**DØ CRYO
CC PRESSURE VESSEL
HEAD TO CYLINDER
WELD TEST
RESULTS**

**DØ ENGINEERING NOTE
3740.214-EN-303
JOHN URBIN
17 MAR 91**

REVIEWED: _____

G. T. Melh...

DATE: _____

3/25/91

FERMILAB

ENGINEERING NOTE

SECTION

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SUBJECT

DP "CC" - WELD-TEST

SIMULATION OF PRESSURE
VESSEL HEAD TO CYLINDER WELD

NAME

J. GABIN

I. STANESBOLL

DATE

2 JUN 89

REVISION DATE

304 PLATE: 2'x4'x5/8"

15 MIN/WELD PASS $\Rightarrow$ 3.2" WELD/MIN

DC

3/8" x 2" WIDE BACKING BAR

REVERSE POLARITY

WELD ROD: 316L-15 5/32"

125 A

* PASS #1	#2	#3	#4	#5	#6	#7	#8	#9	#10
1	200	195	140	190	165	185	150	195	170
2	170	140	100	125	120	105	115	150	135
3	200	190	145	190	170	190	145	200	175
4	190	135	105	125	135	110	115	150	135
5	205	200	140	195	165	195	155	210	170
6	140	135	110	130	140	120	120	135	140
7	185	205	145	200	165	180	160	200	170
8	130	145	110	125	130	105	120	140	145
9	210	165	145	190	175	185	160	195	165
10	170	115	105	140	145	105	125	145	140

* SEE PASS GEOMETRY DIAGRAM

TEMP IN °F

NO DAMAGE TO SHEATH
OR THERMOMETRY WIRE
WAS OBSERVED

1" POSITION - AVG. 115° 20 MIN AFTER PASS COMPLETION

MEAS.
PTS.

FERMILAB

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2φ "CC" - WEAR TEST

NAME

J. UEBIN
I. STANKEBOLL

DATE

2 JUN 89

REVISION DATE

PASS GEOMETRY DIAGRAM