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Supersedes:	19-Jan-2018
Effective:	11-Feb-2019

1.0 Purpose

This procedure establishes calibration requirements for TIG (GTAW) weld machines located at Meyer Tool, Inc. facility at 3055 Colerain Avenue, Cincinnati, Ohio.

2.0 Reference Documents

- 2.1 AWS TFD17.1 Specification for Fusion Welding for Aerospace Applications
- 2.2 GE P8TF3 or P8TF11 Shielded Arc Welding
- 2.3 Honeywell WBS 5018 Fusion Arc Welding
- 2.4 QP-118 Fusion Welding
- 2.5 MTI-168 Machine Preventative Maintenance Form
- 2.6 Pr-4010
- 2.7 DMP 43-001

3.0 Responsibility

- 3.1 The Quality Department has the prime responsibility for operation of the Calibration system.
- 3.2 The Quality Director maintains a surveillance function by periodically auditing the documented Calibration system.

4.0 Calibration Procedure

- 4.1 Calibration is performed by an outside vendor or the MTI calibration department to the requirements listed in section 5.0.

5.0 TIG (GTAW) Welder Calibration

- 5.1 **Amperage:** All fusion (TIG) welding equipment shall be calibrated from the following(s):
 - 5.1.1 3-30 amps, deviation of +/- 1.5%
 - 5.1.2 31- 60 amps, deviation of +/- 1.5%
 - 5.1.3 61-100 amps, deviation of +/- 1.5%
- 5.2 **Volts:** All fusion (TIG) welding equipment shall be calibrated from the following range(s):
 - 5.2.1 10-30 VDC, deviation of +/- 2.0 VDC
- 5.3 **GAS Flow Meters/Regulators:** All Gas Flow Meters shall be calibrated from the following range(s);

Date		Date	
Prepared by	SCOTT HOBBS	Approved	ROB SENITZA

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5.3.1 5-20 CFH, deviation of +/- 2.5 CFH

6.0 Records

6.1 All records will be maintained in accordance with PI-166 Records Control, applicable customer requirements.

Revision History

Rev. Ltr.	Parg.	Description of Revision	Date Rev.	Rev. By
Original	All	New Procedure	19-Jan-2018	M. Guard
A	All	Corrected spelling and formatting	11-Feb-2019	S. Hobbs
A	4.1	Clarified statement and included "...or the MTI calibration department..."	11-Feb-2019	S. Hobbs