



**DOCUMENT MANAGEMENT CONTROL SYSTEM
DOCUMENT ACTION REQUEST**

FORM L-0103.11#
(Rev. 08-96 - #00)

10. DAR No.: 15037
3. Page 1 of

1. Requester: J.L. Hopla Phone: 6-3306 2. Date: 3/10/97
Org. No.: 5140 Mail Stop: 5233

4. Document ID: MCP-4.8.0.22 Title: WELD FILLER MATERIAL ISSUANCE AND CONTROL
Revision ID: 0

5. Type of Action: New Document Revision Deletion
Field Change: Permanent Temporary If temporary: number of cycles/expiration date:

6. Proposed Action: For new document, provide summary of proposed contents. For revisions, rewrite paragraph(s) or attach revised copy and state "revise per attached copy."

Item	Page No./ Paragraph	Description	Justification
1	ALL	New Header (Lockheed Martin Idaho Technologies Co). revised format to comply with STD-1	EDITORIAL
2	throughout	Changed WINCO forms and references to INEL or LMITCO forms and references.	EDITORIAL

7. Is USQ evaluation needed? yes no 8. Is RCRA permit/application modified? yes no unknown
If yes, attach evaluation. If yes or unknown attach INEL Form L-0158# Nancy E Reynolds 3-13-97
Signature Date Signature/Date

9. Proposed Action Review: Accept Reject Attach reason for rejection.
Printed Name: Signature: Org No.: Date:

11. Reviewer Concurrence

Printed Name:	Discipline/ Org No.:	Date:	Engineering	
Signature: <u> </u>	Operations	<u>Nancy Hayes</u>	Editor	<u>3-18-97</u>
<u>Q&PA 2/19/97</u>	ES&H	<u>Nancy Hayes</u>	Operator (Writing Team)	
	Q&PA		Fac. Engineer (Writing Team)	

12. Final Document Approval: Document Owner Signature: Date: 13. Requested Distribution Date:

14. Recommended Implementation Training Needs:
16. Released by: 17. DMCS Location: 18. Release Date: 15. Request would affect:

Management Control Procedure ICPP--D&RI	WELD FILLER MATERIAL ISSUANCE AND CONTROL	Identifier: CPP-MCP-4.8.0.22 Revision: 1 Page: 1 of 5
Document Control Center (208) 526-3501	Document Owner/Approver: J.L. Hopla	Effective Date: DRAFT

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DAR Number: R **1. PURPOSE**

To issue and control certified weld filler material (see definition) in compliance with the INEEL Welding Manual.

2. SCOPE AND APPLICABILITY

Certified weld filler material consumed in **CPP Maintenance** welding activities is issued from established controlled access areas by a *weld filler material issuer* (see def.). Material is issued only to welders, brazers, or welding operators (hereafter referred to collectively as "welders") who are certified to the appropriate weld procedure specification (WPS). This procedure applies to all **CPP Maintenance** welding personnel.

3. PREREQUISITES

- 3.1 All *weld filler material* (see def.) must have applicable certification records on file prior to being issued to the welder (see the INEL Welding Manual, Volume 2 for storage requirements for certified weld filler materials).
- 3.2 Filler material must not be transferred from one welder to another, other than in contaminated environments. Certified weld material can be withdrawn in a certified welder's name and transferred to that person if s/he is in a limited access or contaminated area. Spooled wire can be issued to more than one welder at a time.
- 3.3 Welders must use only that certified weld filler material obtained from the *weld filler material controlled access storage area* (see def.) for welding activities.
- 3.4 When required by the quality level, traceability of consumed certified weld filler material must be maintained in the quality inspection record.
- 3.5 Material heat numbers, sizes, or material types must not be intermixed.
- 3.6 Loose filler material or partially consumed filler material must not be laying about or be outside of controlled containers. This does not apply in contaminated areas.

DOCUMENT CATEGORY III

INEL FORM L-0412.9# (08-96 - Rev. #00)

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3.7 CPP Maintenance management must grant approval for issuance of weld filler materials for other than CPP Maintenance welding activities. The requirements for form **ICPP-5549**, Weld Filler Material Withdrawal Log, will remain applicable.

4. INSTRUCTIONS

4.1 Pre-job Checks and Actions

- 4.1.1 **Welder:** IF all weld procedure specifications and corresponding weld filler materials are not specified in the work package, THEN request cognizant engineer or planner to provide the needed information.
- 4.1.2 Present work package documents specifying the required weld procedure specifications and weld filler material to the weld filler material issuer.
- 4.1.3 **Weld Filler Material Issuer:** Verify current welder qualification for the applicable weld procedure specifications by checking the personnel qualification expiration date as shown on the INEL Welder Certification Status Report.

4.2 Weld Filler Issuance

- 4.2.1 **Weld Filler Material Issuer:** Issue weld filler material to welders.
- 4.2.2 Issue the weld filler material specified in the work package.

NOTE 1: *Quantity issued, size, material grade, and work order number portions may be completed by the craftsman making the withdrawal.*

NOTE 2: *Form **ICPP-5549** is retained as a permanent record.*

- 4.2.3 Record all information called for on form **ICPP-5549**.

