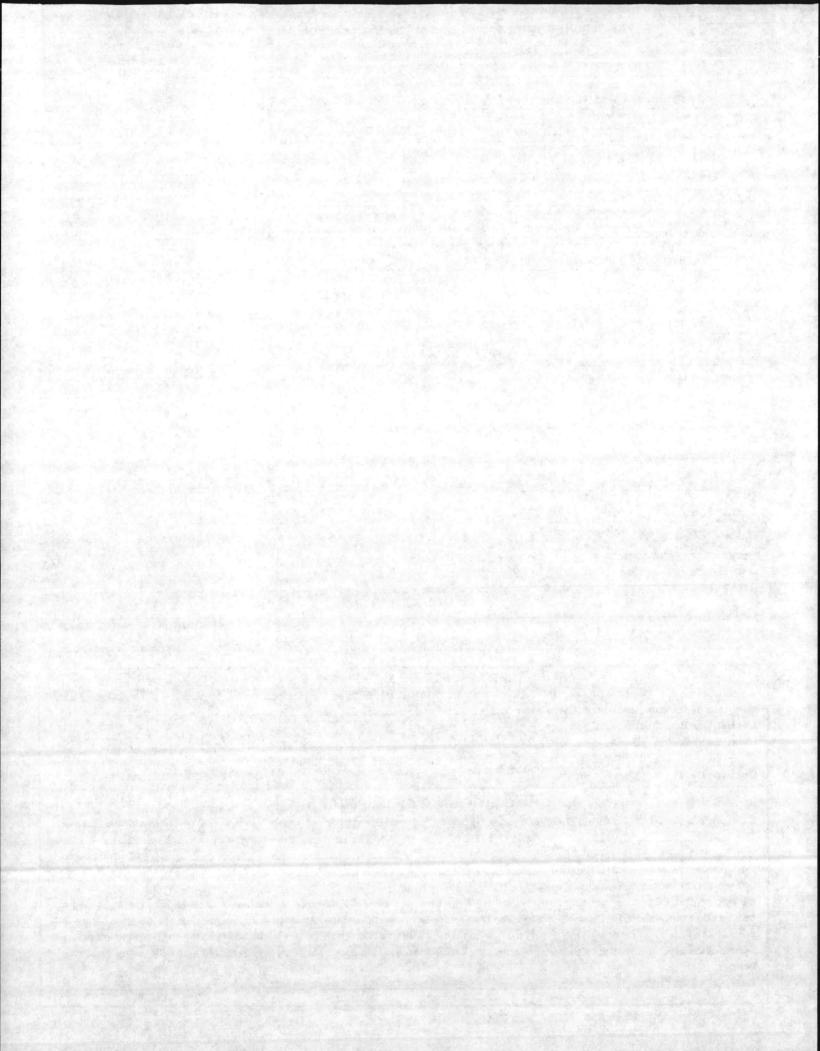
Frank G. Weiss

Office (919) 799-0510

24 HOUR PHONE (919) 799-0510

- Installation & Repairs of Boilers, Turbines, Generators, Pressure Piping • Procedure Welding
- Industrial Painting and Insulation
- Other Mechanical & Plant Maintenance Capabilities

	As Required				145-70
Work done by		oany, Inc. P. O.		/ilmington, NC 47	1576 #5 Bo
Downha		lame and address of repair or alteration o	organization)		(Serial No.)
	m Corp. Lanc	caster, PA			
ocation of Installati	V.1	Corps Air Station - Ne	w River, NC		
nit Identification	Boiler Pressu	Name of Mar	nufacturer Bur	nham Corp.	
dentifying Nos. 15	(Migr Serial No)	15660 (National Board No.)	(Jurisdiction)	B-1	1984 (Year Buill)
escription of Work		k in Fillet Weld from separate sheet or sketch if necessary:	Water Jacket	to Base Plate	
1) Dress	Weld suitable				
2) Repa	ir Weld				
3) 44	DR057A71	C TEST PERF	DRMED B	Y HomedRY	HEATING
				T. ZIOBILITINI	, ,,,,,,,,
FAIR	CONUW	ITNESSED BY A+M	EO. INC.	Pressure Test if A	plied 45
lemarks: Attached a items of th		Partial Data Reports properly	identified and sign	ed by Commissioned hisp	ectors for the follow
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Marile	1 Bays	rden:	yauru.	m sur a	45/5/.
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March	Says	rden		a sui a	43737.
Raule	Says Sleed	rden		a sui a	10/0/.
Marke	lease	rden		a sui a	40707.
Marile	Lays Says	rden		a sui a	4.5 / 5/ .
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Marile	lead	Name of part, terrosumber, migrs	sade and death ongsta		7.5 / 5/ .
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the undersigned, he work described in this Regional Board In 3/16/85 are 3/16/85 are Certificate of Automorphic March 18/16/85 the undersigned, he work described in this Region of the secribed in the secribe	h, and workmanship spection Code Signed A of A o	Name of part terminates interest of this report are correct and that a Repair on this Repair on this Repair of the separation of the separ	COMPLIANCE all idesigns Irepain alteral by I'R'I INSPECTION al Board of Boiler al al and stal than Code nakes any warranty employer shall be lines inspection, exce	Design June Desig	conform to A ative) 17 19 87 tors or the State or have inspected owledge and belief oncerning the work or personal injury or provided in a policy
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he National Board In All 1985 Our Certificate of Automotive the undersigned, he work described in his work has been doly signing this certificate of an all 1985.	h, and workmanship spection Code Signed A of A o	Name of part terminates interest of this report are correct and that a Repair on this Repair on this Repair of the separation of the separ	COMPLIANCE all idesigns Irepain alteral by I'R'I INSPECTION al Board of Boiler al al and stal than Code nakes any warranty employer shall be lines inspection, exce	Design June Desig	conform to A ative: 17 19 87 tors or the State or have inspected owledge and belief oncerning the work or personal injury or provided in a policy



P. O. BOX 3147 WILMINGTON, N. C. 28406

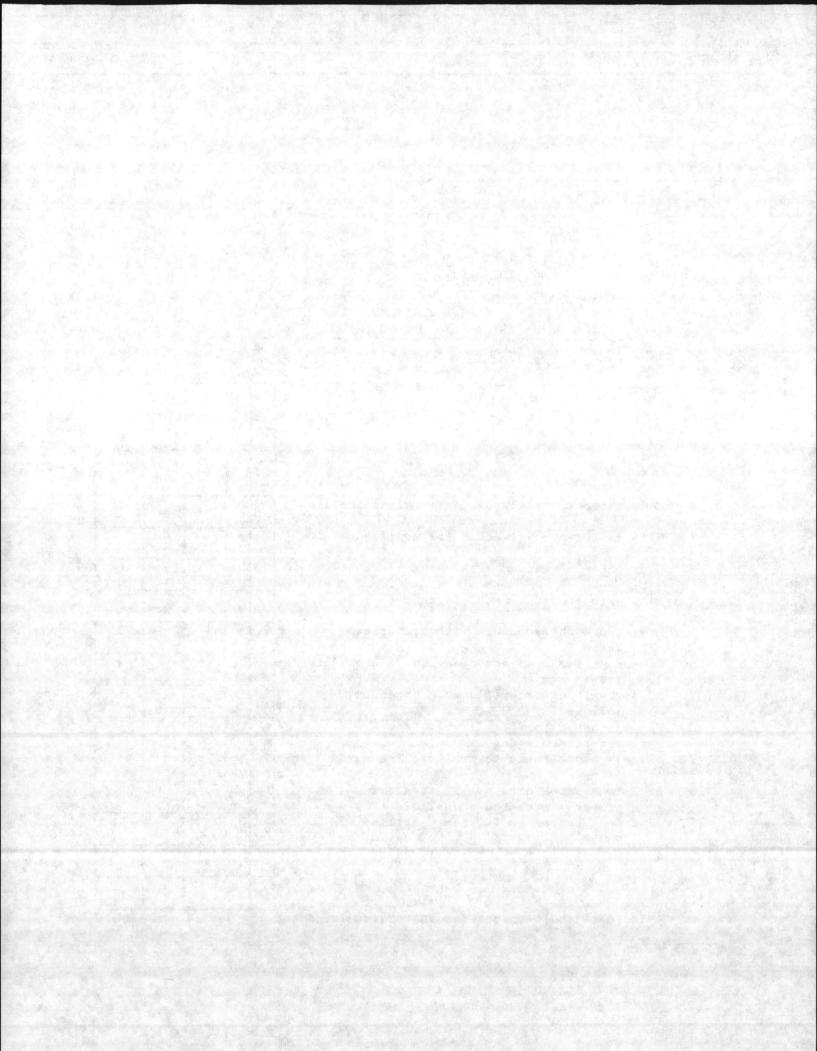
PABRICATION CHECK LIST

"TRAVELER"

