



# Welding

The Welding Shop is fully staffed and is operational 24 hours a day by implementing three shifts. The Welding Shop supports the Structural/Sheet Metal and Pipe Shops in the installation, removal, upgrade and fabrication of vessels' structures and distributive systems.

The welding shop personnel are qualified for welding of:

- Carbon Steel to Carbon Steel
- Carbon Steel to Stainless Steel
- Clad Welding of Manganese Bronze
- Copper Nickel to Copper Nickel
- Aluminum
- Stainless Steel
- Copper Nickel to Carbon Steel
- Consumable Insert Carbon Steel
- Chromium-Molybdenum Alloy Steel
- P2 Piping Open Butt Joint
- Shaft Weld Repairs
- Clad Welding Hard Surfacing
- Copper Nickel to Nickel Base Alloys
- Stainless Steel Overlay on Carbon Steel
- Stud Automatic Timed Arc
- Shaft Austenitic Stainless Steel Overlay
- Ceramic Refrac-T-Back Tape



*Automatic two sided structural component welder*



Specialized training and experience of shop personnel include Certification and Qualification to weld in accordance with DoD, NAVSEA, ABS, USCG, and AWS certification requirements. Our qualified welding processes include: FCAW, GMAW, GMAWS, GTAW, SAW, SMAW and SW. A staff of NDT inspectors reporting separately to the QA staff who perform both shop and shipboard quality inspections augments the shop.



### Major Welding Shop equipment includes:

- Powercon Portable single-operator welders (11)
- Miller II 8-Pack welding machines (11)
- Portable Gas Engine Welders (2)
- Miller CP-300 MIG machines for Aluminum (3)
- Miller Syncrowave 300 TIG machines (4)
- Oxxweld MIG wire-feeders (4)
- Lincoln LN-25 Wire Feeders (46)
- Bug-O Automatic track welding systems (4)
- Automatic Stiffener Welder – Bug-O w/ Lincoln LN-7 Wire Feeders (1)
- Lincoln LT-7 Submerged Arc Tractors with Power Sources (4)
- Lincoln Multi-welds (32)
- Lincoln Submerged Arc Hand Held System
- Lincoln NA5-S Submerged Arc Systems
- Ransom Turning Rolls for tanks up to 20' diameter
- Arc-1800 Pro Weld International Stud Welder
- Aggressive 89Kva Heat Treating Machines (2)