

Location Designations:					Sketch/Description:
<b>1. Pad-to-Tank Welds (Designated with an 'A' code)</b>					
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. <b>On UTC-built cars inspect last 6” of weld termination.</b>	
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.	
<b>Crack Orientation Codes:</b> 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)

<b>Code</b>	<b>Meets</b>	<b>Description</b>	<b>Location</b>	<b>Includes</b>
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

