



Automotive Industry Action Group

Special Process: Welding System Assessment

Version 1, 3/2010

Section 6 - Job Audit

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Job Identity:
 Customer: MAGNA - MESSER
 Shop Order Number: W.O. 29601
 Part Number: 90320-01 ASM
 Part Description: 2387 LOCK POST
 Base Metal Specifications: 5AE 1045 F J 2340 340XF.
 Filler Metal Specification (if required): ER70S-6
 Welding Process(es): GMAW ROBOTIC

at 3012.
 W.O. 29601
 90320-01 ASM
 2387 LOCK POST
 5AE 1045 F J 2340 340XF.
 ER70S-6
 GMAW ROBOTIC

Job for: J. Kittle

Question #	Job Audit Question	Related WSA Question #	Customer or Internal Requirement	Job (Shop) Order or Reference Documentation Requirement	Actual Condition (Objective Evidence)	Pass / Fail / N/A
6.1	Has the welding operation identified the process control equipment necessary to monitor, control and provide feedback on all essential process variables as listed in the applicable Process Tables?	1.8 5.1 5.2	Control Plan.	W.O. 29601		Pass
6.2	Has the logic been established to effectively identify and address process or equipment faults?	5.1	Shut Down/STAR			Pass
6.3	Are over rides or resets logs maintained?	5.1.2			MAIN TENANCE LOG.	Pass
6.4	Are weld faults audible, visible and does the line shut down?	5.1.3			Software Controlled	Pass
6.5	If the weld cycle is interrupted, is the part controlled or contained until dispositioned by appropriate personnel?	2.7 5.1.4			Software Controlled	Pass
6.6	Are the meters and feed back controls calibrated per established frequencies?	5.1.5 3.3			Integrated to Software	Pass
6.7	If applicable, is there an inter-locking of the previous operation and has the quality of parts been verified?	5.1.6				NA

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Job Identity:
Customer: MMANA: MISS from WINDS: GPPS
Shop Order Number: W.O. 29601
Part Number: 90520-01 ASM
Part Description: 4357 LOCK ROSS
Base Metal Specifications: SAE 1045 F J2340 340F
Filler Metal Specification (if required): ER 705-G
Welding Process(es): GMAW ROBOTIC

Old 30hr

Question #	Job Audit Question	Related WSA Question #	Customer or Internal Requirement	Job (Shop) Order or Reference Documentation Requirement	Actual Condition (Objective Evidence)	Pass / Fail / N/A
6.8	Are there secure backups of all programs and procedures (electronic preferred)?	5.1.7			Software Backup	Pass
6.9	Are high/low limit alarms established by actual data.	5.1.8 5.1.1			Software Control	Pass
6.10	Have process variables been defined and developed by data and shown to be statistically capable?	5.1.9			Capability of PPA P	Pass
6.11	Is there acceptable traceability (sequence/date coding)?	5.1.10 5.1.11 2.3 2.7			W.O. Traceability	Pass
6.12	Is there traceability of all process and tooling changes?	4.1 5.1.11 5.4			Setup Verification No changes in Process shown	Pass
6.13	Are there documented welding procedures for each weld location and each process variable?	5.1.12 1.5 1.10	Welding Procedure Data Sheet		Welding Procedure Data Sheet	Pass
6.14	Is there a documented change over procedure (filler material, fixtures)?	1.5 5.1.13 3.6	Set up Verification		Setup Verification	Pass
6.15	Is there a documented start-up and shut-down procedure?	1.5 1.10 5.1.14			Maintenance reference	Pass

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Job Identity:
Customer: AMCARR - MS5 Stem US M 95: GRR3
Shop Order Number: U.S.O. 29601
Part Number: 90820-01 ASM
Part Description: 4387 LOCK POST
Base Metal Specifications: SAE 1045 F 32340 310 YF
Filler Metal Specification (if required): ER 705-G
Welding Process(es): GMAW ROBOTIC

OUT 30/12

Question #	Job Audit Question	Related WSA Question #	Customer or Internal Requirement	Job (Shop) Order or Reference Documentation Requirement	Actual Condition (Objective Evidence)	Pass / Fail / N/A
6.16	Are process control parameters monitored at established frequencies?	5.2	Weld Procedure Data Sheet		Weld Audit of Parameters	Pass
6.17	Are there documented reaction plans with appropriate levels of containment to both out of control and out of tolerance process parameters and provide documented evidence that reaction plans are followed?	5.3 1.21 5.6 1.8 2.7	Control Plan In Process Inspection		In process Inspection	Pass
6.18	How does the organization handle changes to process control parameters after initial customer approval and how do you notify your customer?	1.6 5.4 1.22 1.16	Change - Control / Process.		Process Changes not addressed without review	Pass
6.19	Are In-Process and Final Tests performed at established frequencies?	1.8 5.5	Control Plan		Destruct. Dye Pen. / H/W Section - Dip Pen. Pass	Pass
6.20	Are weld quality requirements clearly defined per customer specifications?	1.9 5.6	Each part may have one or more requirements determined by the welding specification. Parts must meet each requirement. List requirements below and validate.			
6.20.1	Test Type: <u>Weld Length</u>		Control Plan		Length Record	Pass
	Test Method: <u>Caliper Handing</u>				ID # 284497	Pass
	Test Frequency and Quantity: <u>Weld / Fixture</u>				4 Samples	Pass
	Specification: <u>20 mm</u>				20.72 / 20.83	Pass
	Test Type: <u>Destruct</u>		Control Plan		20.62 / 20.67	Pass
6.20.2	Test Method: <u>Destructive base metal</u>				4 Samples	Pass

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Job Identity: Old 3012
 Customer: _____
 Shop Order Number: _____
 Part Number: _____
 Part Description: _____
 Base Metal Specifications: _____
 Filler Metal Specification (if required): _____
 Welding Process(es): _____

Question #	Job Audit Question	Related WSA Question #	Customer or Internal Requirement	Job (Shop) Order or Reference Documentation Requirement	Actual Condition (Objective Evidence)	Pass / Fail / N/A
	Test Frequency and Quantity: <i>1 per fixture build</i>				<i>1 sample</i>	
	Specification: <i>Full hex metal</i>				<i>Reference photos</i>	<i>Pass</i>
					<i>Photo island</i>	<i>Pass</i>

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Job Identity: _____
 Customer: _____
 Shop Order Number: _____
 Part Number: _____
 Part Description: _____
 Base Metal Specifications: _____
 Filler Metal Specification (if required): _____
 Welding Process(es): _____

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Question #	Job Audit Question	Related WSA Question #	Customer or Internal Requirement	Job (Shop) Order or Reference Documentation Requirement	Actual Condition (Objective Evidence)	Pass / Fail / N/A
6.20.3	Test Type: <i>Weld Section</i> Test Method: <i>Weld Section</i> Test Frequency and Quantity: <i>Open for test / skill</i> Specification: <i>3mm max</i>		<i>Control Plan</i>		<i>(4) Weld Section (4) Passes 3.29/3.20/3.41/3.25</i>	<i>Pass</i>
6.20.4	Test Type: _____ Test Method: _____ Test Frequency and Quantity: _____ Specification: _____					

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