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COMPLIANCE IS MANDATORY

John C. Stennis Space Center GAS TUNGSTEN ARC WELD (GTAW) PROCEDURE FOR CARBON STEEL (P-1, GROUP NO. 1 OR 2)

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	Effective Date:	August 15, 2017
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Responsible Office: NASA SSC Center Operations Directorate		
SUBJECT: GTAW Procedure for Carbon Steel (P-1, Group 1 or 2)		

Document History Log

Revision	Date	Originator/ Phone	Description
Basic	04.03.2012	Doug Dike Ext. 8-2803	Initial release. Supersedes SSC-34-008.
A	10.22.2015	Doug Dike Ext. 8-2803	References and acronyms updated. Revised cover sheet to reflect approval by NASA SSC Center Operations Design & Construction Project Management Division; and concurrence by NASA SSC Center Operations Directorate Operations and Maintenance Division, NASA SSC Engineering & Test Directorate, and NASA SSC Safety & Mission Assurance. WPS/PQR attachments clarified.
A-1	08.15.2017	George Smith 8-7680	Administrative changes to attachments to change contractor from FOSC to SACOM.

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1.0 PURPOSE

This John C. Stennis Space Center (SSC) standard (SSTD) provides for a qualified American Society of Mechanical Engineers (ASME) weld procedure of Gas Tungsten Arc Welding (GTAW) of carbon steel pipe or plate for 0.1875" to 1.50" wall thickness using argon as a backing gas.

2.0 APPLICABILITY

This SSTD is valid for welding of all carbon steel pipe or plate that will be used in, but not limited to, nitrogen, helium, air, and hydrogen service. This SSTD applies to all contractor and subcontractor personnel involved with the welding of carbon steel pipe.

3.0 REFERENCED AND APPLICABLE DOCUMENTS

Applicable documents shall be the latest version unless otherwise specified.

ASME Boiler and Pressure Vessel Codes, Section IX, *Welding, Brazing, and Fusing Qualifications*

SPR 1440.1, *SSC Records Management Program Requirements*

SPR 8715.1, *SSC Safety and Health Program Requirements*

SSTD-8070-0013-WELD, *Classes of Welding Inspection*

SSTD-8070-0005-CONFIG, *Preparation, Review, Approval and Release of SSC Standards*

SSTD-8070-0014-WELD, *Qualifying Welders and Welding Procedures*

4.0 RESPONSIBILITIES

Responsibilities for the use and control of this SSTD and for the review and approval of revisions or cancellation of this SSTD shall be as specified in SSTD-8070-0005-CONFIG and the applicable documents referenced therein.

5.0 REQUIREMENTS AND PROCEDURES

- All procedures shall be performed in compliance with applicable requirements in SPR 8715.1. If ever there is a conflict between this SSTD and the SPR, the SPR takes precedence.
- Items denoted as essential variables in the attached weld procedure specifications (WPS) shall not be altered when using the WPS. An alternate WPS may be used only if approved prior to use by the NASA SSC Center Operations Directorate Project Management Division (PMD), the NASA SSC Engineering and Test Directorate (E&TD), and the NASA SSC Safety and Mission Assurance (S&MA) Office.