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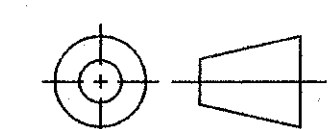
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REVISION HISTORY				
ZONE	REV	DESCRIPTION	DATE	APPROVED

1. FABRICATION, QUALIFICATION, INSPECTION, AND DOCUMENTATION SHALL BE IN CONFORMANCE WITH AWS D1.2:2008.
2. WELDING SYMBOLS IN THE DRAWINGS ARE BASED ON AWS A2.4:2008.
3. ALL WELDING SHALL BE DONE BY AWS-QUALIFIED WELDERS, WELDING OPERATORS, OR TACK WELDERS.
4. DEVIATIONS FROM THE DESIGN DRAWINGS FOR PURPOSE OF PRODUCIBILITY ARE PERMITTED ONLY WITH APPROVAL FROM JLAB OR ITS TECHNICAL REPRESENTATIVE.
5. THE CONTRACTOR'S INSPECTOR SHALL HAVE A CURRENT CERTIFICATION AS AN AWS CERTIFIED WELDING INSPECTOR (CWI) IN CONFORMANCE WITH THE PROVISIONS OF AWS QC1, STANDARD FOR AWS CERTIFICATION OF WELDING INSPECTOR.
6. THE SCOPE OF CONTRACTOR INSPECTION SHALL INCLUDE INSPECTION OF MATERIALS (CLAUSE 5.2, AWS 1.2:2008); INSPECTION OF WPS QUALIFICATION AND EQUIPMENT (CLAUSE 5.3); INSPECTION OF WELDER, WELDING OPERATORS, AND TACK WELDER QUALIFICATIONS (CLAUSE 5.4); AND INSPECTION OF WORK AND RECORDS (CLAUSE 5.5). THE RESULTS OF INSPECTION SHALL BE DOCUMENTED.
7. ALL WELDS SHALL BE VISUALLY INSPECTED AND DOCUMENTED IN ACCORDANCE WITH CLAUSE 5.14, AWS D1.2:2008. THE CONTRACTOR SHALL BE RESPONSIBLE FOR CORRECTION OF ALL DEFICIENCIES IN MATERIAL AND WORKMANSHIP.
8. VERIFICATION INSPECTION, IF DEEMED NECESSARY, SHALL BE PERFORMED BY JEFFERSON LAB.
9. THE FOLLOWING DOCUMENTATION SHALL BE PROVIDED TO JEFFERSON LAB:
 - a. WELDING PROCEDURE SPECIFICATIONS (WPS) (CONFORMING TO AWS D1.2:2008)
 - b. PROCEDURE QUALIFICATION RECORDS (CONFORMING TO AWS D1.2:2008)
 - c. PERFORMANCE QUALIFICATIONS OF WELDERS, WELDING OPERATORS, AND TACK WELDERS (CONFORMING TO AWS D1.2:2008).
 - d. EITHER A CERTIFIED TEST REPORT (MATERIAL TEST REPORT OR MILL CERTIFICATION) OR A CERTIFICATE OF COMPLIANCE OF THE BASE METAL.
 - e. CERTIFIED REPORT OF FILLER METAL.
 - f. CERTIFICATION OF WELDING GAS.
 - g. CERTIFICATION OF AWS CERTIFIED WELDING INSPECTOR, IN ACCORDANCE WITH NOTE (5).
 - h. REPORT OF GENERAL INSPECTION RESULTS, IN CONFORMANCE WITH NOTE (6).
 - i. REPORT OF VISUAL INSPECTION, IN ACCORDANCE WITH NOTE (7).
 - j. WRITTEN WELDING SEQUENCE AND DISTORTION CONTROL PROGRAM ON ANY MEMBER OR STRUCTURE WHERE EXCESSIVE SHRINKAGE OR DISTORTION COULD BE EXPECTED, PRIOR TO THE START OF WELDING ON THAT STRUCTURE.

DOCUMENT CONTROL STAMP IOG	DIM & TOL PER ASME Y14.5 UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: FRACTIONS DECIMAL ANGLES ± N/A .X ± .1 ± .50° .XX ± .01 .XXX ± .005	TRACKING NO. N/A		United States Department of Energy Jefferson Lab Thomas Jefferson National Accelerator Facility Newport News Virginia
		APPROVALS	DATE	
MATERIAL -	THIRD ANGLE PROJECTION 	DRAWN FURCHES	04/12/11	HALL C DOCUMENTS/SPECIFICATIONS WELD NOTES STRUCTURAL ALUMINUM
FINISH MACHINED SURFACES DEBURR & BREAK ALL SHARP EDGES	UNLESS OTHERWISE NOTED	CHECKED <i>[Signature]</i>	04/12/11	
DO NOT SCALE DRAWING		APPROVED <i>[Signature]</i>	4/12/11	REV. -
		APPROVED <i>[Signature]</i>	7/13/11	SCALE NONE USED ON ASSY NO. N/A SHEET 1 OF 1

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