

## BRAZING PROCEDURE SPECIFICATION

**BPS:** 6000-107-F102 **REV. NO.:** 1 **DATE:** 8/10/2006 \*\***APPLICABILITY**\*\*

BRAZING PROCESS: TB and TB ASME: X AWS: OTHER:

**SUPPORTING PQR: 600-102** 

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: Wire Brush/Abrasive Cloth

Clearance:  $\approx 0.003$  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:** Size: 1/16 3/32 1/8

Filler Material Type: Solid Insert: N Insert Type: N/A

Filler Material Notes: Use with Floride Flux

**BASE MATERIALS:** 

**P/S No.** 107 **Gr No.** All **to: P/S No.** 107 **Gr No.** All

Spec. B-88 Cu- Tube Grade: 120 to: Spec. B-88 Cu- Tube Grade: 120

Qualified Thickness Range: AWS: 0.000 thru 0.000 ASME: 0.046 thru 0.190

FLOW POSITIONS:

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

BRAZING FLUX, FUEL GAS, or ATMOSPHERE:

 $\textbf{Flux: Type or Trade Name:} \quad AWS \ Class \ FB3-x$ 

Fuel Gas: Acteylene Flame: Neutral Braze temp. °F 1150 to 1600

**Backing Gas:** 0 **Composition:** 0 % **Backing Gas Flow cfh:** 0 **to** 0

POST BRAZE HEAT TREATMENT:

Heat Treatment Temperature: <sup>0</sup> °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: Wire Brush Tip Size: #3

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

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**Comments:** 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 posession and use of LANL procedures and qualifications.

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