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- 4.2.4 Issue covered and bare straight filler material (for shielded material arc welding [SMAW] and gas tungsten-arc welding [GTAW]) in a weld filler material issue container which is color-coded to ensure that cross contamination of stainless steel by carbon steel does not occur.

NOTE: *Spooled wire for gas metal arc welding (GMAW) and flux core arc welding (FCAW) does not require a filler material issue container.*

- 4.2.5 Tag each weld filler material issue container or spool, ensuring the tag contains the following information:

- A. size
- B. material grade
- C. heat number
- D. QA&O inspection record number
- E. work order number
- F. welder identification (for spooled wire include each welder identification if checked out to more than one welder).

- 4.2.6 **Welder:** Ensure the issue tag accompanies the container or spool at all times until it is returned to the weld filler material controlled access storage area.

4.3 Weld Filler Control

- 4.3.1 **Welder:** Keep all straight length filler material in the weld filler material issue container

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NOTE: *Straight length filler material may be withdrawn on either a daily basis or on a job-by-job basis.*

4.3.2 **IF** straight length filler material has been withdrawn on a job-by-job basis,
THEN at the end of each shift or work period, store the unused portion in its issue container in the controlled access storage area.

NOTE: *Although spooled filler material is usually withdrawn on a job-by-job basis, at the completion of a job the spool may be left on the machine.*

4.3.3 **Weld Filler Material Issuer and Welder:** **IF** a spool of weld filler is left at a machine,
THEN perform appropriate issuance actions.

4.3.4 Before a welder uses the machine,
GO TO step 4.1.1 and perform all applicable steps through to step 4.3.5.

4.3.5 Remove the previous issue tag and apply new issue tag for the new work package.

5. RECORDS

Form ICPP-55439, Weld filler Material Withdrawal log

6. DEFINITIONS

Weld Filler Material. Filler material that may consist of covered electrodes, bare welding rods, spooled wire, consumable inserts, and brazing filler materials.

Weld Filler Material Controlled Access Storage Area. The controlled access area in CPP-662/663 or any satellite controlled access area where certified weld filler material is stored and controlled.

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Weld Filler Material Issuer. Management-assigned individual or designated alternate (such as the shift foreman) who, being familiar with established filler material storage and control procedures, issues weld filler material to welders from the weld filler material controlled access storage area or satellite areas. This person is independent of the welder receiving the filler material.

7. REFERENCES

None.

8. APPENDICES

None.

DOCUMENT CATEGORY III

Lockheed Martin Idaho Technologies Company

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Procedure Basis Document ICPP--D&RI	WELD FILLER MATERIAL ISSUANCE AND CONTROL	Identifier: B-4.8.0.22 Revision: 1 Page: 1 of 1
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The following writing team members must approve all substantive changes to MCP-4.8.0.22.

The following subject matter experts (SMEs) helped create revision 1 of MCP-4.8.0.22.

Writing Team		SMEs	
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Operator/Technician:		ES&H:	
Facility Engineer:	O. O. Gaddis	ES&H:	
		Q&PA:	
		Engineering:	

Step Number	Step Basis	Information Source
4.1	Certified weld filler material is that which meets the material specification requirements and is traceable...to the material certification.	INEL Welding Manual, section 8, 3.2.
4.2	Filler metals must not be transferred from one welder to another, unless welders are in a contaminated environment.	Section 8, 7.1.
4.3	Weld filler must be issued only from a controlled access storage area....	Section 8, 7.2.
4.4	All weld fill is subject to inspection and acceptance as may be required by project specifications.	Section 8, 5.1.
4.5	Refer to step 4.1.	Section 8, 3.2.
4.6	All weld filler materials must be stored in their original containers until they are required to be used.	Section 8, 6.4.
4.7	...implement this or an approved equal procedure to control weld filler material to be used....	Section 8, 4.1
5.1, 5.2	The cognizant engineer must specify the weld filler material requirements that are applicable....	Section 8, 4.2
5.3	Only welders, welding operators, and/or brazers are authorized to withdraw weld filler material.	Section 8, 4.3
5.4	Filler material must be issued to each qualified welder or welding operator for use in accordance with the fill metal specifications designated.... Weld filler must be only from a controlled access storage area, using a filler material withdrawal form....	Section 8, 7.1 and 7.2
5.5	Weld filler material must be stored in a manner that is clearly identifiable and segregated by classification, size and heat or lot number.	Section 8, 6.4.4
5.6, 5.7	All weld filler metal withdrawal form(s), issue slip, or identification tag must accompany all weld filler metal to maintain traceability.	Section 8, 7.3.2

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Step Number	Step Basis	Information Source
5.8	All weld filler materials must be stored in their original containers until they are required to be used.	Section 8, 6.4.4.
5.9	Straight length... filler metal may be withdrawn either on a daily basis or on a job basis with unused filler metal kept at the job site then returned at the completion of the job.	Section 8, 7.3
5.10	Weld filler material traceability to receiving inspection documents must be maintained until weld filler material is consumed.	Section 8, 6.5