Job	Name:	Burnham	Corp.	Boiler	Weld	Repair B-1	
Job	Number:	47576	(NB#	15660)		

		PROJ. MGR	DATE	Q.C.M.	N.C.D.L. BOILER INSP	A.I. HOLD
1.	Code material received and visual inspection					
2.	Mill test reports checked for compliance					
3.	Code material marked with identifiers HT.#					
4.	Materials stored in ASME segregated area					Ÿ
5.	Review of job procedure with Authorized Inspector					
6.	Fit-up assembly in accordance with specifica- tions*					
7.	Proper welding materials and procedure followed W.P.S.# 2A	3/W	3/18	3/2		
8.	Visual inspection of all welds and N.D.E. requirements met	1/4	3/18	7/w		× Y
9.	Witness hydrostatic test* Test Pressure 45 lbs.	The	3/6	7w		in the se
0.	ASME P-4A data forms or NB, repair form properly executed and signed	The	3/14	BW		
1.	ASME Code Symbol or "R" Stamp applied to vessel	The.	3/2	7w		
2.	All records and forms properly filed					

^{*} Indicates hold points for Authorized Inspector

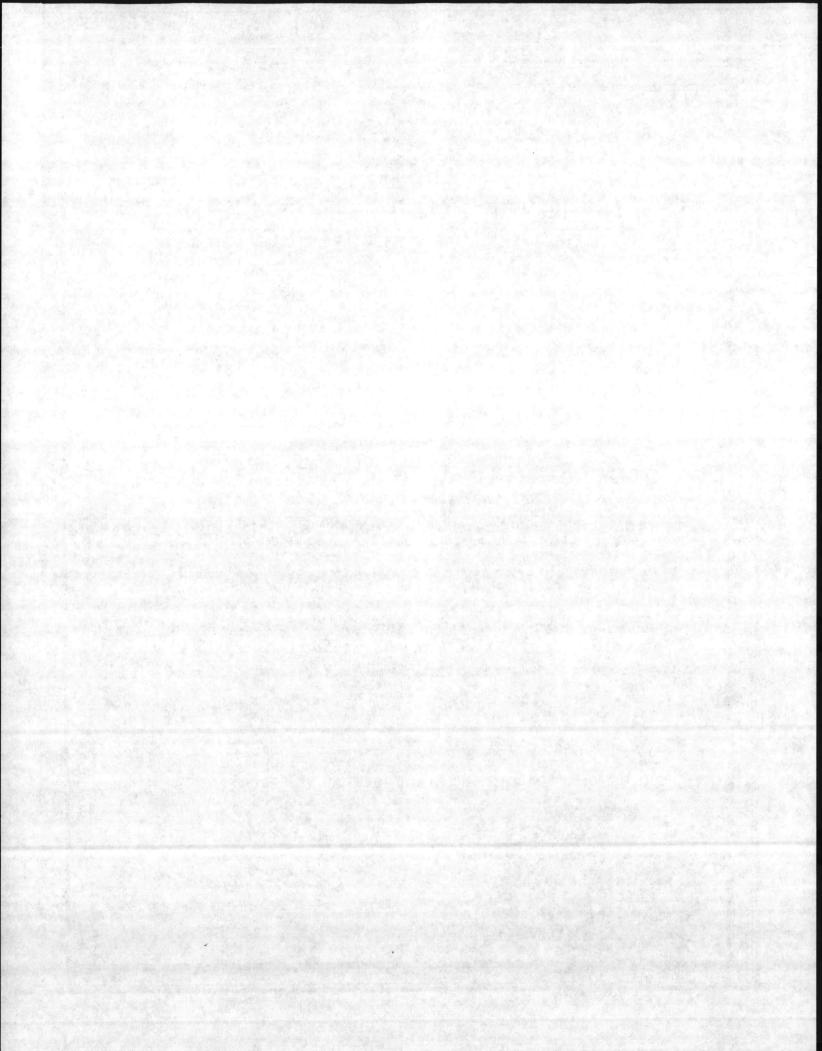




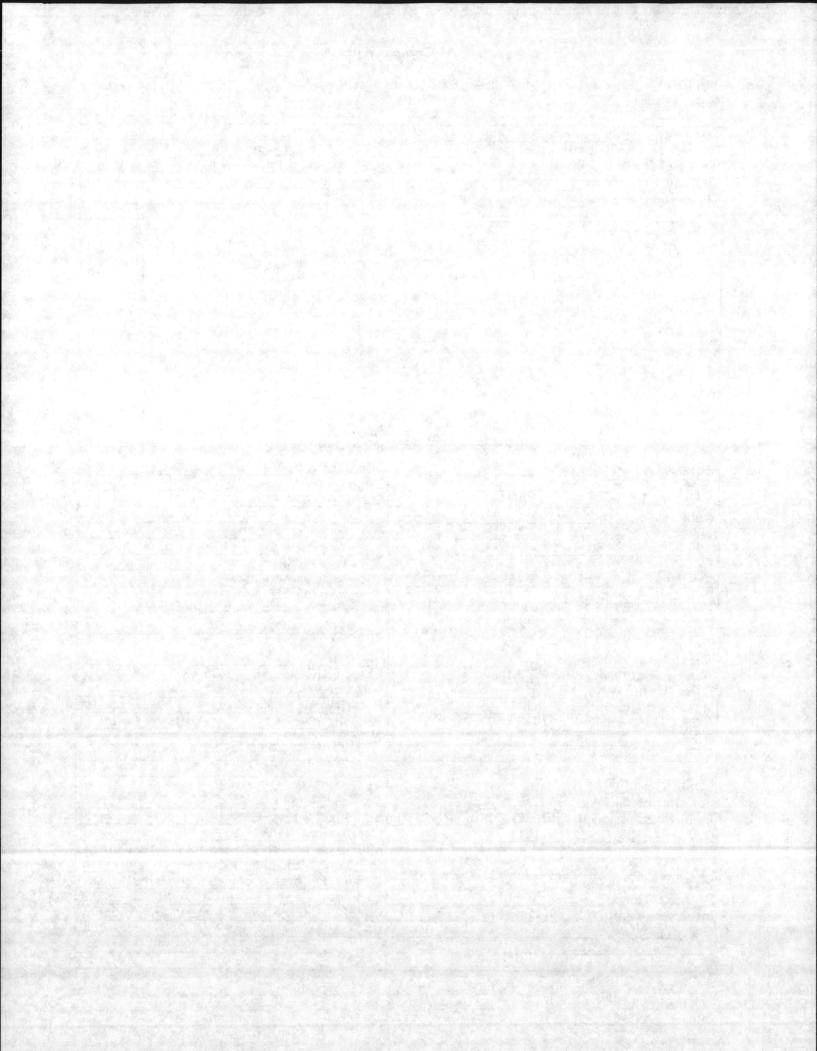
THE NATIONAL BOARD OF BOILER AND PRESSURE VESSEL INSPECTORS

Certificate of Authorization

THIS AUTHORIZATION is issued or renewed on SEPTEMBER 5, 198			
Boiler and Pressure Vessel Inspectors. The use of the Repair symbol and the authority granted by this certificate of authorization are subject to the provisions of the agreement set forth in the application. Any repair stamped with this symbol shall have been made strictly in accordance with the provisions of the National Board Inspection Code. THIS AUTHORIZATION is issued or renewed on SEPTEMBER 5, 198		FIELD REPAIRS CONTRO	17 PH 18
LUQUOT 17 1067	and the authority subject to the pr plication. Any rep	granted by this certif covisions of the agreen air stamped with this sy	icate of authorization are nent set forth in the apmbol shall have been made
and expires on AUGUST 17, 1987 by	THIS AUTHORIZ	ZATION is issued or ren	ewed on SEPTEMBER 5, 1986
	and expires on	AUGUST 17, 1987	by



