### TD-D40-JA01

Daily Weld Summary Report

[Effective: 00/00/00, Rev: 0]

## Daily Weld Summary Report Job Aid

**Guidance Document References:** 

- D-40 Weld Inspection
- Form FD-40-A

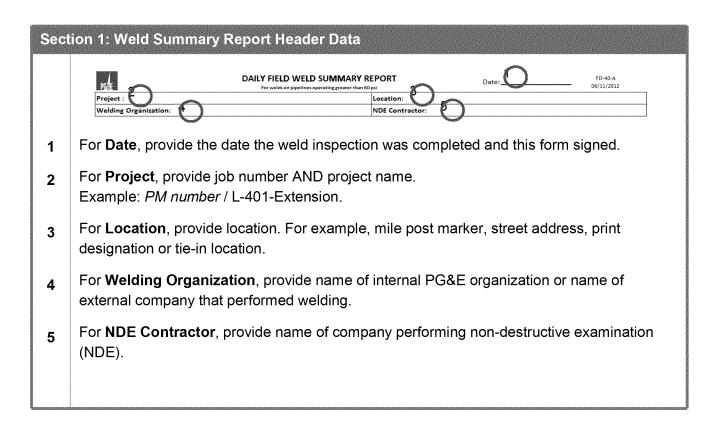
#### Level of Use: ✓Information ❑ Reference ❑ Continuous

#### Table of Contents

Section 1: Weld Summary Report Header Data

Section 2: Identify Weld, Procedure, and Welder

#### Section 3: Inspection Results



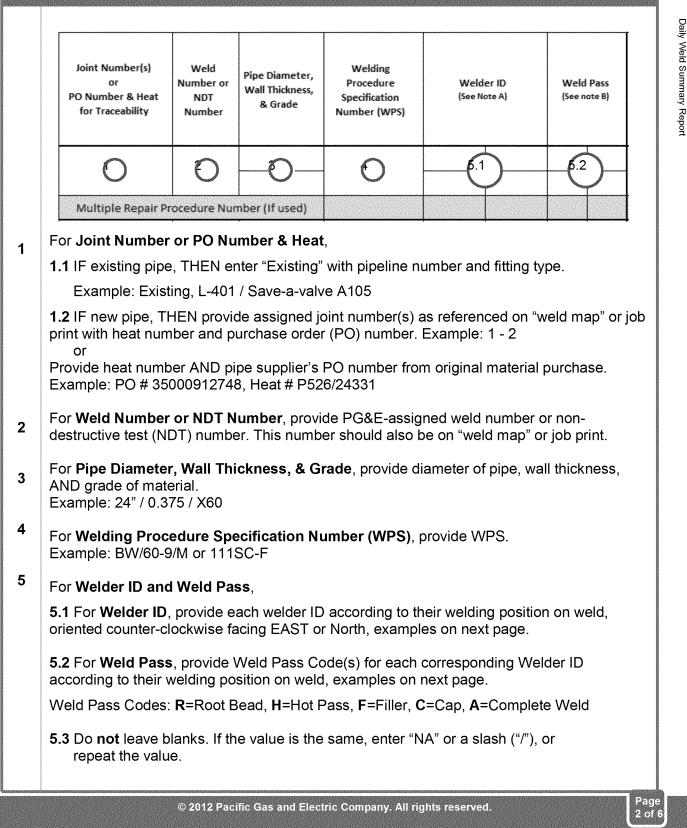


## TD-D40-JA01

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#### Section 2: Identifying Weld, Procedure, and Welder



## TD-D40-JA01

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## PGGE Daily Weld Summary Report Job Aid

