

## Jan Szal

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**From:** Jan Szal  
**Sent:** Tuesday, March 22, 2016 12:58 PM  
**To:** Timothy Mckenna  
**Subject:** FW: Weld inspection of LCLS-II vacuum vessel F10026609

**From:** Jan Szal  
**Sent:** Tuesday, March 22, 2016 12:57 PM  
**To:** James N Blowers <blowers@fnal.gov>; Ted R Beale <beale@fnal.gov>  
**Cc:** Kenneth S. Premo <premo@fnal.gov>; Tug T Arkan <arkan@fnal.gov>; James M O'Neill <oneill@fnal.gov>; Michael S. Jeeninga <msj3854@fnal.gov>  
**Subject:** RE: Weld inspection of LCLS-II vacuum vessel F10026609

We don't have a step dedicated to weld inspection in current revision, so free-form write-up would be preferable. We will try to incorporate it into the next revision.

Jan Szal  
Fermi National Accelerator Laboratory  
P.O. Box 500  
Batavia, IL 60510  
Tel. (630) 840-4572  
[jszal@fnal.gov](mailto:jszal@fnal.gov)

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**From:** James N Blowers  
**Sent:** Tuesday, March 22, 2016 12:39 PM  
**To:** Jan Szal <[jszal@fnal.gov](mailto:jszal@fnal.gov)>; Ted R Beale <[beale@fnal.gov](mailto:beale@fnal.gov)>  
**Cc:** Kenneth S. Premo <[premo@fnal.gov](mailto:premo@fnal.gov)>; Tug T Arkan <[arkan@fnal.gov](mailto:arkan@fnal.gov)>; James M O'Neill <[oneill@fnal.gov](mailto:oneill@fnal.gov)>; Michael S. Jeeninga <[msj3854@fnal.gov](mailto:msj3854@fnal.gov)>  
**Subject:** Re: Weld inspection of LCLS-II vacuum vessel F10026609

Ted, I've asked Jim and Mike to inspect the vacuum vessel welding-wise. Assuming all the welds are painted over, it will be limited to weld sizes and patterns. When Jim contacts you, would you please show him the vessel? I've also told him that they should effort their time using our activity code for the inspection work. Would you also share that info with him?

Jan, should they just write up their inspection results free-form (and we'll attach it to the inspection traveler), or is there a section in the traveler for inspecting the welds?

Thanks,

Jamie

----- Original message-----

**From:** Jamie Blowers  
**Date:** Tue, Mar 15, 2016 2:17 PM  
**To:** James M O'Neill;Michael S. Jeeninga;  
**Cc:** Jan Szal;Ted R Beale;Kenneth S. Premo;Tug T Arkan;  
**Subject:**Weld inspection of LCLS-II vacuum vessel F10026609

Jim and Mike, I trust your travels to Ohio were uneventful and that you're finding the CWI class informative. I have a job for your newly-developed expertise as soon as you come back. We have received a vacuum vessel from PHPK for the LCLS-II prototype cryomodule. I've attached the main drawings. Ted Beale's group will be performing a mechanical inspection using their laser tracker, and as part of the overall incoming inspection I would like the vessel's welds inspected too. Perhaps as you're going through this week's training you could have this vessel in the back (or front) of your mind, and in doing so be reasonably prepared to give it a once-over when you're back next week.

There is an incoming inspection traveler for the overall inspection work. I don't know if it includes a formal weld inspection. Regardless, the results of your inspection should be documented in some reasonable manner and attached to the traveler.

Thanks, and please let me know if you have any questions or need any other drawings.

Jamie