

ECP: Logo		Owner/Buyer: Logo		<b>QUALITY CONTROL KEY FORM</b> <b>* None Building Structural Weldment *</b>			Fabricator logo here			
							QCKF N°			
							Project Name			
				Weldment N°		Job N°				
Ref.		Ref.					Filed/Shop Work	Shop		
Fabrication-ITP		Ref. Code/s		AWS-D1.8: 2009_§3.4 + ANSI- Z49.1-2012			MDMT °C			
Inspection Requirement Spec.		Ref. Drawing					&			
Acceptance Criterion				Weldment Delivery location						

**NCPFIRST**

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Page 1 of 1

Reference Picture -A		Reference Picture-B	

**FABRICATION REQUIREMENT -- AWS-D1.1-Part-5 + (add EPC -Specification here)**

CS-Structural Steel Grade	S355J2-N + S355J2-M	CS-Structural Thk. Range	5 mm ÷ 19 mm	Sharpe Edge Radius	38°
CS-Structural Pipe/Tube Steel Grade		CS-Pipe/Tube Thk. Range	3 mm ÷ 8 mm	Safety Factor	1.5
CS-Plate Material Grade		CS-Plate Thk. Range	3 mm ÷ 25 mm	Flame Cutting Gas	Oxyacetylene Gas
SS-Plate Material Grade		SS-Plate Thk. Range	3 mm ÷ 6 mm	Metal Heat Number	Shall be stamped on all parts
SS-Structural Pipe/Tube Steel Grade		SS-Pipe/Tube Thk. Range	3 mm ÷ 8 mm	Welder ID N°	Shall be stamped on all parts
Required Material Certificates	EN 10204:3.1	CS-Pipe/Tube Dia. Range	25 mm ÷ 100 mm	Structural Drawing	EPC Approved_ Code-B
Surface Condition of Received Material	Rust Grade-C & A	SS-Pipe/Tube Dia. Range	0.5 mm ÷ 100 mm	Pipe support Drawing	EPC approved_ Code-A
Joint Preparation (Take-offs)	CNC & Manual Flame Cutting	Joint Fit-up Tolerance	1.5 mm (max)	Traceability Map N°	EPC approval_ Code-B
Joint Preparation (Weld Areas)	Machine and Hand Grinder	Groove Angle Range	25° ÷ 38° (max)	RT- Reports Form	EPC approved_ Rejected
CS-Surface Condition for Coating	Metal Shot Blasted: SP5/Sa 3	Groove Tacking Method	Root Tack	NDE Inspector	ASNT Level II
NDE requirement before Welding	UT on Weld-Face	CJP -Weld Ends or Tab	Weld-Tabs	Welding Inspector	AWS-QC1 / AWS-B5.1

Applied Joint Designs	CJP, PJP, Fillets, & Lap Joints	CJP-Curve or Square ends	Curved Ends	Testing Key Form (TKF) N°	
SS-Surface Condition for Coating	Garnet Shot Blasted: SP16	Weldment Manipulation	Overhead Crane	QW-Thk Range (mm)	3.18 ÷ 2T (max) (AWS-D1.1-Table4.2)

**WELDING REQUIREMENT -- AWS-D1.1-Part- 4 + AWS-D1.8-Section-6.1**

Sq.	WPQR N°	WPS N°	QW-Process	Position	QW-J	Weld-Type	BG	QW-Thk	FTD	J-Service	NDE	P-HB-Survey	VQL <sup>(D1.1-§4.8.1)</sup>
1	NCP -C10-ISI	N-12.S1	GTAW = Root SMAW = Fill	2G, 2F	CJP	Groove	No	10mm	Yes	DC-SFRS	RT	No	Class 1
2	To be Qualified (in Tubular steel)	N-12.S2	GTAW = Root SMAW = Fill	6G	CJP	ALL	No	10mm	Yes	SLB-Weld	MT	No	Class 1
3	To be Qualified (in Tubular steel)	N-12.S3	SMAW = All	2G, +5G	CJP	ALL	No	12mm	Yes	DC-SFRS	UT	NCP-6387_001 (Figure A)	Class 1
4	TBA	N-12.S4	SMAW = All	2F, +3F	PJP	ALL	No	12mm	Yes	SLB-Weld	LPT	No	Class 1
5	To be Qualified (in Tubular steel)	N-12.S5	GTAW = Root FCAW = Fill	6G	CJP	ALL	No	19mm	Yes	DC-SFRS	RT	NCP-6387_001 (Figure B)	Class 1
6	NCP -C12-ISI	N-12.S6	GTAW = Root MCAW = Fill	1G-Flat 2G-HV	CJP	Groove	No	12mm	Yes	DC-SFRS	RT	NCP-6387_001 (Figure A)	Class 1
7	NCP -C12-ISI	N-12.S7	GTAW = Root MCAW = Fill	1F, 2F	PJP	Fillet	No	12mm	No	SLB-Weld	MPT	No	Class 1
8	NCP-C18-ISI-b	N-12.S8	SMAW = Fill MCAW = Fill	1F, 2F	CJP	Groove	CAG	18mm	Yes	DC-SFRS	RT	No	Class 1
9	To be Qualified (in Tubular steel)	N-12.S9	MIG/MAG = All	6G	PJP	ALL	NO	6mm	No	Handrails, Ladders	LPT	No	Class 2
10													

Acronyms | Visual Quality Level = VQL, Production Hardness = P-HB, Demand Critical = DC, Seismic Force Resisting System = SFRS, Joint = J, Fatigue Toes Dressing = FTD, Secondary Load Bearing = SLB, Back Gouge = BG, Carbon Arc Gouging = CAG

Item	SAFETY REQUIREMENT -- In process Compliance to the following sections	Item	QUALITY DOCUMENT REQUIREMENT-- In Process QC Inspection & Sign Off
1	ANSI-Z49.1-2012-Section 3. General Provisions, Management and Supervision	1	Structural & Pipe welds Traceability Maps
2	ANSI-Z49.1-2012-Section 4. Protection of Personnel and the General Area	2	Detail-Production Fabrication Drawing --- (In process QC Inspection of Fabrication & Welding activities)
3	ANSI-Z49.1-2012-Section 5. Ventilation (Work Shop)	3	Structural Weld Book --- (Verification of correct WPS per Joint per Welder is used)
4	ANSI-Z49.1-2012-Section 6. Fire Prevention and Protection	4	Fabrication-Inspection & Test Plan (F-ITP) --- (In process Inspection )
5	ANSI-Z49.1-2012-Section 10. Oxyacetylene Fuel Gas Welding and Cutting Safety	5	NDE-Report --- (Verify acceptability of RT-Template & Data-compliance to Code & TKF & QCKF combined)
6	ANSI-Z49.1-2012-Section 11. Arc Welding and Cutting Equipment Safety.	6	Filler Metal Test Report --- (Verify compliance to AWS-D1.8_§ 6.3.8 & F-ITP)
7		7	

Rev.	Date	Prepared By	Checked By	Approved By
Shop Address				QA/QC - Acceptance Stamp