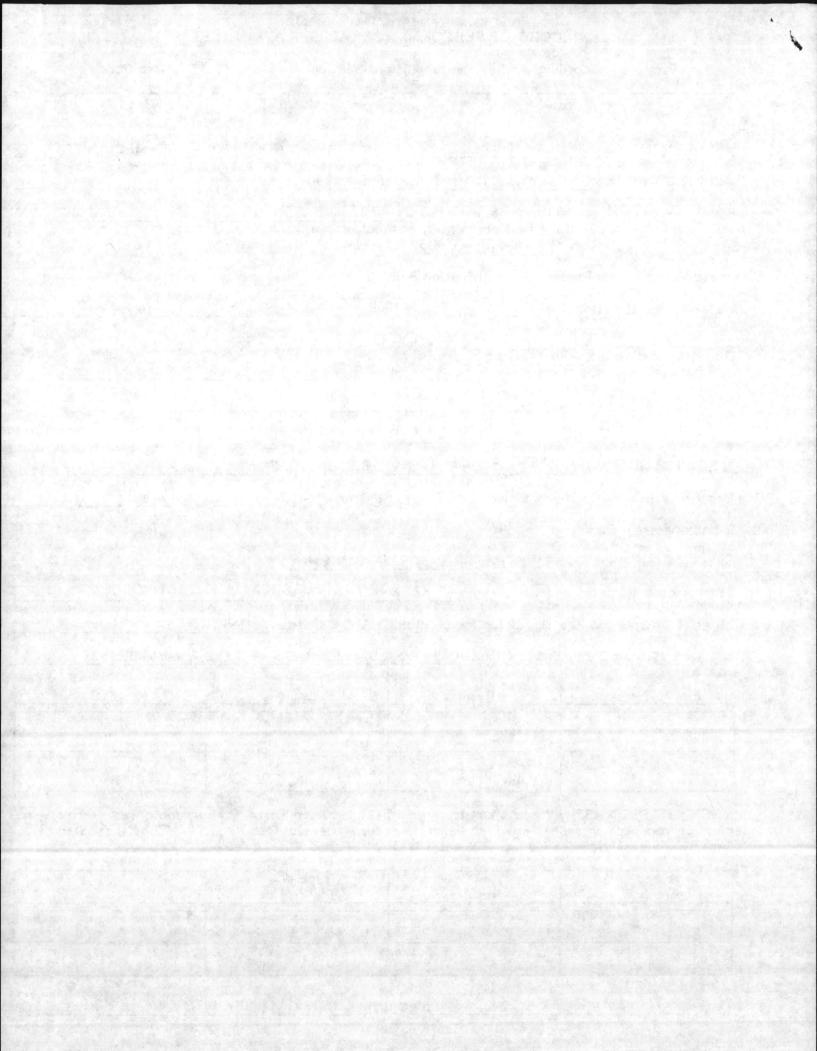
Company Name A & M Company, Inc.	
Procedure Qualification Record No. 2	Date 3/15/85
WPS No. 2A	
WPS No. 2A Welding Process(es) SMAW	
Types (Manual, Automatic, Semi-Auto.)	Manual
JOINTS (QW-402)	
n/	REPAIR EXISTING
	DERAIR EXISTING
the state of the s	KETAIL EXISTING
	FILLET WELD
- 1/4" - 5/16"	
- 1/4 - 5/16	
Groove D	esign Used
BASE METALS (QW-403)	POSTWELD HEAT TREATMENT (QW-407)
Material Spec. SA285	Temperature N/A
Type or Grade C	Time N/A Other N/A
P-No. 1 to P-No. 1 Thickness 1/4' - 5/16'	Other N/A
Thickness 1/4' - 5/16'	
Diameter N/A Other N/A	
OtherN/A	GAS (QW-408)
	Type of Gas or Gases N/A
	Composition of Gas Mixture N/A
	Other N/A
FILLER METALS (QW-404)	
Weld Metal Analysis A-No. 1	
Size of Electrode 3/32	ELECTRICAL CHARACTERISTICS (QW-409
Filler Metal F-No. 4	Current DC
SFA Specification 5.1	Polarity Reverse
AWS Classification E7018	Amps. 80-110 Volts 20-25
Other N/A	Other N/A
	TECHNIQUE (OW/ // 10)
POSITION (QW-405)	TECHNIQUE (QW-410)
Position of Groove 2F Weld Progression (Uphill, Downhill) N/A	Travel Speed N/A String or Weave Bead Stringer
	Oscillation N/A
Other	Multipass or Single Pass (per side) Multipa
	Single or Multiple Electrodes Single
PREHEAT (QW-406)	Other Each pass of weld bead shall be
Preheat Temp. 65°F Min.	cleaned of anything that would affect the
Interpass Temp. 800°F	integrity of the welds by grinding, chipping
Other N/A	or brushing



