

## COUPP High Purity Fluid Handling Cart

### QUALITY CONTROL DOCUMENT

Assembly / Sub-Assembly name: \_\_\_\_\_

Filled out by (name): \_\_\_\_\_ Date: \_\_\_\_\_

Make a sketch of the assembly below. Show each component, weld joint and connection. Label components by component tag number. Label tubing sizes. If assembly is set up for welding, designate the purge gas inlet and outlet. Number each weld in the sequence (work from purge port inlet towards outlet).

#### Preparation checklist:

- Tubing ends square to better than 0.008"?
- Tubing clean and dry inside and out?
- Remnants of tape residue, foreign matter, marker marks > 3" away?

#### Pre-welding checklist:

- Voltage at welder power source: \_\_\_\_\_
- Interior purge flow rate: \_\_\_\_\_  
(minimum 15 scfh for 1/4" tubing, 25 scfh for larger tubing)
- Interior purge flowing for more than 1 minute per 4 feet of tubing?
- Electrode: No. of welds < 25 for 3/4" & 1/2" tube, < 30 for 1/4" tube?
- Oxygen and Moisture < 1 ppm?
- Weld head purge gas on?

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**Welding information**

Welder:

Name: \_\_\_\_\_

Identifying mark or symbol: \_\_\_\_\_

WPS used: \_\_\_\_\_

WQR number: \_\_\_\_\_

Weld machine being used: \_\_\_\_\_

Weld number  
(from sketch)

# of prior welds made  
by this Electrode

Comments

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**Pre-Installation Conditioning**

**Water flushing** (conductivity  $\leq 0.06 \mu\text{S-cm?}$ ) Meter used: \_\_\_\_\_

Millipore water upstream of assembly: effluent water:

**Particle counting measurement** (0 particles  $\geq 0.3$  microns &  $\leq 5$  particles  $\geq 0.1$  microns?)

*Handheld Lighthouse 3016* – Use 10 minute x 0.1 cfm record.

Record # \_\_\_\_\_ Date & Time stamp: \_\_\_\_\_

0.3 micron counts:

0.5 micron counts:

0.7 micron counts:

1.0 micron counts:

2.0 micron counts:

5.0 micron counts:

*Solair 3100 unit* – Use 1 minute x 1.0 cfm record.

Record # \_\_\_\_\_ Date & Time stamp: \_\_\_\_\_

0.3 micron counts:

0.5 micron counts:

1.0 micron counts:

3.0 micron counts:

5.0 micron counts:

10.0 micron counts:

**Moisture measurement** after drying ( $< 1$  ppm?) Meter used: \_\_\_\_\_

Moisture measured : \_\_\_\_\_