



Pantex Product Weld Inspection Form (Visual)

(Reference WI 02.03.15.01.01)

(1) Item ID		(2) Work Order/Job #				(3) Date:													
(4) Code (Acceptance Criteria)		(5) Welding Procedure Specification (WPS) #				(6) Base Material Specification/Type													
(7) Location/Supplier		(8) Welder's Signature				(9) Base Metal Heat #			(10) Filler Metal Heat/Lot #										
(11) Joint Identification		(12) Welder Identification	(13) Initial Joint Inspection	(14) WPS Verification	(15) Welder Qualification	(16) Material Control	(17) Final Weld Inspection	(17a) Weld Size/Profile	(17b) Weld Location	(17c) Cracks	(17d) Penetration	(17e) Excess Porosity	(17f) Excessive Under Cut	(17g) Weld Reinforcement	(17h) Root	(17i) Fusion	(17j) Arc Strikes	(17k) Weld Spacing	(17l) Undercut

✓ = Pre-Weld Attributes Verified (13-16)

X = Reject (17a—17l)

(18) Additional Comments:

(19) Inspector Name/Signature

Date

Qualification	Former Certified Welding Inspector	_____
	Certified Welding Inspector	_____
	Senior Certified Welding Inspector	_____
	American Welding Society, Option 3	_____

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Instruction Sheet	
Block Number	Explanation
1	Enter the drawing/piece/part/copy number.
2	Enter the Work Order or Job number.
3	Date of Inspection. If more than one date is required specify all dates.
4	Identify the acceptance criteria (e.g., code) to which inspection occurred. If more than one identify all applicable codes and specify which code applies to each joint in either block 11 or block 18.
5	Enter the WPS number. If more than one Welding Procedure Specifications (WPS) then identify all applicable WPS and specify which WPS applies to each joint in either block 11 or block 18.
6	Identify the base material type/grade/group number. Different base metals must be traceable to the weld joint in which it was used.
7	Enter company name.
8	All welders that perform welds on the product must sign.
9	Enter the base material heat number. Different base metal heat numbers must be traceable to the weld joint in which it was used.
10	Enter the filler material heat or lot number. Different filler material heat or lot numbers must be traceable to the weld joint in which it was used. If autogenously welded then "NA."
11	Identify each joint being welded (piece numbers, view, sheet, etc.). If space is needed duplicate page 1 of this document. If only one welder then "All" may be placed in the block one time to represent all joints.
12	Enter the welder's unique identification symbol for that weld joint (e.g., initials, symbol, etc.).
13	Check this block if an initial joint inspection occurs. (e.g., thickness, joint preparation, root opening, groove design, etc.).
14	Check this block if the welding equipment parameters have been verified to match the WPS.
15	Check this block if the welder's qualifications were verified before welding begins.
16	Check this block if the work area has been verified to have been kept uncluttered so no foreign material (base metal or filler metal) could be introduced.
17	If any of the following inspection criteria (17a—17l) has an "X" placed in the attribute block the weld is rejected for that reason. If marked with "X" repair is needed. Repaired welds shall meet applicable code requirements. If a different weld process from the original is used for the repair, approval must be obtained from Pantex. Repaired weld must meet the original inspection criteria.
17a	Refer to the design drawing for weld size and appropriate code for weld profile acceptance criteria.
17b	The design drawing specifies weld location.
17c	Cracks are never allowed.
17d	The design drawing will specify the amount of penetration. If no number is present beside the weld symbol, it is assumed to be full penetration. (reference AWS A2.4)
17e	Refer to the appropriate welding code for acceptance criteria.
17f	Refer to the appropriate welding code for acceptance criteria.
17g	(Groove welds) Refer to the appropriate welding code for acceptance criteria.
17h	If possible, inspect the root pass of groove welds for fusion, reinforcement, penetration, etc.
17i	There shall be a smooth transition from weld metal to base metal. There shall be no sharp transitions or overlapping weld metal.
17j	Refer to the appropriate section of each applicable code to determine what is permissible. The code may require and describe arc strike repairs and therefore may not require engineering approval.
17k	Weld spacing primarily refers to intermittent welds and shall agree with design requirements. AWS 2.4 implies that welding should start in the middle with the ends tied in; the ends may have different length of weld segments or shorter spacing.
17l	Refer to the appropriate welding code for acceptance criteria.
18	This space is provided for clarifying information if needed.
19	Inspector's name, date, and qualification (1 of 4).