

Location Designations:

Pad-to-Tank (Designated by 'A' codes)

Code	Description	Location	Inspect
A1 <sup>1</sup>	7" Transverse weld.	A- & B-Ends	Full length of weld.
A2 <sup>2</sup>	Front sill pad longitudinal welds.	AR, AL, BR, BL	Full length of weld to termination at bolster pad.
A6 <sup>3</sup>	Inboard termination of sill pad longitudinal welds.	AR, AL, BR, BL	Last 6" of weld to termination.
A8 <sup>4</sup>	Sill pad-to-tank slot welds.	A- & B-Ends (4 to 10 places per car)	Inboard and outboard slot welds.
A9	Bolster pad-to-tank transverse weld.	ARO, ARI, ALO, ALI, BRO, BRI, BLO, BLI	
A10	Top of body bolster longitudinal weld.	AR, AL, BR, BL	

<sup>1</sup> On some cars, this weld will be continuous around outboard end of pad. On most cars, this weld will be 5" to 8-½" in length, terminating at backstop reinforcements

<sup>2</sup> This weld wraps around pad, terminating in transverse portion just outside of sill web. On some cars built between 1969 and 1986, there may be a seal weld connection transverse and longitudinal welds.

<sup>3</sup> Does not apply to cars with continuous cradle pad.

<sup>4</sup> There may be two or three slots labeled "a" - "c." On insulated cars with continuous cradle pad, inspection of inboard slots labeled "d" and "e" is not required.

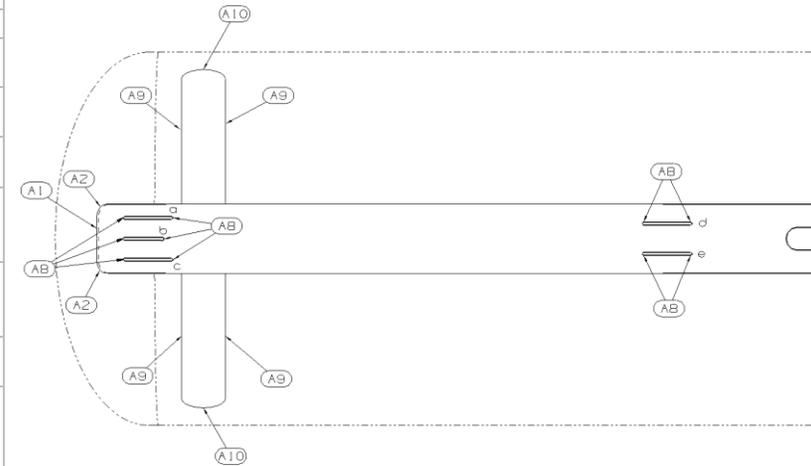
Use the "ACF P470 or ACF 389." template to report relevant reinforcement defects.

Use the "Generic Body Bolster." template for body bolster defects.

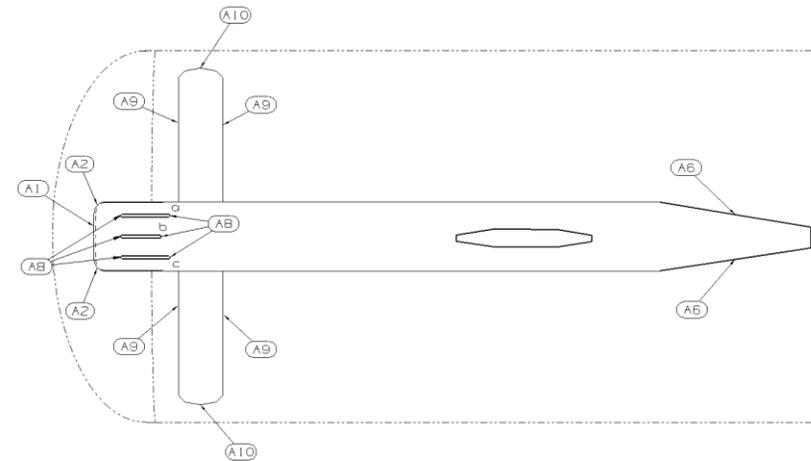
Use the TCID "Record Shell/Sill Damage" button for:

- All parent metal defects.
- All structural defects outside the scope of these templates.

