



BRAZING PROCEDURE SPECIFICATION

BPS: 6000-107/108-F102 **REV. NO.:** 0 **DATE:** 8/10/2006 ****APPLICABILITY****
BRAZING PROCESS: TB and TB **ASME:** X **AWS:** **OTHER:**
SUPPORTING PQR: Z-1-2-1-TB-107-1

JOINT: This BPS shall be used in conjunction with the General Welding Standards (GWS) and Welding Fabrication Procedure (WFP) sections and criteria for joint details, repairs, NDE, inspection etc.

Joint Type: Socket/lap **Class:** Brazed joint
See GWS 1-06 and WFP's for joint details **Preparation:** Abrasive cloth/wire brush
Clearance: ≈ .003 **Brazed Joint Overlap Min.:** 4T **Max.:** 1.5"

FILLER METALS:

AWS Specification: 5.8 and 5.8 **AWS Class:** BAg-7 and BAg-7
F No: 102 and 102 **A No:** N/A **Size:** 1/16 3/32 1/8
Filler Material Type: Solid **Insert:** N/A **Insert Type:** N/A
Filler Material Notes: Flat or round filler using Eutectic Albraze 850 or equiv. (AWS Type 3)

BASE MATERIALS:

	P/S No. 107	Gr No. N/A	to: P/S No. 108	Gr No. N/A
Spec. B-152 Cu- Pipe, plate, sheet & st	Grade: All	to: Spec. B-169 CuAlFe- Pipe, plate, sheet	Grade: All	
Qualified Thickness Range: AWS:	0.000 thru	0.000	ASME: 0.125 thru	0.500

FLOW POSITIONS:

Qualified Positions: AWS: N/A **ASME:** FF HF VF **Flow Direction:** V-UP Flow

BRAZING FLUX, FUEL GAS, or ATMOSPHERE:

Flux: Type or Trade Name: FB3-x
Fuel Gas: Acet/Oxy **Flame:** Neutral **Braze temp. °F** 1145 to 1400
Backing Gas: N/A **Composition:** 0 % **Backing Gas Flow cfh:** 0 to 0

POST BRAZE HEAT TREATMENT:

Heat Treatment Temperature: 0 °F **Max. Time at Temperature:** 0

BRAZING TECHNIQUE: For fabrication specific requirements such as fitup, cleaning, grinding, PWHT and inspection criteria refer to Volume 2, Welding Fabrication Procedures

Cleaning Method: Abrasive cloth/wire brush **Tip Size:** #3

APPROVAL: Signatures on file at FME DES **DATE:** 8/10/2006

Comments: This BPS developed as a result of S&W review of LANL Welding Program and Procedures. T = the thickness of the thinner member to be brazed.

Use of LANL Welding Procedures and Welder Qualifications for non-LANL work shall be at the sole risk and responsibility of the Subcontractor, and the Subcontractor shall indemnify and save LANL and the Government harmless from any and all claims, demands, actions or causes of action, and for any expense or loss by reason of Subcontractor's and their employees possession and use of LANL procedures and qualifications.