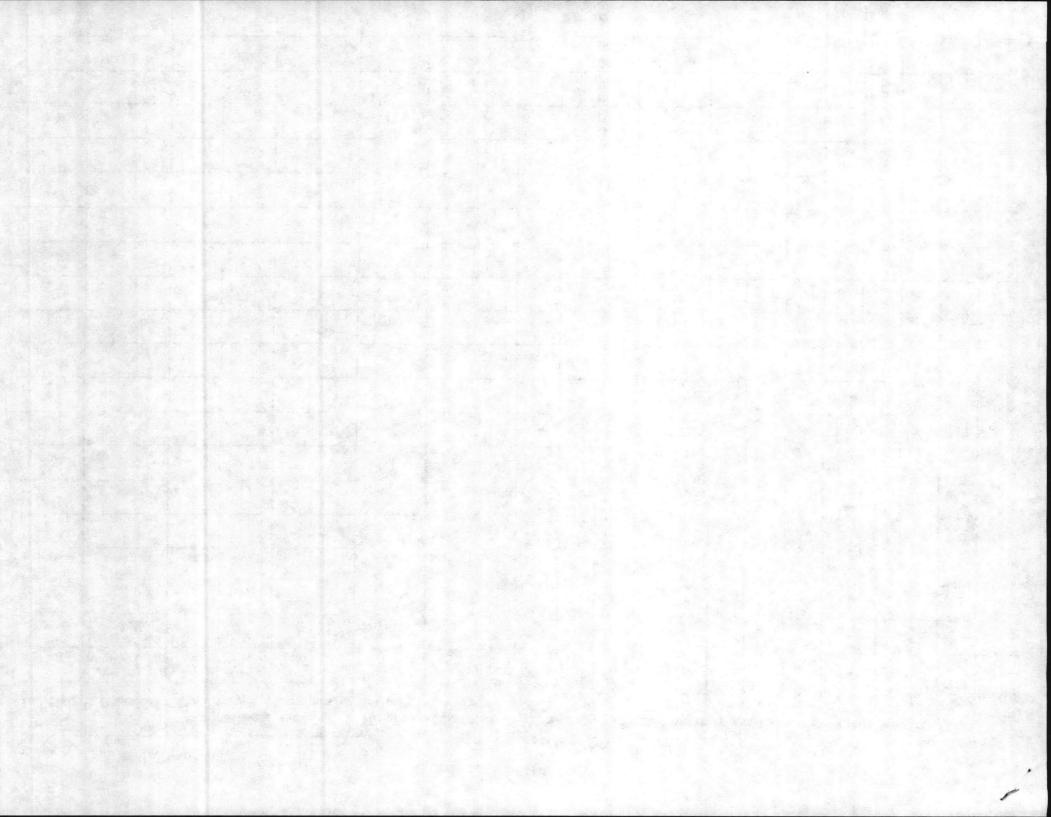
A & M COMPANY, INC. RECORD OF PERFORMANCE QUALIFICATION TEST

Prepared according to the requirements of Section IX of the ASME Boiler Code

		Date V	Velded 2-6-85
ELDER'S NAME_F	red L. Osborne	PERSONAL NO. 54325	55 SYMBOL NO.
VELDING PROCESS	Combination G.T.A.	W. & S.M.A.W.	
or downwa	al, state wheather upward ard.) (Flat, horizontal, v 05, QW-461-2, QW-461-3,	ertical or overhead;	
n accordance with F	Procedure Specification N	No2	
Material Specification	on_SA106Bto_S	A106B of P-No. 1	to P-No1
Diameter and wall the otherwise joint the		Sch. 80	
Thickness range this	qualifies 1/1	6" to .674"	
SPECIFICATION NO		ER METAL GROUP NO. F	4 & 6
Describe filler meta	I if not included in Table	Q-II-2 or QN-II-2:	
s backing strip used	no no		
	- CAN III O	RMATION ONLY	
Flux for Submerged	er and trade name	3/32" Hobart 7018 & 3/32	20-25 C.F.H.
Flux for Submerged GUIDED E Type and	Arc or gas for Inert Shie	3/32" Hobart 7018 & 3/32 elded Arc Welding Argon ee QW-462.2(a), QW-462.3(a) Type and	20-25 C.F.H. , QW-462.3(b)
Flux for Submerged GUIDED E	er and trade name	3/32" Hobart 7018 & 3/32 elded Arc Welding Argon ee QW-462.2(a), QW-462.3(a)	20-25 C.F.H.
GUIDED E Type and Figure No.	Arc or gas for Inert Shies BEND TEST RESULTS (Se	3/32" Hobart 7018 & 3/32 elded Arc Welding Argon ee QW-462.2(a), QW-462.3(a) Type and	20-25 C.F.H. , QW-462.3(b)
GUIDED E Type and Figure No. 2 Face 2 Root RADIOGRAPHIC RE	Arc or gas for Inert Shies BEND TEST RESULTS (See Results Satisfactory Satisfactory Sults: As an alternate spaces provided below in	3/32" Hobart 7018 & 3/32 elded Arc Welding Argon ee QW-462.2(a), QW-462.3(a) Type and	20-25 C.F.H. , QW-462.3(b) Results iographic Test Results QW-305 of the ASME
GUIDED E Type and Figure No. 2 Face 2 Root RADIOGRAPHIC RE	Arc or gas for Inert Shies BEND TEST RESULTS (See Results Satisfactory Satisfactory Sults: As an alternate spaces provided below in	3/32" Hobart 7018 & 3/32 elded Arc Welding Argon ee QW-462.2(a), QW-462.3(a) Type and Figure No. to Guided Bend Tests, Rad accordance with QW-304,	20-25 C.F.H. , QW-462.3(b) Results iographic Test Results QW-305 of the ASME
GUIDED E Type and Figure No. 2 Face 2 Root RADIOGRAPHIC RE must be recorded in Sec. IX Code, Article Type and	Arc or gas for Inert Shies BEND TEST RESULTS (Se Results Satisfactory Satisfactory SULTS: As an alternate spaces provided below in the 2 of Section V and UW	3/32" Hobart 7018 & 3/32 elded Arc Welding Argon ee QW-462.2(a), QW-462.3(a) Type and Figure No. e to Guided Bend Tests, Rad n accordance with QW-304, 7-51 of Section VIII, Division Type and	20-25 C.F.H. , QW-462.3(b) Results iographic Test Results QW-305 of the ASME I Code.
GUIDED E Type and Figure No. 2 Face 2 Root RADIOGRAPHIC RE must be recorded in Sec. IX Code, Article Type and	Arc or gas for Inert Shies BEND TEST RESULTS (Se Results Satisfactory Satisfactory SULTS: As an alternate spaces provided below in the 2 of Section V and UW	3/32" Hobart 7018 & 3/32 elded Arc Welding Argon ee QW-462.2(a), QW-462.3(a) Type and Figure No. e to Guided Bend Tests, Rad n accordance with QW-304, 7-51 of Section VIII, Division Type and	20-25 C.F.H. , QW-462.3(b) Results iographic Test Results QW-305 of the ASME I Code.



Name	Fred L.	Osborn	e			& M COMI		sonal	No.	54325					Symb		E		
Date valified	Process	Pos.	Base Type T	Metal hickness	Filler Metal	Diameter of Pipe	Ye	ar 198	Ť	-	T	T	Qualifi	T	7	1		Lia	
nattited						Of tape	1_	2	3 -	4	5	6	7	8	9	10	五	1	Rema
-15-85	Combination G.T.A.W.	n 6G	SA106B P-1	.337	ER70S-2	4 Sch. 80	ļ	2-15 F.W.								ļ			
	S.M.A.W.			1	E7018			ļ., .		-			-	1					
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	10-		+						Mars .	1851			-	+	+	-	+	-	



WELDING PROCEDURE SPECIFICATION FOR A COMBINATION OF GAS TUNGSTEN ARC WELDING AND SHIELDED METAL ARC WELDING OF CARBON STEEL PER ASME SECTION IX BOILER AND PRESSURE VESSEL CODE "WELDING AND BRAZING QUALIFICATIONS"

W.P.S. No. 2 Date: 6/13/80 Revision: Date: Sheet 1 of 5

WELDING PROCESS: The welding shall be done by a combination of Gas Tungsten Arc Welding for the stringer bead (first pass) and second pass. The remaining passed (weld on) shall be done using the Shielded Metal Arc Welding Process. Both processes shall use manual equipment.

BASE METAL: The base metal used to qualify this welding procedure specification conforms to ASME SA 53 Grade B listed under "P" No. 1 Classification.

BASE METAL THICKNESS: The base metal thickness used to qualify this Welding Procedure Specification is 0.382" thick which will qualify material thickness 1/16" (0.0625") thru 49/64" (0.7656"). The Welding Procedure Specification is qualified on 1-1/4" diameter which will qualify over 1" diameter pipe.

FILLER METAL: The filler metal for the Gas Tungsten Arc Welding process shall conform to ASME filler metal specifications SFA 5.2 weld metal analysis A-I Group "F" No. 6 A.W.S. RG 65. The diameter of the filler metal is 1/8".

The filler metal for the Shielded Metal Arc Welding process shall conform to ASME filler metal specifications SFA 5.1 weld metal analysis A-1 Group "F" No. 4 AWS Classification E 7018. The diameter of the filler metal is 3/32".

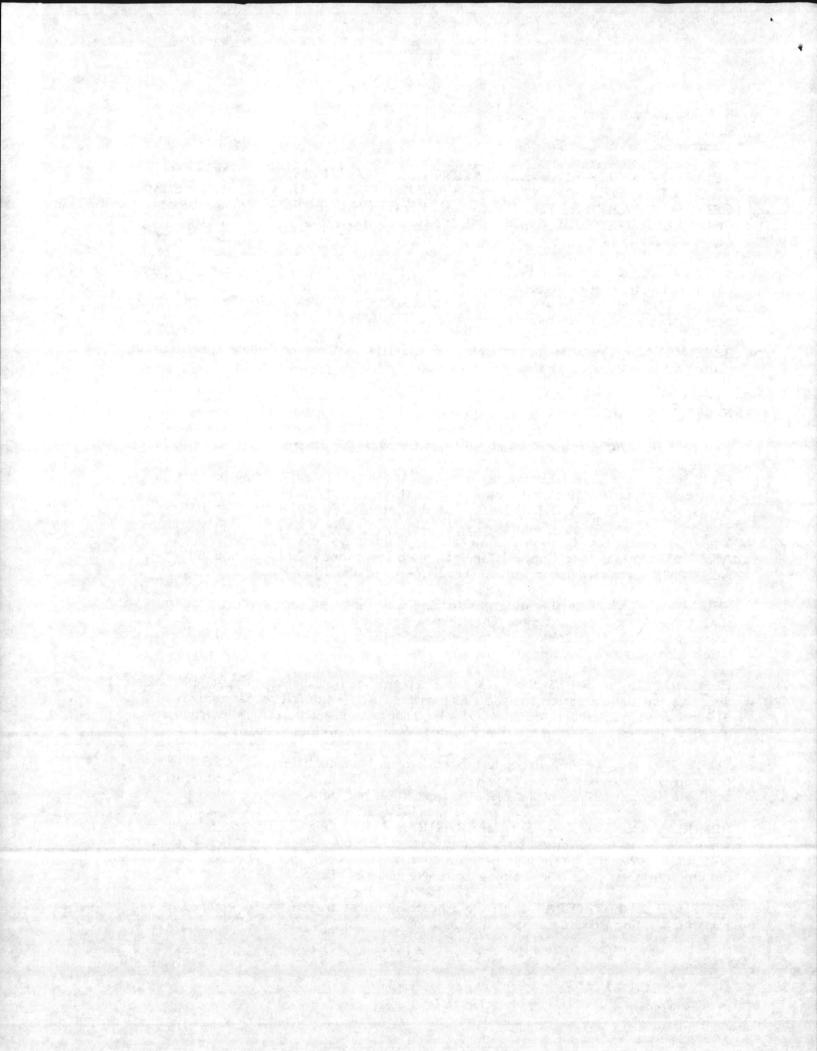
SHIELDING GAS: The shielding gas for the Gas Tungsten Arc Welding process shall be welding Grade Argon. The flow rate shall be 15 C.F.H. thru 30 C.F.H. The cup size shall be 3/8". External shielding gas is not required for the Shielded Metal Arc Welding process.

