

| Location Designations: | | | | | Sketch/Description: |
|---|--------------------------|---|--|---|---------------------|
| 1. Pad-to-Tank Welds (Designated with an 'A' code) | | | | | |
| Code | Meets | Description | Location | Includes | |
| A1 | HM-201 SS-3 88.B.2 | Front sill pad-to-tank transverse weld. | A- & B-Ends | Full length including weld around corner of pad. | |
| A2 | HM-201 SS-3 88.B.2 | Front sill pad longitudinal welds. | AR, AL, BR, BL | Full length of weld to termination @ bolster. | |
| A3 | HM-201 | Fillet weld in front sill pad-to tank cutout | A- & B-Ends. | Complete weld. | |
| A4 | HM-201 | Sill pad longitudinal weld – outboard termination. | AR, AL, BR, BL | 6” of weld from termination. | |
| A5 | HM-201 | Front sill pad-to-bolster pad transverse weld. | A- & B-Ends | Complete weld. | |
| A6 | HM-201 | Inboard termination of sill pad longitudinal welds. | AR, AL, BR, BL | Inspect 24” of weld including wrap around to weld termination @ 24” NWZ. <u>On UTC-built cars inspect last 6” of weld termination.</u> | |
| A7 | HM-201 | Sill pad-to-bolster pad transverse weld. | A- & B-Ends | Complete weld. | |
| A8 | HM-201 | Sill pad-to-tank slot welds. | A- & B-Ends | Last 6” of weld at each end of slot. | |
| A9 | HM-201 | Bolster pad-to-tank transverse weld. | ARO, ARI, ALO, ALI, BRO, BRI, BLO, BLI | 36” from junction with cradle pad. | |
| Crack Orientation Codes: PPM – Pad Parent Metal TPM – Tank Parent Metal WTP – Weld Toe-to-Pad WTT – Weld Toe-to-Tank OTH – Other | | | | | |

2. Sill-to-Pad Welds (Designated with an 'B' code)

| Code | Meets | Description | Location | Includes |
|-------------|----------------|--|-----------------|---|
| B1 | SS-3 88.B.2 | Transverse welds (top of sill flange). | A- & B-Ends. | Full length of weld, inspect form top of sill. |
| B2 | 88.B.2 | Outboard termination of longitudinal weld (outside of sill). | AR, AL, BR, BL. | Last 6" of weld to termination. |
| B3 | SS-3 88.B.2 | Transverse welds (bottom of top sill flange). | A- & B-Ends. | Full length of weld from inside. |
| B4 | 88.B.2 | Inboard termination of longitudinal weld (outside of sill). | AR, AL, BR, BL. | Last 6" of weld including any portion of weld that wraps around sill and connects with B44. |
| B22 | 88.B.2 | Outboard termination of longitudinal weld (inside of sill). | AR, AL, BR, BL. | Last 6" of weld. |
| B44 | 88.B.2 | Inboard termination of longitudinal weld (inside of sill). | AR, AL, BR, BL. | Last 6" of weld. |

Crack Orientation Codes:

- PPM** – Pad Parent Metal
- SPM** – Sill Parent Metal
- WTP** – Weld Toe-to-Pad
- WTS** – Weld Toe-to-Sill
- OTH** – Other

