

Swagelok® Orbital Welding + ASME Section IX Qualification

This 5-day course is designed to familiarize each participant with orbital welding principles, design standards, equipment, and welding procedures. On Day 5, each student will complete multiple weld coupons and paperwork required for ASME Section IX weld qualification testing. All ASME Section IX weld qualification testing costs are included in the class registration fee.

Course objectives:

- Understand basic metallurgy and industry standards, and specifications for welding
- Set up and operate orbital welding equipment
- Utilize borescope for weld inspection
- Learn how to select, use, and care for tungsten electrodes
- Learn how proper gas selection and purging techniques affect weld quality
- Troubleshoot common issues
- Practice orbital weld procedures up to 1.5" tubing diameter
- Develop weld procedures and adjust the variables of the GTAW process
- Learn about weld shrinkage and how to calculate cut lengths
- Create an assembly within allowable tolerances
- Create samples to be submitted for ASME Section IX qualification

What's included in the registration fee?

- 5 days of training
- Use of orbital weld equipment and consumables to complete all practical projects
- Student course guide
- Weld reference cards
- Certificate of course completion
- ASME Section IX weld test/qualification fees
- Lunch and snacks each day

Day 1:

- GTAW process, history, evolution, practical theory, and weld variables

Day 2:

- Overview of Swagelok welding system functions, setup and operations
- Introduction to the 5H fixture block; side plates, plenums, collets, adjusting alignment, and using the arc gap gage
- Using the auto-generate function to create a welding program on 1/2" x .065" SS tubing
- Define what makes an acceptable weld, how to evaluate a weld and how to generate a weld coupon
- Using the level adjustment feature on the M200 power supply
- Developing weld parameters to meet specific weld size (root width)

Day 3:

- How to weld differential wall
- Review of Standard Operating Procedures
- Introduction to the 20H fixture block

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- Additional weld coupon exercises, 1/4" and 1/2"
- Welding larger sizes, 1" or 1 1/2", and implementation of tacking

Day 4:

- Introduction of Micro-Fit® fixture block
- Weld shrinkage calculations
- Facing tool setup and operation
- Weld assembly within allowable tolerances
- Prep spool pieces for ASME Section IX qualification

Day 5

- Reserved for ASME Section IX welds and paperwork
- Each student must submit 4 samples of 1/4" and 4 samples of 1/2"

Training locations:

Swagelok Southwest Phoenix Training Center
4926 E. Beverly Road
Phoenix, AZ 85044

Swagelok Southwest Albuquerque Training Center
2732 Vassar Place NE, Suite A
Albuquerque NM 87107

Registration fee:

\$3,500 per student

Contact for more information or to register:

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Swagelok Southwest

Phoenix Office

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Albuquerque Office

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