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COMPLIANCE IS MANDATORY

John C. Stennis Space Center ASME PROCEDURE FOR WELDING MONEL ALLOY (P-42) TO CARBON STEEL (P-1)

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Responsible Office: NASA SSC Center Operations Directorate	
SUBJECT: ASME Procedure for Welding Monel Alloy (P-42) to Carbon Steel (P-1)	

Document History Log

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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 to Carbon Steel at SSC.

2.0 APPLICABILITY

This SSTD applies to all contractor and subcontractor personnel involved with the welding of Monel Alloy to Carbon Steel at SSC.

3.0 REFERENCES

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

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

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

ASME B31.3, *Process Piping*

ASTM A105, *Standard Specification for Carbon Steel Forgings for Piping Applications*

ASTM A106, *Standard Specification for Seamless Carbon Steel Pipe for High Temperature Service*

ASTM A234, *Standard Specification for Piping Fittings of Wrought Carbon Steel and Alloy Steel for Moderate and High Temperature Service*

ASTM B127, *Standard Specification for Nickel-Copper Alloy (UNS N04400) 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 B467, *Standard Specification for Welded Copper-Nickel Pipe*

ASTM B564, *Standard Specification for Nickel Alloy Forgings*

ASTM B725, *Standard Specification for Welded Nickel (UNS N02200/UNS N02201) and Nickel Copper Alloy (UNS N04400) Pipe*

ASTM B730, *Standard Specification for Welded Nickel (UNS N02200/UNS N02201) and Nickel Copper Alloy (UNS N04400) Tube*

AWS Welding Handbook

FED QQ-N-281, *Federal Specification: Nickel-Copper Alloy Bar, Rod, Plate, Sheet, Strip, Wire, Forgings, and Structural and Special Shaped Sections*

MIL-N-24106, *Nickel-Copper Alloy Bars, Rods and Forgings*