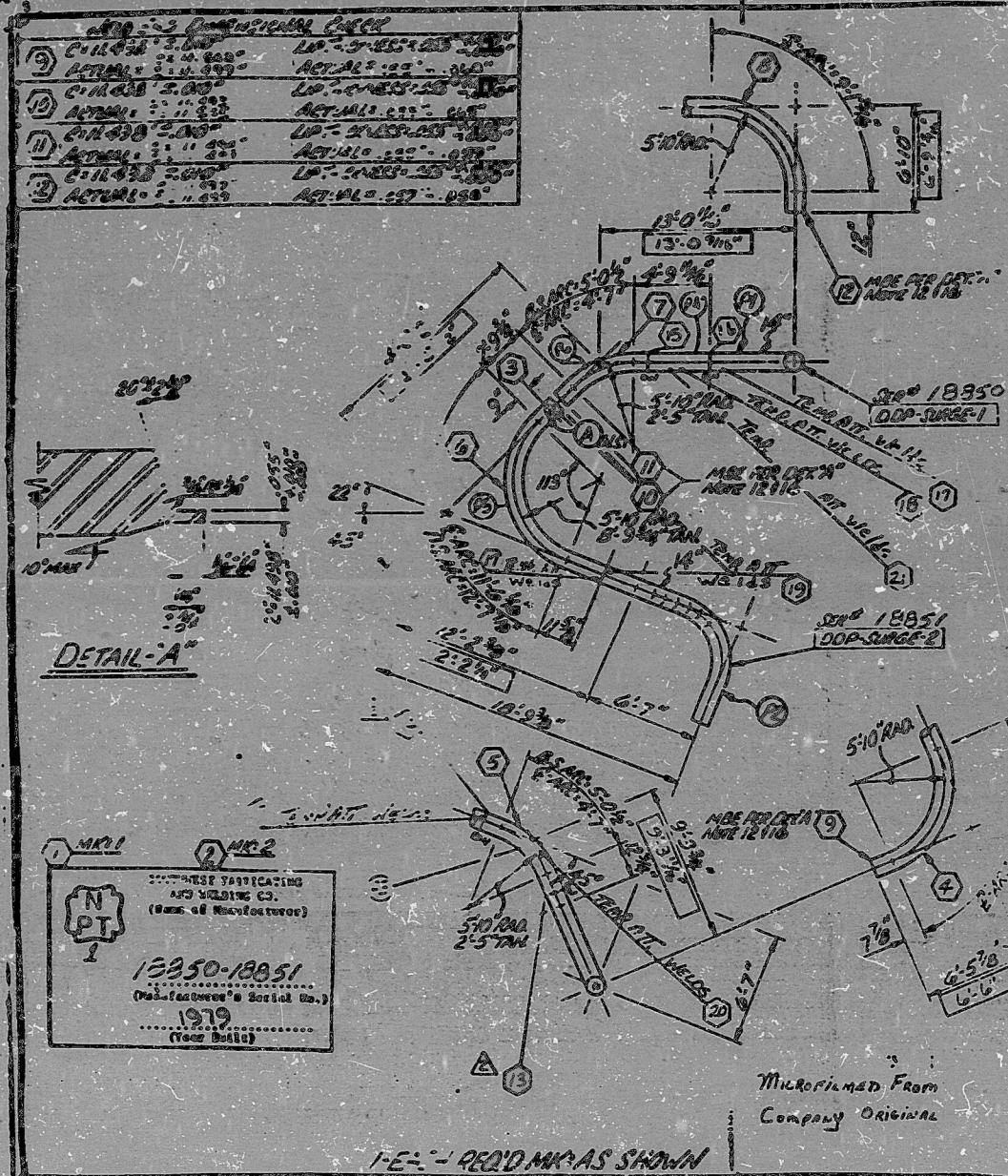


NO.	DESCRIPTION	DATE	BY
1	CHANGES	11-1-58	...
2	CHANGES	11-1-58	...
3	CHANGES	11-1-58	...
4	CHANGES	11-1-58	...
5	CHANGES	11-1-58	...



- CODE CASE 1623-2
1. WELD WITH LOW STRESS STENCIL ON BT & HEAD AND SERIAL NO. TO BE APPLIED TO EACH PART OF THE FABRICATED ASSEMBLY.
 2. SEE ATTACHED MANUFACTURING RECORD SHEET FOR CONSTRUCTION AND PROCEDURE.
 3. INSTALL 3/4" THRU 2" HOLES PER SHEET 28(100)
 4. T.T.C. ROOT PASS OF ALL WELDS.
 5. CHECKED DRING ALL WELDS - 250 RMS MAX.
 6. WELD REINFORCEMENT OF BUTT WELDS 1/16"
 7. ALL TEMPORARY ATTACHMENTS SHALL BE OF A CRYSTALLINE AND IDENTIFIED MATERIAL.
 8. ALL SURFACES FROM WHICH METAL HAS BEEN REMOVED BY THE SHOP, SHALL BE LIQUID PENETRANT EXAMINED PER PROCEDURE.
 9. LIQUID PENETRANT EXAMINE PER PROCEDURE ALL SURFACES AND ALL ACCESSIBLE SURFACES OF FINISHED BUTT WELDS, NOZZLE WELDS, POINT WELDS, AND THE HEAT AFFECTED ZONE OF THE BASE METAL ADJACENT TO THE WELDS. PENETRANT EXAMINE EACH 1/2" IN 12" MAX DEPOSIT.
 10. LIQUID PENETRANT EXAMINE PER PROCEDURE ALL SURFACES FINISHED OR UNFINISHED 3/16", 1/8" AND GROUND SURFACE INSIDE HEAD AT 1/16" WELDS.
 11. LIQUID PENETRANT EXAMINE PER PROCEDURE ALL FLEED WELD BEVELS.
 12. LIQUID PENETRANT EXAMINE PER PROCEDURE ALL FINISHED BUTT WELDS.
 13. ALL METAL TO BE 304 STAINLESS STEEL.
 14. ALL WELDS SHALL BE 1/8" BEHIND ON W.R. 1/16" MIN. GAP & 1/16" MIN. BEHIND.
 15. WELDS SHALL NOT BE LOCATED IN BENDS.
 16. HEAT TREATMENT ANNEAL BANDS PER PER CELL 105.
 17. LIQUID PENETRANT EXAMINE PER PROCEDURE AND RECORD ANNEAL BANDS.
 18. ALL WELDS TO BE MADE BY THE SHOP.
 19. WELDS TO BE MADE BY THE SHOP.
 20. WELDS TO BE MADE BY THE SHOP.
 21. WELDS TO BE MADE BY THE SHOP.

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FOR INFORMATION ONLY

RECORDING CONTROL DATE NOV 05 1958

QA SECTION 1 GNM 2201-01-0085 001

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