

TEMPORARY CHANGE REQUEST

TCR NO. **TCR-ENG-038,R0-002**

(e.g., TCR-ENG-021,R0-001)

The Temporary Change Request (TCR) Form is to be used to process urgent or minor changes for PPPL Policies, Organization/Mission Statements and Procedures. The TCR should be used when changes are:
1) urgent, and can not wait the 2-4 week period for Department Head review/comment, or
2) minor, and do not warrant Department Head review.

Person Requesting Change: Larry Dudek Phone Ext: _____

Department Name: Fabrication and Operations Division of Engineering and Infrastructure

Document Number: ENG-038 Revision No.: 0

Document Title: Welding Materials Control

Reason for change: Delete use of welding material issuance and return documents.

Change description: (Summarize and attach changed pages, with changes clearly indicated)

Alter steps 6 and 8 to eliminate the documentation of welding material

Delete steps defining the document paths

1. Does this TCR significantly alter the intent or scope of the document? YES: _____ NO: X

2. Does this TCR significantly impact ES&H? YES: _____ NO: X

If 1 or 2 is YES, Explain why the changes should not be routed for Department Head review:

Larry Dudek
Department/Division Head Approval

6/16/14
Date

John De Looper
Head, Best Practices and Outreach/designee

6/16/14
Date

Release/Effective date of this TCR: 6/16/14

Incorporate this TCR into next revision of this document? YES: X NO: _____

Subject: Welding Materials Control	Effective Date: 6/10/05	Initiated by: Michael Williams Associate Laboratory Director for Engineering and Infrastructure
	Supersedes: EM-0023 Rev. 1	Approved: Stewart Prager Director

TCR-ENG-038,R0-002

Management System (Primary): 03.00 ENGINEERING (ENG)
Management System Owner: Associate Laboratory Director for Engineering and Infrastructure
Management Process: 03.04 Engineering Programs and Processes
Process Owner: Associate Laboratory Director for Engineering and Infrastructure
Sub-Process: 03.04.01 Welding
Sub-Process Owner: Larry Dudek
Subject Matter Expert: Morgan Styer

APPLICABILITY

This procedure is applicable to all welding and torch brazing materials to be used at PPPL.

INTRODUCTION:

This procedure provides the requirements for control, storage, and issuance of welding materials at PPPL, to assure that the proper materials are used, and that materials are properly stored prior to use, in accordance with ENG-037.

DEFINITIONS

Welding Materials – Consumable welding and torch brazing filler materials, including covered electrodes, bare welding wire, brazing filler metal, and torch brazing flux.

Weld Supervisor - Individual responsible for direct supervision of welders and brazers, who is authorized to issue welding materials.

Designee - Individual responsible for issuance of welding materials, who is specifically designated by a Weld Supervisor to do so. A designee may not issue welding materials to himself.

REFERENCES:

ENG-037 General Welding & Brazing Requirements

EQUIPMENT REQUIRED:

Controlled storage area(s), electrode storage oven(s).

PREREQUISITES:

Personnel responsible for utilization of this procedure shall be cognizant of its requirements, to assure proper implementation.

Procedure:

Responsibility

Action

- | | |
|--------------------------|---|
| Welding Engineer | 1. Specifies requirements for welding material storage, issuance, return, reconditioning, and deletion, as defined in this procedure.
NOTE: All welding consumables shall be of domestic origin unless approved by the weld engineer. |
| Weld Supervisor/Designee | 2. Implements this procedure by controlling storage, identification, issuance, return, and reconditioning of welding materials. |
| Welder | 3. Implements this procedure by using only controlled welding materials, and maintaining identification of materials during usage. |
| Weld Supervisor/Designee | 4. Provides controlled storage area for all welding materials, in a clean and dry space, including identification of filler materials by type or grade, oven storage of low-hydrogen type covered electrodes (per manufacturer's recommendations), and controlling issuance of materials to properly qualified personnel, within the specified time limits. |
| Welder | 5. Requests welding materials from controlled storage area, based on qualifications and particular job requirements. |
| Weld Supervisor/Designee | 6. Issues welding materials, based on particular job requirements and welder's qualifications. |

Welder 7. Returns used and partially used welding materials at the end of each shift, except unused low hydrogen electrodes shall be returned within their specific maximum allotted time of issuance. Ensures that filler material identification is maintained, and that work area is clean, with no unused or partially used filler materials remaining at the end of each workday.

NOTE: When using the MIG/FCAW, the wire spools stay with the welding machine.

Weld Supervisor/Designee 8. Returns any unused low-hydrogen electrodes which have been returned within their specific maximum allotted time of issuance to storage ovens for a minimum re-drying period of eight (8) hours. Low-hydrogen electrodes which have been exposed to atmosphere for more than their specific maximum allotted time of issuance, and all filler materials which are dirty, damaged, or inadequately identified, shall be discarded.

Welding Engineer 9 Periodically monitors compliance with this procedure.

TRAINING

Welding Engineer 1. Specifies the appropriate training methods and means below; obtains concurrence of the Associate Laboratory Director for Engineering and Infrastructure; and ensures the training is provided.

- A. Target Audience: Welders, Weld Supervisors
- Instructor: Welding Engineer
- Training Method: Read Only
- Frequency: Once.

RECORDS REQUIREMENTS SPECIFIC TO THIS PROCEDURE

Not Applicable - No Documents to be stored as records are referenced in this procedure.