ELECTRICAL CHARACTERISTICS: The current shall be direct current, electrode negative, straight polarity for the Gas Tungsten Arc Welding Process using a 3/32" diameter 2% thoriated tungsten electrode and direct current, electrode positive, reverse polarity, for the Shielded Metal Arc Welding Process.

POSITION: This Welding Procedure Specification was qualified in the 2G fixed position with the axis of the pipe vertical. The Welding Procedure Specification shall allow for welding of the plate or pipe in all positions.

PREHEAT AND INTERPASS TEMPERATURE: No welding shall be performed when the parts to be joined by welding are below room temperature (65° F min.) without first warming the welding area to a minimum of 65° F. Welding shall not be continued when the welding zone exceeds 800° F.

POST WELD HEAT TREATMENT: No post weld heat treatment is required for this Welding Procedure Specification.



PREPARATION OF BASE MATERIAL: The edges of the parts to be joined by welding shall be prepared by machining, flame cutting, or grinding as shown on the attached drawing and shall be cleaned of oil, grease, scale, rust, or other foreign material. See Figure No. 1.

BACKING STRIP OR BACKING GAS: The welded joint shall not utilize a backing strip or backing gas.

JOINT WELDING PROCEDURE: The welding techniques such as electrode size, filler metal size, mean voltage and amperages for each electrode shall be substantially as shown on the attached drawing. See Figure No. 1.

APPEARANCE OF WELDING LAYERS: The welding current and manner of depositing the weld metal shall be such that there shall be practically no undercutting on the side walls of the welding groove or the adjoining base material.

<u>CLEANING:</u> All slag or flux remaining on any bead of welding shall be removed before laying down the next successive bead of welding.

<u>DEFECTS</u>: Any cracks, porosity, lack of fusion, or lack of penetration that appear on any bead of welding shall be removed by chipping, grinding, gouging, or any other suitable means, before depositing the next successive bead of welding.

PEENING: None required by this Welding Procedure Specification.

TREATMENT OF UNDERSIDE OF WELDING GROOVE: None required by this Welding Procedure Specification.

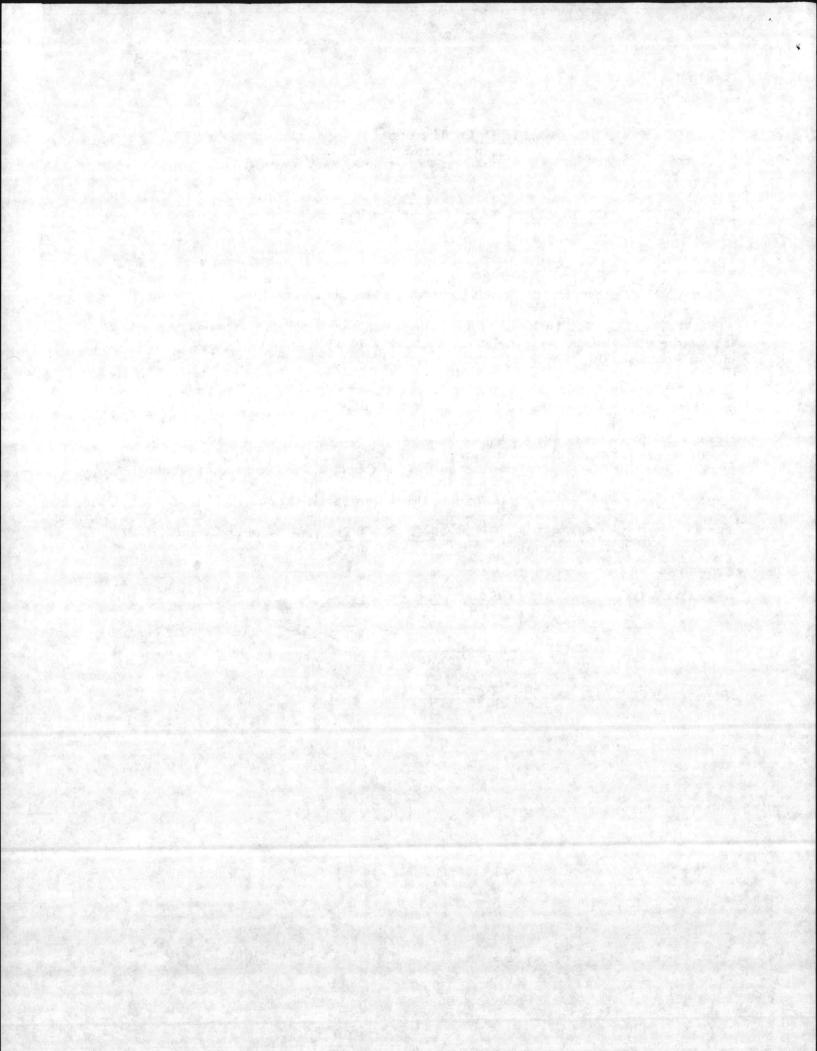
APPROVED BY:

A & M Company, Inc.

