

Guideline

6/5

CLAP

FORM N°33

Version : 6

Directive 97/23/EC

Keywords : Permanent joint

Welding

Brazing

Gluing

Qualification

Directive references: Annex I § 3.1.3 - 97/23 EC

Annex I § 3.1.2 - 97/23 EC

Adopted by WPG: 06/03/2012

Adopted by CLAP: 06/03/2012

Subject: ESR on manufacturing – Permanent joints

Question: Do the requirements related to permanent joints given in Annex I, sections 3.1.2 and 3.1.3 apply also to permanent joints other than welded joints?

Answer:

Yes

The definition in Article 1 paragraph 2.8 also covers other permanent joints such as e.g. those produced by brazing, braze welding, expansion, gluing, frottage and riveting.

For that reason, the requirements of 3.1.2 and 3.1.3 apply also for these types of joints.

Note: Removable expansion devices (e.g. expansion plug for sealing exchanger tubes) do not require destructive methods to be disconnected and therefore are not permanent joints.

Modifications compared to the previous adopted version: Copy of guideline 6/5 (06/03/2012).