



BRAZING PROCEDURE SPECIFICATION

BPS: 6000-102/107-F102 **REV. NO.:** 0 **DATE:** 2/7/2008 ****APPLICABILITY****
BRAZING PROCESS: TB and TB **ASME:** X **AWS:** X **OTHER:**
SUPPORTING PQR: 6000-8/S107-F102

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: Lap/Socket **Class:** Full flow
See GWS 1-06 and WFP's for joint details **Preparation:** Square tube ends and abrasive cloth/SS wire brus
Clearance: 0.003 **Brazed Joint Overlap Min.:** 4T* **Max.:** 1.5"

FILLER METALS:

AWS Specification: 5.8 and 5.8 **AWS Class:** BAg-5 and BAg-7
F No: 102 and 102 **A No:** N/A **Size:** 3/32 1/8
Filler Material Type: Solid **Insert:** N/A **Insert Type:** N/A
Filler Material Notes:

BASE MATERIALS:

	P/S No. 102	Gr No. 1	to: P/S No. 107	Gr No. 1
Spec. A-312 - SS-Smls & welded pipe	Grade: All	to: Spec. B-88 Cu- Tube		Grade: All
Qualified Thickness Range: AWS:	0.036 thru	0.150	ASME: 0.036 thru	0.150

FLOW POSITIONS:

Qualified Positions: AWS: All ASME: FF, HF, VU, VD **Flow Direction:** V-Up/V-dn

BRAZING FLUX, FUEL GAS, or ATMOSPHERE:

Flux: Type or Trade Name: FB3A or FB3C
Fuel Gas: Acetylene **Flame:** Neutral **Braze temp. °F** 1150 to 1600
Backing Gas: N/A **Composition:** 0 % **Backing Gas Flow cfh:** 0 to 0

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/SS wire brush/file **Tip Size:** #5 or 6

APPROVAL: Signatures on file at FME DES

DATE: 2/7/2008

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 possession and use of LANL procedures and qualifications.