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Revisions:

Rev	Originator / Date	Revised / Date	Approval / Date:	Description:
1	RPS / 8/20/13		REH 8/28/13	Originated

WELDING & BRAZING REQUIREMENTS

Section 1 shall apply to general metal joining requirements

Section 2 shall apply to fusion welding requirements

Section 3 shall apply to resistance welding requirements

Section 4 shall apply to electron beam welding requirements

Section 5 shall apply to brazing requirements

1. General Requirements

1.1 The material supplied on this purchase order contains welding or brazing specifications included in this note, and shall comply with the following requirements.

1.2. Source of welding or brazing, per the applicable specifications listed below, shall be performed by a Caton Connector Approved Welding or Brazing Supplier.

1.2.1 The Caton Connector approved Welding/Brazing supplier listing is located on the Caton Connector Quality Notes website adjacent to this Quality Note. Contact your Caton Connector buyer with any questions pertaining to this Quality Note.

1.2.2 Each supplier shall pass an initial audit for inclusion on the approved welding and brazing supplier list. Continued listing requires that the supplier pass a surveillance audit not to exceed 3 years. Audits may be held on site or remotely at the discretion of the auditor.

1.2.3 NADCAP accreditation may serve as either the initial or surveillance audit, provided that a supplementary audit, desktop or other, evaluate the supplier's compliance to WS 33739 and other unique requirements. Caton Connector reserves the right to perform a weld audit at any time when the supplier's performance is found to be deficient in any manner.

This document is an integral part of the contract (purchase order), which calls it out. The revision in effect at the time the purchase order was placed applies.



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1.3 Where ASME Boiler and Pressure Vessel Codes are specified, welding shall be performed by ASME certified sources. To access the list of ASME certified sources: <http://cstools.asme.org/holdersearch/>

1.4 Approval may be granted to weld to a specific specification, multiple specifications, product family or part number. Contact your Caton Connector buyer for approval

1.5 This Quality Note and the associated approved supplier list does not apply to welding and brazing specifications not specifically included in the Quality Note.

1.6 Nondestructive Test, if applicable – All Nondestructive Test, for example radiography, penetrant, magnetic particle or ultrasonic inspections, shall be in accordance with Quality Note TC.

2. Fusion Welding Requirements

2.1 Governing Documents

2.1.1 AWS D17.1 as modified by WS-33739 Caton Connector Aerospace Fusion Welding Requirements is the governing document where WS-23719, G577917, MIS-47201, AMS-STD-2219, MIL-STD-2219, MIL-W-8604, MIL-W-8611 or AWS D17.1 is specified in the technical data package (TDP), see Figure 1. Specifications AWS D1.1, AWS D1.2, AWS D1.6 or AWS D9.1 shall be modified by the appropriate appendix of WS33739.

2.2 Successfully passing an audit conducted to the requirements of AWS D17.1 will result in approval to perform AWS D17.1 and the Technical Data Package imposed AWS D1.1, AWS D1.2, AWS D1.6 or AWS D9.1 as modified by WS33739.

3. Resistance Welding Requirements (Spot and Seam)

3.1 SAE AMS-W- 6858 was cancelled November 2007 and was superseded by AWS D17.2.

3.2 Where SAE AMS-W- 6858 is specified in the technical data package, welding in accordance with SAE AMS-W- 6858 or AWS D17.2 will be accepted until June 30, 2010. After this date only AWS D17.2 will be permitted.

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4. Electron Beam Welding Requirements

4.1 Electron Beam Welding shall comply with the applicable specification (AMS-2680 or AMS-2861), as specified in the technical data package.

4.2 Electron Beam Weld procedures shall be approved by Caton Connector prior to welding.

4.3 Caton Connector approval for AMS 2680 also constitutes approval to AMS 2681.

5. 03LB0 Brazing Requirements

5.1 MIL-B-7883 has been cancelled and replaced by the American Weld Society specifications.

5.2 Procedure qualification shall be in accordance with AWS B2.2 with the 03LB0 exception in 5.2.1.

5.2.1 Existing MIL B 7883, Class B and C, brazements, which are not fluid or gas retaining or carrying, may be qualified by previous successful inspection by Caton Connector and delivery to Caton Connector.

Advance approval by Caton Connector is required.

5.2.2 - For the Patriot program, when a Patriot drawing requires brazing in accordance with MIL-B-7883, Grade B, internal inspection(NDT) as required by the appropriate AWS specification is not required. All other inspection requirements of the AWS specification for Class B shall be satisfied.

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