



BRAZING PROCEDURE SPECIFICATION

BPS: 6000-xxxx-101/107-F102 **REV. NO.:** 0 **DATE:** 8/5/2008 ****APPLICABILITY****
BRAZING PROCESS: TB and TB **ASME:** X **AWS:** **OTHER:**
SUPPORTING PQR: 6000-101/107-F012

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:** Clean to bright shiny metal
Clearance: .002 -.005 **Brazed Joint Overlap Min.:** 4T **Max.:** 1.312

FILLER METALS:

AWS Specification: 5.8 and 5.8 **AWS Class:** BAg-7 and BAg-5
F No: 102 and 102 **A No:** **Size:** 3/32 3/32
Filler Material Type: Solid **Insert:** N/A **Insert Type:** N/A
Filler Material Notes:

BASE MATERIALS:

	P/S No. 101	Gr No.	to: P/S No. 107	Gr No.
Spec. ASTM A-53/A-106	Grade:	to: Spec. ASTM B-88		Grade:
Qualified Thickness Range: AWS:	thru	ASME:	0.030	thru 0.120

FLOW POSITIONS:

Qualified Positions: AWS: N/A ASME: All **Flow Direction:** Up or down

BRAZING FLUX, FUEL GAS, or ATMOSPHERE:

Flux: Type or Trade Name: FB3A
Fuel Gas: Acetylene **Flame:** Neutral **Braze temp. °F** 1225 to 1370
Backing Gas: N/A **Composition:** % **Backing Gas Flow cfh:** to

POST BRAZE HEAT TREATMENT:

Heat Treatment Temperature: N/A °F **Max. Time at Temperature:** N/A

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 to 6

APPROVAL: Signatures on file at ES DE **DATE:** 8/5/2008

Comments:

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.