Sketch/Description:



A,C,F., 200 CONTINUOUS CRADLE PAD



A,C,F., 200 CONTINUOUS CRADLE PAD

Location Designations:			
Sill-to-Pad Welds (Designated by 'B' codes)			
Code	Description	Location	Inspect
B2	Outboard termination of longitudinal weld (outside of sill).	AR, AL, BR, BL	Last 6" of weld to termination.
B22	Outboard termination of longitudinal weld (inside of sill).	AR, AL, BR, BL	Last 6" of weld to termination.
B4	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.
B44 <sup>1</sup>	Inboard termination of longitudinal weld (inside of sill).	AR, AL, BR, BL	Last 6" of weld.
E4	Draft Sill Stiffener	AR, AL, BR, BL	Sill Web Top to Bottom

<sup>1</sup> Weld may be wrapped around inboard end of sill.

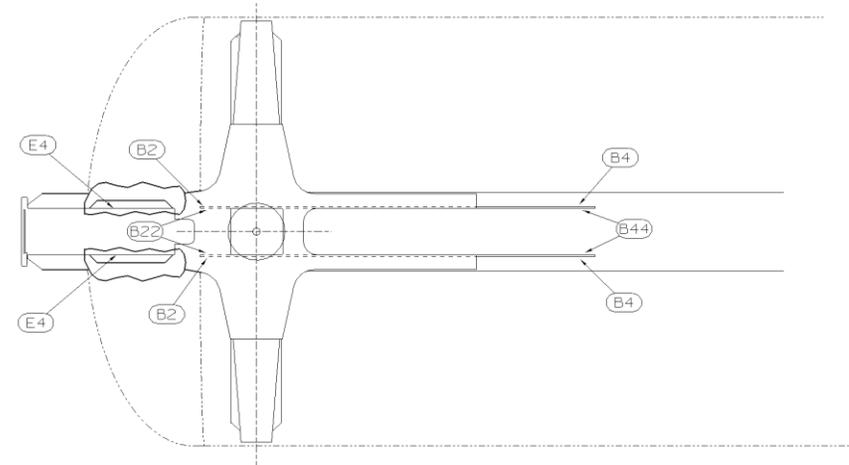
Use the "ACF P470 or ACF 389." template to report relevant reinforcement defects.

Use the "Generic Body Bolster." template for body bolster defects.

Use the TCID "Record Shell/Sill Damage" button for:

- All parent metal defects.
- All structural defects outside the scope of these templates.

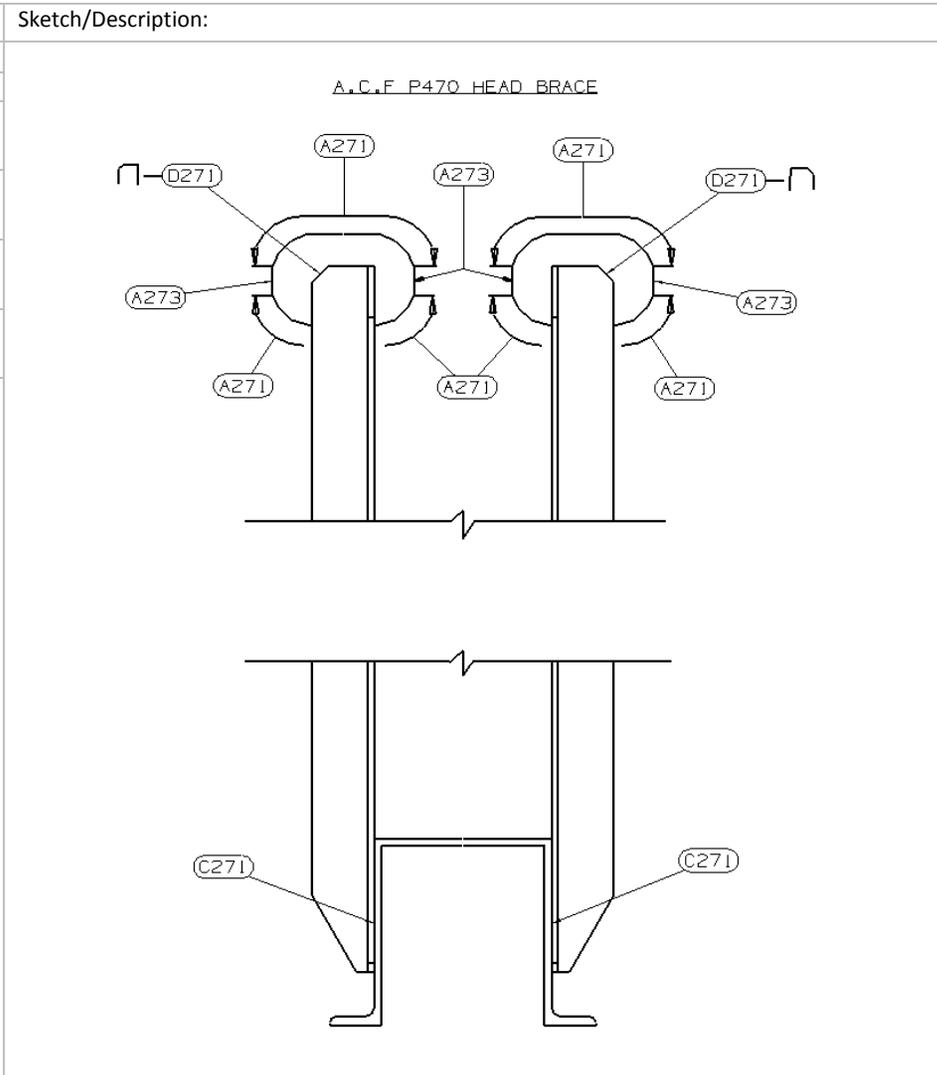
Sketch/Description:



