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John C. Stennis Space Center
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**SSTD-8070-0034-WELD Rev. Basic
JULY 2014**

COMPLIANCE IS MANDATORY

John C. Stennis Space Center ASME Procedure For GTAW Welding Monel Alloy (P-42)

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SUBJECT: ASME Procedure For Welding Monel Alloy		

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1.0 PURPOSE

This John C. Stennis Space Center (SSC) standard (SSTD) outlines the qualified Gas Tungsten Arc Welding (GTAW) procedure for use in welding Monel Alloy (ASME P-No. 42) at SSC.

2.0 APPLICABILITY

This SSTD applies to all contractor and subcontractor personnel involved with the welding of Monel Alloy (ASME P-No. 42).

3.0 REFERENCES

All references are assumed to be the latest version unless otherwise indicated.

ASME Boiler and Pressure Vessel Codes, Section II, *Materials*

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

ASTM B127, *Standard Specification for Nickel-Copper Alloy (UNS 4400) Plate, Sheet, and Strip*

ASTM B163, *Standard Specification for Seamless Nickel and Nickel Alloy Condenser and Heat-Exchanger Tubes*

ASTM B164, *Standard Specification for Nickel-Copper Alloy Rod, Bar, and Wire*

ASTM B165, *Standard Specification for Nickel-Copper Alloy (UNS N04400) Seamless Pipe and Tube*

ASTM B366, *Standard Specification for Factory-made Wrought Nickel and Nickel Alloy Fittings*

ASTM B564, *Standard Specification for Nickel Alloy Forgings*

MIL-T-1368, *Military Specification for Tube and Pipe, Nickel-Copper Alloy, Seamless and Welded*

SPR 1440.1, *SSC Records Management Program Requirements*

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

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

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

4.0 RESPONSIBILITIES

- a. Users of this SSTD shall comply with its requirements, ensure use of the correct version of this Standard and the documents it references, and inform the appropriate organization of needed changes in accordance with SSC Standard SSTD-8070-0005-CONFIG.
- b. Responsibilities for the use and control of this SSTD and for the review and approval of revisions or cancellation of this Standard shall be as specified in SSTD-8070-0005-CONFIG and the applicable documents referenced therein.