Company Name

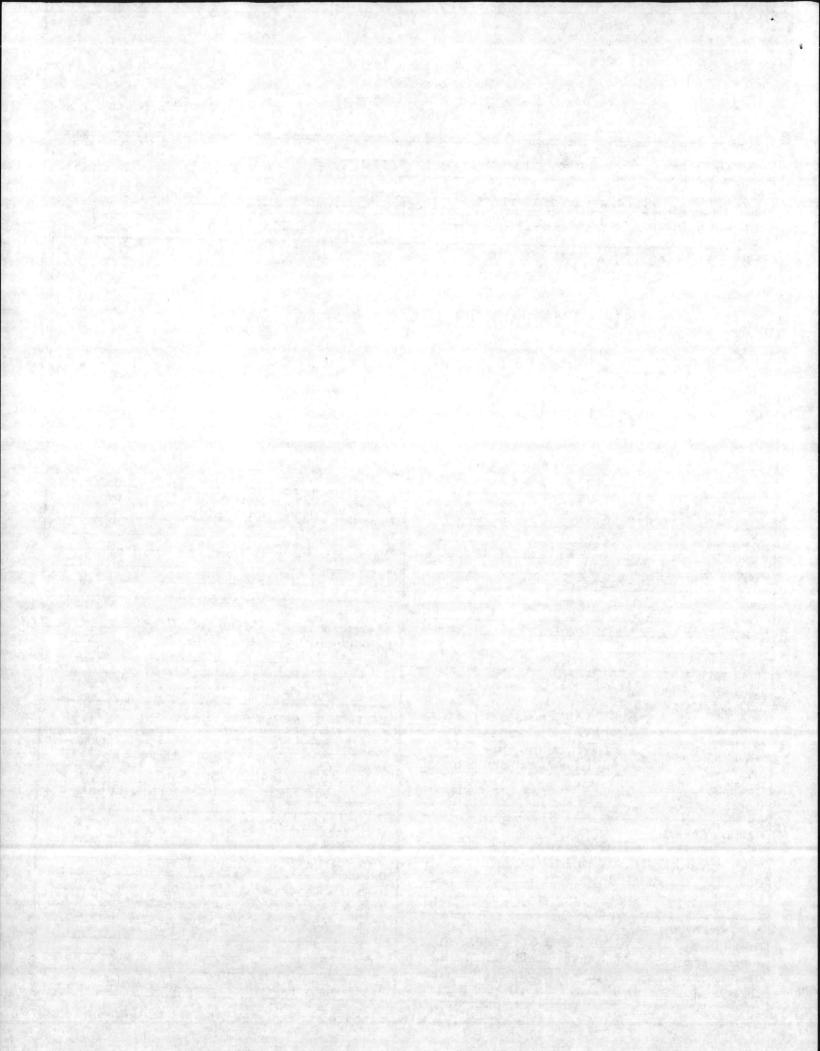
Company Representative

DATE: 6-30-80



W.P.S. No. 2 Sheet 3 of 5

A & M Company, Inc.	
ompeny Name	Dete 6/13/80
ocedure Cualification Record No.	- Land wolding weldout
PS No. Gas tungsten arc welding for	or stringer bead shielded metal arc welding weldout
rec (Manual, Automatic, Semi-Auto.) Manual	
per (menue), Automotic, Semi-Auto.)	
DINTS (QW-402)	
See Figure No. 1 Attache	d
See Figure 140. I Pittaene	
	얼마는 나는 그들은 아이들은 얼마를 하는 것이다. 그는 그 모든 그 모든 사람들은
> (0)	
	roove Design Used
1.00	POSTWELD HEAT TREATMENT (QW-407)
ASE METALS (QW-403) ASME SA 53	Temperature None Required
naterial Spec.	Time N/A
ype or Grade	Other
• No to P • No 1	- Odler
1-1/4" diameter	
ASITIECE!	
Other	GAS (QW-408)
	Type of Gas or Gases Argon for GTAW
	Composition of Gas MixtureN/A
	Other
ILLER METALS (QW-404)	
Veld Metal Analysis A.No. GTAW and 3/32" for	SMAW ELECTRICAL CHARACTERISTICS (QW-409)
6 for GTAW and 4 for SMAW	Current Direct Current
Tar CTAW and 5 I for SM	Straight - GIAW, Reverse - SWAW
FA Specification RG65 for GTAW and E7018 f	or SMAW. GIAW /3/93 Valte GIAW 3/12
Other	
Aner	see Figure No. I for further details
POSITION (QW-405)	TECHNIQUE (QW-410)
Position of Groove 2G Horizontal	Travel Speed N/A String or Weave Bead stringer_beads
Weld Progression (Uphill, Downhill) N/A	String or Weave Bead Stringer Deads Oscillation N/A
Other	Oscillation
	Single or Multiple Electrodes single electrode
	Other See Figure No. 1 for further details
PREHEAT (QW-406)	그리는 그는
Preheat Temp. Room Temp 82 1. Interpess Temp. Maximum of 800° F	



Tensile Test (QW-150)

W.P.S. No. 2 Sheet 4 of 5

Specimen			Area	Ultimate . Total Load lb.	Ultimate Unit Stress psi	Character of Failure & Location
No.	Width	Thickness		9,770	53,400	Ductile Fracture
1-3587 T-1	0.489"	0.3/4"	0.1829"	7,770	75,100	Base Metal .
	14 10 19 19 19 19 19 19 19 19 19 19 19 19 19	0.00711	0.1050	10,270	52,700	Ductile Fracture
1-3587 T-2	0.504"	0.387"	0.1950	10,270	2,, 50	Base Metal

Guided Bend Tests (QW-160)

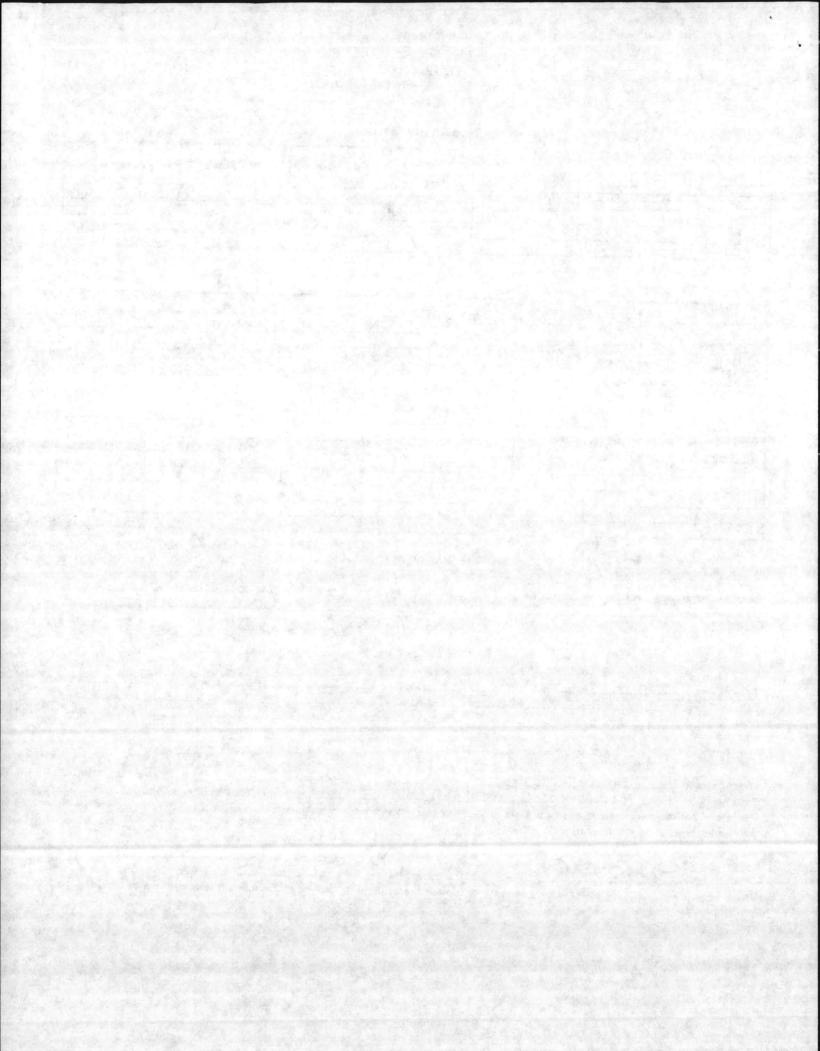
100	Type and Figure No.	Result
011 0 1	Figure 462.22	No Indications Conforms
Side Bend		No Indications Conforms
Side Bend	Figure 462.22	3 Indications 1/32" thru 3/32" conforms
Side Bend	Figure 462.22	3 Indications 1/32" till d 3/32" conforms
Side Bend	Figure 462.22	4 Indications 1/64" thru 3/32" conforms

Toughness Tests (QW-170)

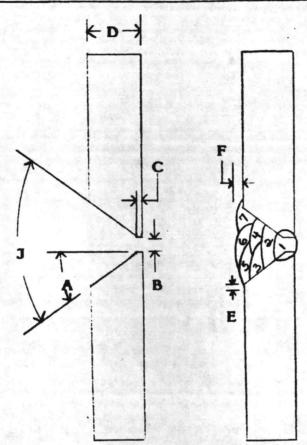
				Impact	Lateral Exp.		Drop Weight	
	Notch Location	Notch Type	AND THE RESIDENCE OF THE PARTY	Impact Values	% Shear	Mils	Break	No Break
								1.89
1000							Jacob B	
		-						
, .			Will Company	100			The Part of	

Fillet Weld Test (CW-180)

Result — Satisfactory: \	/esNo	Penetration into P	Parent Metal: Yes	No	
		Other Tests	None Required	ľ	
Type of Test				-	100
Deposit Analysis					10 mg
Other	TO SEE THE CONTROL OF T		·		1.16
•					
	Horace Long Hobart Bros. Co. We		_ Clock No	Stamp No.	
Walder's Name	Hobart Bros Co. We	d Test Lab	Laboratory Test No.	_T_3587	-
Tests conducted by:	tements in this record are corre	ect and that the test weld	s were preprared, welded	and tested in acco	rdance with
We certify that the sta	ction IX of the ASME Code.				
the requirements of Se	ction ix of the Asiac code.	7 () () () () () () () () () (A Marian Commencer)_
	00	Manufacturer	A & M Gomp	any, Inc.	23/
Dete 6-3	0-30	Car	-	20	
Dete	ts are illustrative only and may	he modified to conform to	the type and number of to	ests required by the	Code.)

