

Audit Process- Welding

Manufacturing

DOCUMENT CHECK

Please select which of the following updated versions are available?

- ☐ Aluminum Design Manual ☐ ASME Boiler and Pressure Vessel Code ☐ Cutting and Allied Processes
- ☐ Missile & Aerospace Fusion Welders ☐ Qualification of Aircraft ☐ Safety in Welding
- ☐ Specification for Welding Procedure and Performance Qualification

Please select which of the following updated versions are available?

- ☐ Guide for the Visual Examination of Welds ☐ Standard Practice for Liquid Penetrant Testing
- ☐ Standard Practice for Liquid Ultrasonic Testing ☐ Standard Practice for Magnetic Particle Testing
- ☐ Standard Practice for Radiographic Examination
- ☐ Standard Reference Radiographs for Examination of Aluminum Fusion Welds
- ☐ Standard Welding terms and Definitions

Please select which of the following updated versions are available?

- ☐ Brazing and Nondestructive Examination ☐ Fusion Welding for Aerospace Application
- ☐ Nondestructive Testing Acceptance Criteria ☐ Requirements for Nondestructive Testing Methods
- ☐ Resistance: Spot and Seam ☐ Sheet Metal Welding Code
- ☐ Specification for Fusion Welding for Aerospace Application
- ☐ Specification for Resistance Welding for Aerospace Application
- ☐ Standard Methods for Mechanical Testing of Welds ☐ Standard Symbols for Welding
- ☐ Structural Welding Code- Aluminum ☐ Structural Welding Code- Sheet Steel
- ☐ Structural Welding Code- Stainless Steel ☐ Structural Welding Code- Steel
- ☐ Structural Welding Code- Titanium ☐ Welding

Please select which of the following updated versions are available?

- ☐ ADCAP welding documents ☐ Certification & Qualification of Nondestructive Test Personnel
- ☐ NADCAP NDT Inspection Documents ☐ NAVSEA Technical Publication S9074-AQ-GIB-010/248
- ☐ NAVSEA Technical Publication S9074-AR-GIB-010/278 ☐ NAVSEA Welding Standard 250-1500-1
- ☐ Raytheon Process Specification for Aerospace Fusion Welding

Please select which of the following are Certified?

- ☐ Visual Inspection ☐ Radiographic Inspection ☐ Ultrasonic Inspection ☐ Magnetic Particle
☐ Dye Penetrant Inspection

Please select which of the following are Qualified?

- ☐ ASTM E164 ☐ ASTM E1417 ☐ ASTM E1444 ☐ ASTM E1742 ☐ AWS QC1

QUALITY CONTROL CHECK

Is Quality and Procedures Manual available?

- ☐ Yes ☐ No ☐ NA

Is a documented evaluation done for qualified Sub-Tier Suppliers?

- ☐ Yes ☐ No ☐ NA

Is grade specified in purchase orders for base material?

- ☐ Yes ☐ No ☐ NA

Is American Welding Society (AWS) Classification and Specification mentioned on the purchase order for filler material?

- ☐ Yes ☐ No ☐ NA

Is requirement specified in purchase order for paints?

- ☐ Yes ☐ No ☐ NA

Have any controls been established to monitor the receipt of incoming material?

- ☐ Yes ☐ No ☐ NA

Is there an objective evidence of correction of non-conforming material or work in process

Yes

No

NA

Are weldments traceable to a Qualified or Certified Welder?

Yes

No

NA

Is the objective evidence that a welder/ weld operator has worked with a particulate process, material type and weld joint geometry within the last 6 months?

Yes

No

NA

Has a formal Material Review Board (MRB) process for disposition weld defects been established?

Yes

No

NA

Is there objective evidence to assure that welds are not obstructed by subsequent operations and are inspected prior to being covered up?

Yes

No

NA

Is there proper documentation of Requests for Information (RFI's) necessary to resolve discrepancies and variations from contract requirements?

Yes

No

NA

Is there a procedure for processing revised or voided drawings?

Yes

No

NA

Are you able to easily identify the submerged arc welding (SAW) fluxes and filler wire?

Yes

No

NA

Are the procedures for storage and control of low hydrogen Shielded Metal Arc Welding (SMAW) electrodes. in place?

Yes

No

NA

Is the welding filler wire sent to an independent Material's Lab for Testing and P.O. verification prior to being employed?

Yes

No

NA

Is Calibrated Mixture Chambers used If the Organization mixes their own shielding gases?

Yes

No

NA

Are Weld Chambers being utilized by the organization?

