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John C. Stennis Space Center
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August 2017

COMPLIANCE IS MANDATORY

John C. Stennis Space Center GAS TUNGSTEN ARC WELDING (GTAW) PROCEDURE FOR P-8 STAINLESS STEEL TO P-1 CARBON STEEL

Approved by:

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	Effective Date:	August 17, 2017
	Review Date:	April 11, 2022
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Responsible Office: NASA SSC Center Operations Directorate		
SUBJECT: GTAW Procedure for P-8 Stainless Steel to P-1 Carbon Steel		

Document History Log

Status/Change/ Revision	Change Date	Originator/Phone	Description
Basic	05.22.2012	Doug Dike x8-2803	Initial release, supersedes SSC-34-018.
A	04.11.2017	Larry DeQuay X8-1956	Five-year review. Updated cover sheet to reflect approval by NASA SSC PMD; with concurrence from NASA SSC E&TD, NASA SSC OMD, and NASA SSC S&MA. Administrative changes throughout document. Updated acronyms, as well as WPS, PQR, Certificate of Analysis, and WPQ attachments.
A-1	8.17.2017	George Smith X8-1680	Administrative change on attachments to change contract named 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 for Gas Tungsten Arc Welding (GTAW) of P-8 Stainless Steel to P-1 Carbon Steel pipe or plate with a thickness range of 0.1875" to 1.00".

2.0 APPLICABILITY

This SSTD applies to all National Aeronautics and Space Administration (NASA) SSC contractor and subcontractor personnel involved in the GTAW welding of stainless steel to carbon steel.

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

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

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.

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