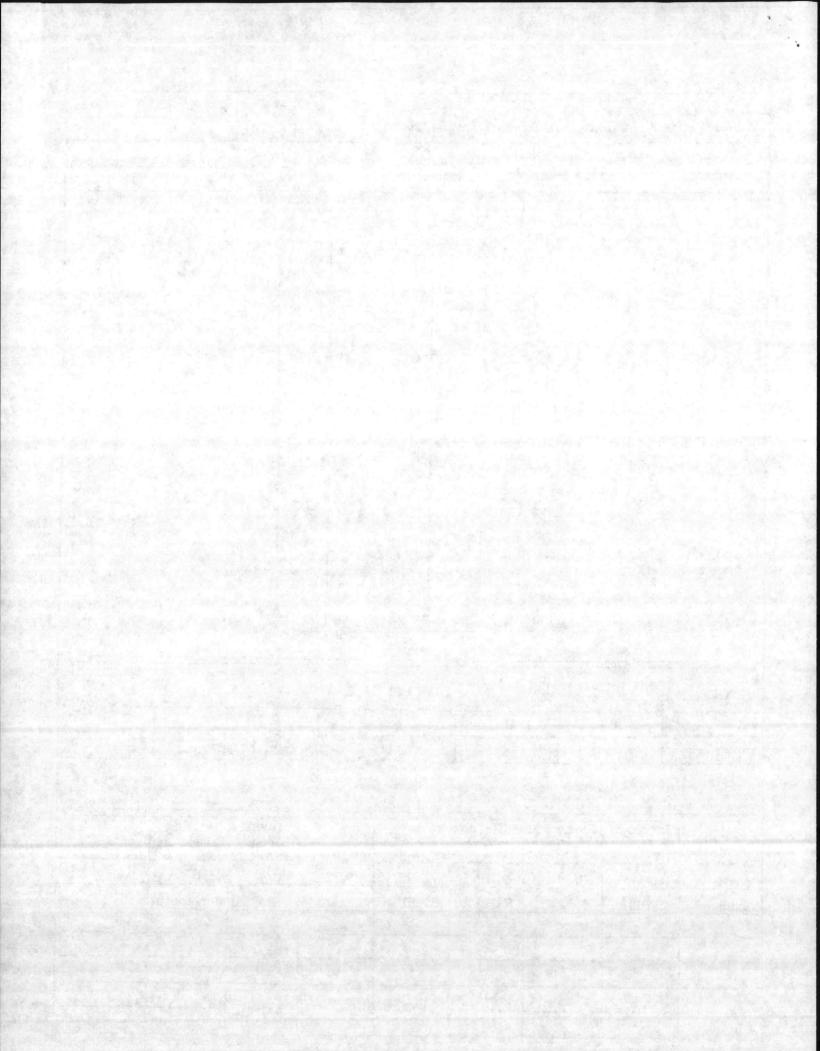


A & M Compar	ny, Inc.	W.P.S. No. 2
P. O. Box 3147	Wilmington, North Carolina 28406	Revision
Figure Number 1		Date 6/13/80
Number 1	Test Position 2 G Horizontal	Sheet 5 of 5



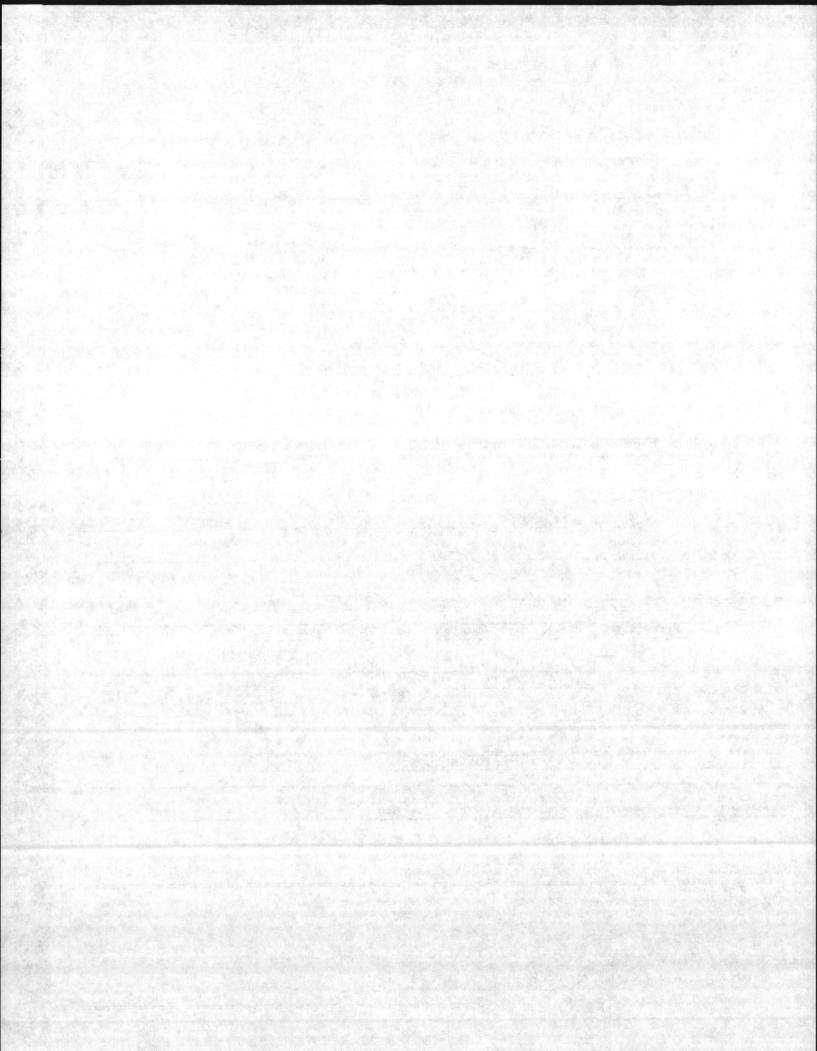
ANG	LE			DIMENSION	ing. The	A STATE OF THE STATE OF	
Α	G	В	С	D	E	F	J
37.5°	75°	3/32"	1/16"	0.382"	1/8" max	1/8" max	

Bead No	Electrode or Wire Type	Electrode or Wire Size in.	Current Polarity	Amps	Volts	Travel Speed In/Min	Welding Direction	
1 & 2	RG 65	1/8"	DCEN	75/95	9/12	2/4	Horizontal	
3 thru 7	E7018	3/32"	DCEP	85/105	22/25	4/6	Horizontal	
			7.00					
	To the To Highly Halls						and the Wales	Life Lagra
			- 140 p. 150	THE RESERVE				
· <u></u>						100		