Yes

No

NA

Are Pre-Weld, Inter-pass and Post-Weld Cleaning Requirements defined to the Welding Procedure Specification (WPS)?

Yes

No

NA

Are Preheat, Inter-pass and Post-Weld heat treatment addressed on the Welding Procedure Specification (WPS)?

Yes

No

NA

Are the weld settings used in production within range of those documented on the WPS or PQR for automatic/ mechanized welding?

Yes

No

NA

Are the weld settings used in production within range of those documented on the WPS or PQR for semi-automatic welding?

Yes

No

NA

In regards to fabrication work, are the weld inspectors knowledgeable and qualified to perform the same?

Yes

No

NA

Are the procedures being used by the Welders in close proximity to what is written?

Yes

No

NA

For visual weld inspection, are tools and visual aid being used?

Yes

No

NA

Are Hold Points at the facility strictly being used for weld inspection?

Yes

No

NA

Is there a formal Material Review Board (MRB) established for disposition of non-conforming weldments?

Yes

No

NA

Please select the positions the welders are qualified to perform

☐

Groove Welds

☐

Fillet Welds

SAFETY STANDARDS

Please confirm the presence of the health and safety officer?

Yes

No

NA

Please select the options for which evidences are seen at the site?

☐

Welding Safety Program

☐

Safety Training classes being conducted

☐

Weld operator annual vision test

☐

Weld inspector's annual vision test

Is the facility environmentally controlled?

Yes

No

NA

Is the relative humidity being monitored and documented?

Yes

No

NA

Is a proper welding gas distribution system seen?

Yes

No

NA

Are facility Equipment List and Capabilities Profile sheets accessible?

Yes

No

NA

Within the welding area, does the facility have lifting crane capacity?

Yes

No

NA

Are welding positioners seen at the facility?

Yes

No

NA

Has an area ben designated for weld and/or Base Material grinding?.

Yes

No

NA

Is the welding area clean, safe and properly organized?

Yes

No

NA

Are Welding Fume Extractors seen in the facility?

Yes

No

NA

Are Pre and Post Weld heat treatments (PWHT) being performed at the Facility?

Yes

No

NA

Are separate areas being maintained for Stainless Steel, Titanium, Carbon Steel or Aluminum?

Yes

No

NA

Please confirm if blast cleaning is being performed at the facility?

Yes

No

NA

Is analysis of Base material or Weld metal being conducted?

Yes

No

NA

Is leak testing being conducted at the facility?

Yes

No

NA

Comments

textarea

SUPPLIER'S DETAILS

Name of the Company

Please mention the address

Please mention the date of the Establishment of the Company

DATE

2017-01-01

Please confirm the Business Characterization.

Please confirm the size of the Facility

Please confirm the Length of the shifts

Please confirm the number of employees

Please confirm the number of Welding Inspectors

Please confirm if there are any QA/QC personnel amongst the staff members or not?

Yes

No

NA

Please confirm if there is a Certified Weld Inspector on Site or not?

Yes

No

NA

Please confirm if the DCMA is on site or not?

☐ Yes☐ No☐ NA

Please confirm if there are any ASNT Level I/II/III NDT Inspectors on site?

☐ Yes☐ No☐ NA

Please confirm if the NAS- 410 NDT Inspectors are on Staff or not?

☐ Yes☐ No☐ NA

Please confirm if the company follows and documents any NDT procedures?

☐ Yes☐ No☐ NA

Are the Welders on staff certified?

☐ Yes☐ No☐ NA

Please confirm if Weld supervisor's are seen on site?

☐ Yes☐ No☐ NA

Please confirm if Weld Engineers are seen on site or not?

☐ Yes☐ No☐ NA

Please confirm if the company has hired MFG Engineers or not?

☐ Yes☐ No☐ NA

Is the Supplier working for the client currently?

☐ Yes☐ No☐ NA

Are the quality system approvals in place?

Yes

No

NA

For the staff in the Quality Department, is there a separation in reporting of duties?

Yes

No

NA

Has the quality control officer given the authority to Stop Work and the responsibility to Identify Quality Problems and Provide Recommendations?

Yes

No

NA

Is there an Evidence of a Review Process of Certified Material Test Reports (CMTR) to ASTM Specifications?

Yes

No

NA

The materials as specified in the Technical Data Package, is traceable and can be identified without any hassle?

Yes

No

NA

Is American Welding Society (AWS) Classification and Specification mentioned on the purchase order for filler material?

Yes

No

NA

Comments

textarea