

Addendum No 1

THE YOUNGSTOWN WELDING & ENGINEERING CO. RECORD OF WELDING PROCEDURE
QUALIFICATION TESTS 0-1

Specification No. T-173-A-708A Date Feb. 29, 1968
Welding Process TIG Manual or Machine Machine
Material Specification SA 240 to SA 240 of P-No. 8 to P-No. 8
Thickness (if pipe, diameter and wall thickness) .365
Thickness Range this test qualifies 1/16 to .730
Filler Metal Group No. F- None FLUX OR ATMOSPHERE
Weld Metal Analysis No. A- _____ Flux Trade Name or Composition None
Describe Filler Metal if not included in Table Q-11.2 or QN-11.2 Inert Gas Composition Argon-Helium
Trade Name Linde Flow Rate 10 CFH-35 CFH
For oxyacetylene welding—State if Filler Metal is silicon or aluminum killed. Is Backing Strip used? None
Preheat Temperature Range None

WELDING PROCEDURE
Single or Multiple Pass Single Postheat Treatment 1900° - 2050°F
Single or Multiple Arc Single
Position of Groove Flat (See Pars. & Figs. Q-2 & Q-3, or QN-2 & QN-3)
(Flat, horizontal, vertical, or overhead; if vertical, state whether upward or downward)

FOR INFORMATION ONLY

Filler Wire—Diameter None WELDING TECHNIQUES
Trade Name None Joint Dimensions Accord with VM&ECO Procedure T173A
Type of Backing Argon Gas amps 250 volts 12-15 inches per min. 7"-12" PM
Forehand or Backhand _____ 425

REDUCED SECTION TENSILE TEST (Figs. Q-6 and QN-6)

Specimen No.	Dimensions		Area	Ultimate Total Load, lb.	Ultimate Unit Stress, psi	Character of Failure and Location
	Width	Thickness				
06-3	1.660	.353	.5860	48,500	82750	Weld Area
06-24	1.660	.355	.5910	49,250	83340	1-3/4" from Weld Area

GUIDED BEND TESTS (Figs. Q-7.1, Q-7.2, QN-7.1, QN-7.2, QN-7.3)

Type and Figure No.	Result	Type and Figure No.	Result
07.2	Sound - no tears	07.2	Sound - no tears
07.2	Sound - no tears	07.2	Sound - no tears

Welder's Name T. Markovich Clock No. 300 Stamp No. T.J.
Who by virtue of these tests meets welder performance requirements.
Test Conducted by Sheet & Tube, VM&ECO Laboratory—Test No. 4361
per [Signature]

We certify that the statements in this record are correct and that the test welds were prepared, welded and tested in accordance with the requirements of Section IX of the ASME Code.

The Youngstown Welding and Engineering Co.
Signed _____ (Manufacturer)
By [Signature]
C. J. Wem

Feb. 29, 1968

CONSOLIDATED EDISON COMPANY
CO Report No. 247/69-6

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PDR ADOCK 05000247
A PDR