

**Directive 2014/68/EU****Adopted by CLAP :** 26/11/2020**Directive References:** Annex I §3.2.1

Annex I §3.1.3

**Subject:** Welding of a pipe - Visual examination of welds, on the internal surface during the final assessment**Question:** Must an internal visual examination required as part of the final examination of point 3.2.1 of Annex I of the PED on circular welds of pipes or of connection between equipment constituting an assembly be carried out systematically?**Answer:**

No, the visual examination of the internal surfaces of welds does not to be carried out systematically.

It shall be carried out when the surface is accessible to a visual examination with the naked eye, at the final stage.

It shall also be carried out when required by the technical reference system or by the hazards and risks analysis, but in this case it is possible to take into account of the controls carried out during manufacture.

Where appropriate, visual examination of the final assessment is anticipated during the manufacturing process, if it is no longer possible at the final stage.

Note: Point 3.1.3 of Annex I of PED is not applicable to the personnel performing the visual examination (see CLAP X129 – PED Guideline F-07).