Brazer Qualification Record

In Compliance with NFPA 99 and ASME Code Section IX

15

Name of Brazer: 1.(Brazer's Printed Name)

Brazer Identification Number: 2. Last 6 SSN Digits

Braze Test Date: 3. (Date of Braze)

Braze Procedure Specification followed: 13-BPS148

Brazing Qualification Limits

Brazing Variables	Actual Values	Ranges Qualified
Brazing Process	Manual Torch	Manual Torch
Method of Cleaning	3M Pad, Cloth Wipe, SS Wire Brush	3M Pad, Cloth Wipe, SS Wire Brush
Base Metals P-Number	P-107	P-107
First Base Metal Thickness	0.060″	0.030″ to 0.120″
Second Base Metal Thickness	0.051″	0.026″ to 0.102″
Joint Type	Socket	Socket & Lap
Joint Clearance	0.001″ to 0.010″	0.001″ to 0.010″
Joint Overlap Length	1.09″	1.36″ maximum
Internal Purge Gas	Oil Free Dry Nitrogen @ 5 to 10 CFH	Oil Free Dry Nitrogen @ 5 to 10 CFH
First Brazing Flow Position	Horizontal	All Flow Positions
Second Brazing Flow Position	Vertical Up	
Filler Metal Product Form	Face Fed Rod	Face Fed Rod
Filler Metal Specification	BCuP 2	All BCuP Series Rod
Filler Metal F-Number	F-103	F-103

Examination Results

Visual Examination of Completed Braze Assembly (QB-141.6): Acceptable (no signs of flaking or internal oxidation)
Test Lab Sectioning Test Results (QB-181): Acceptable

We certify that the statements in this record are correct and that the test coupons were prepared, brazed, and tested in accordance with requirements of NFPA 99 and Section IX of the ASME Code.

4. (Print ATR/Representative Name)	5. (Signature of ATR/Representative)	(Date of Braze)
NITC Representative/Authorized Testing Representative Name	NITC Representative/Authorized Testing Representative Signature	Date:
6. (Print Contractor/Supervisor's Name)	7. (Signature of Contractor/Supervisor's)	(Date of Braze)
Manufacturer/Contractor Company Name	Manufacturer/Contractor Representative Signature	Date:
National ITC Corporation		
Certified Test Lab Company Name	Certified Test Lab Representative Signature	Date:

The undersigned contractor hereby adopts this Brazer Qualification Record and accepts the responsibility for construction of brazements performed by the Brazer in accordance with the Contractor's Brazing Procedure Specifications.

Manufacturer/Contractor Company Name	Manufacturer/Contractor Representative Signature	Date: