

Guideline

6/14

CLAP

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Permanent joining procedure

WPQ

Directive references:

Annex I § 3.1.1 - 97/23 EC

Annex I § 3.1.2 - 97/23 EC

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Subject: ESR on manufacturing – Welding on a pressure bearing component

Question: Does any welding operation on a pressure bearing component have to require a qualification of the welding procedures and of the welders/welding operators?

Answer: Yes, when the weldment can create a pressure hazard on the pressure bearing component.

Examples of welding operation for which qualification is required according to Annex I section 3.1.2 include:

- 1) Welding of a lifting lug on a pressure bearing chamber;
- 2) Welding of an attachment to a valve body;
- 3) Welding of reinforcing pads for nozzles;
- 4) Repair by welding on a chamber before placing on the market;
- 5) Major welding on a casting during production.

Examples of welding operations for which qualification is required according to Annex I section 3.1.2, unless the hazard analysis demonstrates that there is no pressure hazard, include:

- 6) Minor welding on a casting during production;
- 7) Buttering of a tube sheet;
- 8) Overlay welding on a pressure chamber (anticorrosive, wear coating...).

Modifications compared to the previous adopted version: Copy of the guideline 6/14 (19/01/2005).