



GCS

PROCESS SPECIFICATION: L-3 GCS WELDING STANDARDS

1.0 SCOPE:

This specification details the specifications and expectations for the welded material.

2.0 ORDER OF PRECEDENCE:

In the event of a conflict between the text of this document and the references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

3.0 PLUG/GROOVE/FILLET WELD(S):

- 3.1** Design of welded connections, fabrication processes, inspections and qualifications shall be in accordance with AWS D1.2/D1.2M or equivalent SAE specification.
- 3.2** Parts may be located using SEMI-PERFS.
- 3.3** Plug welds to withstand a pull test of at least 300 lbs in shear on each weld tab in the direction towards the opening without damage to the part.

4.0 SPOT WELDS(S):

- 4.1** Design of welded connections, fabrication processes, inspections and qualifications shall be in accordance with AWS D82M:200X or equivalent SAE specification.