

Boeing Canada  
de Havilland Division

# ENGINEERING STANDARD PRACTICE

TITLE:	QUALIFICATION OF WELDMENTS OF TUBULAR SURFACES
SPECIFICATION NUMBER:	ESP 81
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This standard practice verifies that qualification of weldments of tubular surfaces specified on drawings shall conform to the parameters of weld class codes in the document D49-001-024/SF-001 published by the Department of National Defence in the qualification of manual for fusion welders.

Specifically, weld class code TS for material, thinnest combination for approval range and class code TF for material wall thickness 0.375" x 0.035" (or equivalent in metric scale). Inspection and test procedures are outlined in Table IX of the above document. Welders shall weld those production parts which are within the thickness range encompassed by the above document for the type of categories authorized respectively.