SPECTION REP	ORT-BOILERS	A springers and the	ale i raligioni				DATE OF INSPECT	ION	
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N 0105-LF-004-0	000			TYPE OF	INSPECTION		124 1744, 1.	5 3671	1783
	de la companya de la				NTERNAL &	BX	WITH PRESSURE T	ERNAL C	7 OPER
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TAVE	ACENGCOM						5. BOILER INSPECT	OR	
NOR	folk, yal					-	Thomas ?	LLan	ier
		BOILER DA	TA					TIONAL BOAR	D NO
MANUFACTURER	recult for a		and the state of			-	6. REASON FOR NO	239	RTIFICATE
WATIONAL PROPERTY NO.	RADIA	TOR							
PROPERTY NO.	S. MFG. SERI	AL NO.	6. N	MFG. MODEL	NO.				
5	10/74 8. YEAR BUIL		A	C- 40	25	all in parties			
BUILDING NO.									
75-764 FUEL (Check)	1953	11. PRESSUR	/, C	410,000	BTULH	R.			
		DESIGNED		ATING	TEST				
COAL P	OIL GAS	30	pai /	2 psi	45	psi			
FEED WATER TREA			13. TYPE				-174		
SATISFACTO	RY UNSATI	ISFACTORY	TUBE	TO FI	RE JBE	C. I.			
BOILER USE FATING COMBUSTION			•	14 6N 2	STION CONTRO EYWEL AS TEMPERATO	L URE	Name)		- 89
COMBUSTION	x CO ₂	% EX	CESS O2	14 6N 2		L URE	Name) *F: AFTER HE	AT TRAP	_ 8
FATING.		% EX		14 6N 2	EYWEL, AS TEMPERATE	L URE		AT TRAP	
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AFATING COMBUSTION 7,5		% EX	` S	AFTER BO	EYWEL AS TEMPERATO DILER_25 VICES LVES LVES	L URE	F: AFTER HE	24. COND	
AFATING COMBUSTION 7,5		* EX	S S	AFTER BO	EYWEL AS TEMPERATU DILER 25 VICES LVES NUMBER AN 1- 2"	L URE			
MEHTING COMBUSTION 7,5 MANUFACTURER WHTTS			S S	AFTER BO AFTER BO AFETY DE BAFETY VA 22 PRESSUI	EYWEL AS TEMPERATO DILER_25 VICES LVES LVES	D SIZE	F: AFTER HE	24. COND	
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MANUFACTURER MANUFACTURER MANUFACTURER	11 10WN	% EX	STEAM	AFTER BOAFETY VA	OILER 25 VICES LVES LVES RE GAUGE CORRECTION ATER LEG C	D SIZE	23. PSI SETTING	600	D
MANUFACTURER MANUFACTURER MANUFACTURER	11 10WN		STEAM	AFTER BO AFTER BO AFETY DEV BAFETY VA 22 PRESSUIT	OILER 25 VICES LVES LVES RE GAUGE CORRECTION ATER LEG C	D SIZE	23. PSI SETTING 30	24. COND	D
MANUFACTURER MANUFACTURER MANUFACTURER MANUFACTURER MANUFACTURER MANUFACTURER MANUFACTURER MANUFACTURER MANUFACTURER	11 10WN		STEAM	AFTER BOAFETY VA	OILER 25 VICES LVES LVES RE GAUGE CORRECTION ATER LEG C	D SIZE	23. PSI SETTING	24. COND	D
MANUFACTURER WATTS MANUFACTURER	11 10WN	IN SE	STEAM	AFTER BO AFTER BO AFETY DEV BAFETY VA 22 PRESSUIT 26 W	OILER 25 VICES LVES NUMBER AN L 211 RE GAUGE CORRECTION ATER LEG C	D SIZE	23. PSI SETTING 30	24. COND	D
MANUFACTURER MANUFACTURER MANUFACTURER MANUFACTURER MANUFACTURER MANUFACTURER MANUFACTURER MANUFACTURER	X CO2	IN SE	STEAM FIR	AFTER BO AFTER BO AFETY DEV AFETY VA 22 PRESSUIT 26 W	OILER 25 VICES LVES NUMBER AN L 211 RE GAUGE CORRECTION ATER LEG C	D SIZE	23. PSI SETTING 30	24. COND	D
MANUFACTURER	LUNHAM B	IN SE	STEAM FIR	AFTER BO AFTER BO AFETY DEV AFETY VA 22 PRESSUIT 26 W	OILER 25 VICES LVES NUMBER AN L 211 RE GAUGE CORRECTION ATER LEG C	D SIZE	23. PSI SETTING 30	24. COND	D
MANUFACTURER	DUNHAM B NOZZLE HOZZLE	IN SE BUSH - I SPRA	STEAM FIR RVICE	AFTER BO AFTER BO AFETY DEV AFETY VA 22 PRESSUIT 26 W	OILER 25 VICES LVES NUMBER AN L 211 RE GAUGE CORRECTION ATER LEG C	D SIZE	23. PSI SETTING 30	24. COND	D
MANUFACTURER	DUNHAM B WOZZLE #2 MENTS SETTIWE A FALTITUE	IN SE SYSH - I SPRH	STEAM FIRE FIRE FIRE FIRE FOR A	PRESSUIF	PARENT	D SIZE	23. PSI SETTING 30	24. COND	D
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MANUFACTURER MA	DUNHAM B WOZZLE THE Z MENTS SOTTING A F PLTITUK	IN SE SPRA SPRA SFRA OF GAG	STEAM FIR RVICE PART FIR RVICE RVICE RVICE RVICE RVICE	PRESSUI PRESSUIF AFTER BO AFTER B	VICES LVES LVES LVES CORRECTION ATER LEG C	D SIZE	23. PSI SETTING 30	24. COND	D

* G.P.O.: 1982-507-422



DATA RECORD SHEET - BOILERS
NAVFAC 9-11014/40 (9-69) Superredes NAVDOCKS 2509

	VENTURI TYPE	ROTARY CUP	GAS RING	AIR ATOMIZED
FIRING EQUIPMENT	UNDERFEED - MULTIPLE RETORT UNDERFEED - SINGLE RETORT SPREADER - DUMP GRATE SPREADER - VIBRATING GRATE SPREADER - TRAVELING GRATE	BALL & RACE BOWL MILL TUBULAR OIL BURNERS X MECHANICAL STEAM ATOMIZED GAS	내는 사람이 어느 아니는	COAL - PULVERIZER ATTRITION BALL & RACE BOWL MILL TUBULAR OIL BURNERS MECHANICAL STEAM ATOMIZED
FUEL	FUEL & FIRING EQUIPM COAL ANTHRACITE BITUMINOUS GAS NATURAL MANUFACTURED		ALTERNATE FUEL & F OAL OIL ANTHRACITE BITUMINOUS OTHER NAVY S OTHER	IRING EQUIPMENT RCIAL 1, 2, 4, 5, 6 SPECIAL
NORMAL FEEDWATER TEMPE	/A of WATER WALL ECONOMIZER SUPERHEATER A of DRIMS	AUTOMATIC SEMI-AUTOMATIC MANUAL PRESSURE (psig) 30 DESIGN MAWP 15 INSTALLED WE AIR HEATER	EXPORT ELEC. POWER GENERATION LAID UP - WET LAID UP - DRY, X Heating CAPACITY 21.2 HP LB. HR EDR 885.5 M BTU/HR.	DATE BUILT 1984 DATE INSTALLED 5-15-85 BOILER TYPE C.I. WATER TUBE X FORCEI INDUCT PRODUCES CIRCULATION X LOW TEMP. WATER HIGH TEMP. WATER FORCED

THE PARTY OF STREET

			MANUFACTURER	TYPE	SETTING	RANGE	PRESSURE CLASS
FITTING	NUMBER	SIZE	MANUFACTURER	19 x 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3 3			
AFETY VALVES	1	14	WATTS	MODEL M	30		
TEAM OUTLET VALVES	1	2"	GRINNELL	GATE		150	
BLOW-OFF VALVES	1	1½	GRINNELL	GATE		150	
FEEDWATER VALVES	1	3/4"	GRINNELL	GATE		125	
WATER COLUMN	N/A						
FEEDWATER REGULATOR	1	3/4	WATTS MOOR 335-1		12	10-25	
WATER GAGES	N/A					0-50 PS 60-260	I
STEAM GAGES	1	3"	US GAGE	ALTITUDE		60-260	
SOOT BLOWERS	N/A						
FUSIBLE PLUGS	N/A						

SAFETY VALVE - MFG WATTS SIZE 11/2" CAP. 2,105,000 BTU/HR

PRIMARY CONTROL - HONEYWELL R4795D

BURNER TIP SIZE - 3.5 GPH MONARCH F 80 BPS 80°