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John C. Stennis Space Center
Stennis Space Center, MS
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SSTD-8070-0014-WELD Rev. B-1
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COMPLIANCE IS MANDATORY

John C. Stennis Space Center STANDARD FOR QUALIFYING WELDERS AND WELDING PROCEDURES

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Responsible Office: NASA Center Operations Directorate		
SUBJECT: Standard for Qualifying Welders and Welding Procedures		

Document History Log

Revision	Date	Originator/ Phone	Description
Basic	10/5/04	R. Nyberg/ 8-1502	Initial Release – supersedes SSC-34-006 Rev. K with the following changes: New document number and format per SPG 1400.1. Added/specified sections per SPG 1400.1 where appropriate throughout the document. In Retests section, deleted sentence “re-qualification will be allowed on three test assemblies, any one of which passes will re-qualify without retest penalty.” In 3.0 added references to SSC Standards. In Criteria for Welder section, specified that records of qualifications shall be retained in the individual’s personnel certification file in the FOS Contractor’s S&MA office and that they would be available to individuals authorized to examine them. In Welding Procedure Qualification section, specified that WPS/PQR records shall be provided by Quality Assurance to Central Engineering Files for each welding procedure and they shall be available to those authorized to examine them and specified welding procedure qualification test per ASME and AWS standards. Changed Table Notes section to “NOTES”. Added Records and Forms section per SPG 1400.1. Added Acronyms and Abbreviations list. Deleted Table 1 - Test for Welder Qualification. In 6.1.A.2 – Plate – deleted weld position 2G. In NOTE 1: deleted weld position 2G. In Sections 7.A.2 and 7.B, changed the amount of time (from 12 months to 6 months) allowed in which a specific weld has not been performed before a welder must be re-qualified.
A	1.19.10	Doug Dike x8-2803	Formatted in accordance with SPR 1400.1. Updated referenced documents. Sections 1.0, 4.0.a.2 and 4.0.a.3: Braze reference removed. Section 5.0: Added “welder must have correctable 20/20 vision. Section 6.2.1a and b: Added requirements referenced in STP-8810-0012,

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			STP-8810-0013, and SSTP-8810-0028. Section 6.2.1d: Added how number is determined. Section 6.2.1.3: Changed reference for bend tests from QW-161.3 to QW-160. Section 7.0c.1 Updated immediate retest. Section 8.3: Qualification updated. Section 8.4: deleted NOTE 1: For tests in the 3G and 4G positions (plate), mechanical testing or radiographic testing shall be per AWS D1.1 or ASME Section IX. NOTE 2: For tests made on pipe in the 2G and 5G or in the 6G position, mechanical testing or radiographic testing shall be per ASME Section IX. NOTE 3: For T-1 steel, two (2) tensile specimens shall be taken from each test assembly welded, in addition to the other qualification tests. NOTE 4: When a welder is to be qualified to weld on stainless steel (P-8 base material), carbon steel plates or pipes of P-1 material may be substituted for the performance test and welded with austenitic electrodes (A-8 or A-9 of table QW-442 ASME Section IX). NOTE 5: When a welder is required to weld on material of lesser or greater thickness, the welder and welding procedure must be re-qualified per the applicable code.
B	1.06.15	Doug Dike X8-2803	Five-year review. Updated references and acronyms. Administrative changes required. Responsible Organizations reflected on the cover sheet have been revised as follows: Safety and Mission Assurance, Responsible Organization, with concurrence by Project Management Division, Operations and Maintenance Division, and Engineering and Test Directorate. 6.2.1.d.1, Weld Shop Supervisor among those approved to assign sequential number on the process plan to be stamped on the test coupon by the Inspector. 6.2.2.4, added Welder Continuing Proficiency requirement. "FOSC" changed to "NASA or its designee" in all references throughout document.
B-1	02.12.16	R. Carol Wolfram X8-1164	Administrative change. Replaced "FOSC" and "NASA or its designee" with "SACOM" throughout document.