

<b>Material Standards &amp; Specifications</b>
<b>Specialty Products Company</b>



<b>MSS</b>	<b>4.004</b>	<b>Weld Section Test</b>
<b>Approved by:</b>	<b>CCH</b>	
<b>Revision:</b>	<b>A</b>	
<b>Date:</b>	<b>07/10/08</b>	

**Scope:**

This test is applicable to welded assemblies only. This test is run for the purpose of detecting the presence weld imperfections. This is a destructive test. This specification replaces IP-065.

**Procedure:**

- There shall be three (3) samples tested per welding lot.
- Linear welds 0.0-1.0[in] (25[mm]) long:  
Section near the center of the weld.
- Linear welds 1.0-3.0[in] (25-75[mm]) long:  
Section in two (2) places: near one end & near the center of the weld.
- Linear welds over 3.0[in] (75[mm]) long:  
Section in three (3) places: near the ends & near the center of the weld.
- Circular welds (around bosses, tubes, bars, etc.):  
Section four places approximately 90° apart.  
One section should be at the weld termination.
- Verify complete weld filler penetration.
- No cracks or voids allowed in welds.
- Weld undercut not to exceed 0.03[in] (0.8[mm]).
- Test sections must be identified as to date & purchase order.
- Submit test records with the shipment, prior to shipment, or as requested on the Purchase Order.
- Test records & sections must be retained for not less than three (3) years. Photographs or samples of tested sections may be requested at the discretion of Specialty Products Quality Services.
- Failure of any of the samples requires rejection of the entire lot. Root cause evaluation and corrective action must be documented and submitted to Specialty Products Company for review and approval before proceeding.