Location Designations:

Pad-to-Tank and Head brace to Pad/Sill (ACF270)

Code	Description	Location	Inspect
A271	Head pad-to-tank horizontal weld.	AR, AL, BR, BL	Full length of weld.
A273	Head pad-to-tank vertical weld.	AR, AL, BR, BL	Full length of weld.
C271	Angle-to-sill vertical weld.	AR, AL, BR, BL	Full length of weld, two welds per location.
D271	Angle-to-pad entire weld.	AR, AL, BR, BL	Full length of weld.

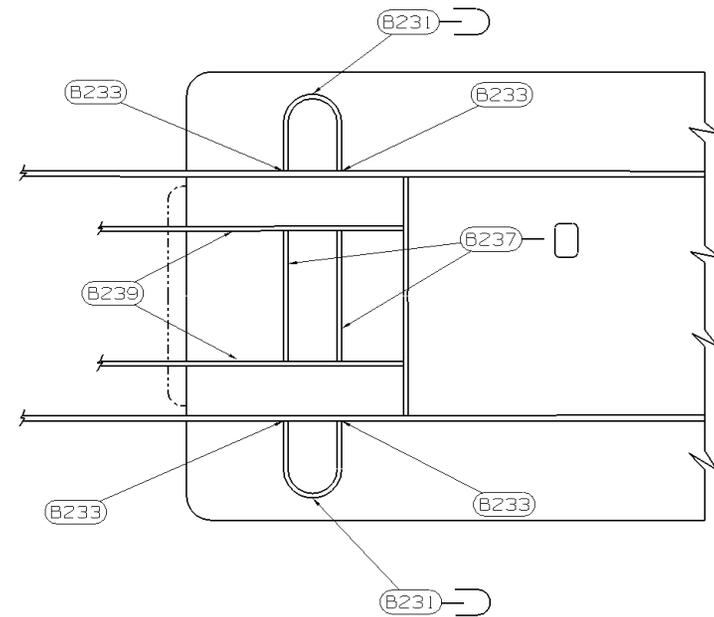


Location Designations:

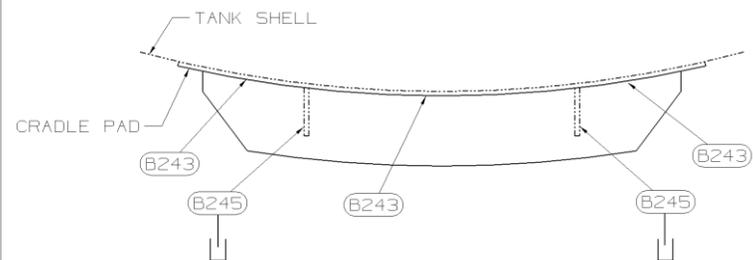
Z-Section Stub Sill Modification (ACF230)

Code	Description	Location	Inspect
B231	U-brace-to -cradle, U-shaped weld (top and bottom)	AR, AL, BR, BL	Full length of weld.
B233	U-brace-to -sill vertical weld.	ARO, ARI, ALO, ALI, BRO, BRI, BLO, BLI	Full length of weld.
B237	Transverse backstop plate-to-sill and cradle pad weld.	A, B	Full length of weld.
B239	Transverse backstop plate-to-longitudinal backstop weld.	AR, AL, BR, BL	Full length of weld.
B243	Mini-bolster-to-pad transverse weld.	A, B	Full length of weld.
B245	Mini-bolster-to-sill vertical weld.	AR, AL, BR, BL	Full length of weld.

Sketch/Description:



NOTE: OUTBOARD OF BOLSTER, WING BAR NOT SHOWN FOR CLARITY



NOTE: INBOARD OF BOLSTER AT END OF CRADLE PAD, LOOKING OUTBOARD.