



WORK INSTRUCTION


WELDING PROCESS

REVISION: 00

PROCEDURE NO.: WI-8.2.4.10

DATE EFFECTIVE: 04/15/09

SEQUENCE*	OPERATION DESCRIPTION
1	Verify material/heater part number with visual or dimensional inspection on the first piece followed by a random sample basis.
2	Visually inspect material/weld area for damage.
3	Clean and prepare materials as needed.
4	Adjust welding machine settings to appropriate setup.
5	Verify inert gas pressure is properly set. Adjust as necessary.
6	Visually inspect electrode for damage/defects. Replace or regrind as needed.
7	Adjust electrode to appropriate depth inside the torch.
8	Setup welding workbench as required.
9	Setup ground wire for welding.
10	Adjust torch to ensure proper distance between the electrode and material surface.
11	Ensure proper protective equipment is used during the welding process.
12	Activate the welding process. Use filler rod as needed.
13	Deactivate the welding process once welding is completed.
14	Leave torch positioned by the material for appropriate time after welding is completed.
15	Visually inspect weld quality. Inspection based on the first piece followed by a random sample basis.
16	Clean heater/materials after welding as needed.
*Sequence may vary based on requirements of individual jobs	

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REVISION HISTORY

REVISION	DATE OF	SECTIONS	DESCRIPTION OF CHANGE
00	04/15/09	All	Initial release

AUTHORIZATION

POSITION	HELD BY	AUTHORIZATION SIGNATURE OR INITIALS
Prepared By: Design Engineer	Ryan Lott	<i>Ryan M Lott</i>
Senior Management Representative/ Management Representative:	Abe Joseph	<i>Abe Joseph</i>