Step 5, continued)										
5.4 Examples for fillin	ng out <b>Weld</b>	er ID and N	Neld Pa	<b>ass</b> fie	ds:					
a) One welder comple	eted entire	weld (all fo	ur quarl	ers of	pipe):					
		1 Welder Cre	w							
	Weld	ler ID	Weld	Pass	]					
	Welder 1	/	А	1	1					
	/	/	/	/						
					•					
) One crew of two w	elders. whe	ere each we	elder co	mplete	d one l	nalf o	f the v	veld:		
,	-,	2 Welder Cre								
	Weld		Weld Pass							
	Welder 1	Welder 2	A	A	-					
	/	/	/	/						
		1	I '	l '						
-	crew (Weld		omplete	•			rform	ed roc	t bead a	Ind
-	crew (Welc	<b>ler 3 &amp; 4) c</b> Two (2 Welder) (	omplete	ed filler			rform	ed roc	ot bead a	Ind
	crew (Welc	<b>ler 3 &amp; 4) c</b> Two (2 Welder) (	omplete	ed filler			rform	ed roc	t bead a	ınd
-	crew (Welc	ler 3 & 4) c Two (2 Welder) ( ler ID	omplete	ed filler			rform	ed roo	t bead a	ind
-	crew (Welc	der 3 & 4) c Two (2 Welder) ( ler ID Welder 2	Omplete	Pass R, H			rform	ed roo	ot bead a	ınd
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Section 3: Inspection Results Passes Electrical Characteristics DCEP/DCEN & DC/AC Voltage & Amperage Range **Travel Speed & Direction** Pre & Post-heat Temp Defects Repaired Bevel Cond. & Fit up Released for NDT (Y or NA) Visual weld Defects Electrode Type Time Between NDT Repaired Joint Cleaning NDT Results (If Rejected) Test\* Remarks Record all weld defect codes with welder ID Scap. (See Note C) Vis. Before welding begins, examine weld preparation of pipe and parts to be welded for joint 1 cleanliness, bevel condition, and fit up. For Joint Cleaning, Bevel Conditions, and Fit Up, enter "A" for accepted or "R" for 2 rejected. 2.1 IF Joint Cleaning AND Bevel Conditions AND Fit Up are rejected, do not begin the weld until the rejected condition(s) have been corrected. During welding, compare the following measurements to requirements in the Welding 3 **Procedure Specification:**  A decrease in the minimum preheat, interpass temp. or post-heat requirement. Electrode type and/or shielding gas or flux. An increase in maximum time between completion of the root bead and the start of the second bead. Electrical characteristics, a change from DCEP to DCEN, or DC to AC. Voltage & Amperage ranges. Welding travel speed range and travel direction. For Pre & post-heat Temp, Electrode Type, Time Between Passes, Electrical 4 Characteristics, Voltage & Amperage Range, and Travel Speed & Direction, enter "A" for accepted when weld meets requirements, or "R" for rejected when weld does not meet requirements. 4.1 IF any of these six fields contains an "R" for rejected, THEN 4.1.1 Weld must be cut out. **4.1.2** Enter reason for each rejection with welder ID in Remarks AND state "Cut out. 4.1.3 END of Inspection.



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Sect	ion 3: Inspection Results (Continued)									
5	IF weld is completed AND all previous inspection criteria is "A" for accepted,									
	THEN perform a visual inspection of weld as required by Gas Standard D-40, "Weld Inspection". Use the following defects codes listed below for visual inspection:									
	C = CrackUA = Unacceptable AppearanceAB = Arc BurnIP - Incomplete PenetrationWD = Weld DimensionsIF = Incomplete FusionBT = Burn ThroughUC = UndercutP = PorosityIC = Undercut									
6	For <b>Visual Weld Defects</b> , enter "A" for accepted when weld meets requirements, or "R" for rejected when weld does <b>not</b> meet requirements.									
	6.2 IF there are any visual defect(s), THEN									
	6.2.1 Enter "R" for rejected.									
	6.2.2 Enter applicable weld defect code and welder ID for each defect in the Remarks column.									
	6.2.3 When defect(s) are repaired, THEN re-examine weld for visual defects.									
	<b>6.2.4</b> For <b>Vis. Defects Repaired</b> enter "A" for accepted when weld meets requirements, or "R" for rejected when weld does <b>not</b> meet requirements.									
	6.2.5 IF there are visual defects, THEN									
	NOTE									
	A qualified repair procedure is required to be used whenever repairs are made to a previously repaired area.									
	<ul> <li>Enter applicable weld defect code and welder ID for each defect in the Remarks column.</li> </ul>									
	<ul> <li>Cut out weld and enter "Cut out" in Remarks column OR use a Repair Procedure Specification to repair weld in previously repaired area and fill out next line of form, Multiple Repair Procedure Number with new data.</li> </ul>									
7	For <b>Released for NDT</b> ,									
•	<b>7.1</b> IF <b>no</b> additional NDT is required, THEN enter "NA" for not applicable, and proceed to Step 9 on the next page.									
	<b>7.2</b> IF additional NDT is required, such as radiography (RT), ultrasound (UT), or magnetic particle inspection (MT), THEN enter "Y" for yes, AND hand off weld to NDT personnel.									
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