

# **GENERAL REPAIR PROCEDURE FOR WELDS**

**FOR THE**

**MODIFY AS REQUIRED**

**Document No.:**

**Information Class: Confidential**

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### **1.0 PURPOSE**

This specification describes the methods utilized for the repair of weld defects found by radiography or ultrasonic examination.

NOTE: All NDE and welding performed per this specification shall be in accordance with approved contract procedures.

### **2.0 SCOPE**

This specification provides the method for repairing weld defects, examination and required records.

### **3.0 RESPONSIBILITIES**

The assigned Quality Manager shall be responsible for controlling repairs in this procedure.

### **4.0 PROCEDURE**

#### 4.1 Procedure:

- 4.1.1 Remove the defect by gouging, grinding, or chipping.
- 4.1.2 Visually Inspect (VI) the cavity to verify removal of the defect, or that the indication has been reduced to an acceptable level, and for weldability.
- 4.1.3 Weld the cavity.
- 4.1.4 VI the completed weld repair.
- 4.1.5 Examine (RT or UT) the completed weld repair by the original method that discovered the defect.

#### 4.2 Records:

Records required to control and document welding and NDE are contract records and shall be maintained by the Welding Manager, QC Manager or other Responsible Management as required by contract, Code, jurisdiction and requirements. They typically include the following:

- WPS and NDE procedures
- Process Control Documents
- Reports

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### 5.0 REFERENCES

ASME Section I	Rules for Construction of Power Boilers
ASME Section VIII	Rules for Construction of Pressure Vessels
B31.3	ASME Code for Process Piping
NBIC	National Board Inspection Code
API 510	Pressure Vessel Inspection Code: Maintenance Inspection,

### 6.0 TERMINOLOGY

<u>Term</u>	<u>Definition</u>
NDE	Nondestructive Examination
RT	Radiographic Examination
UT	Ultrasonic Examination
VI	Visual Inspection
WPS	Welding Procedure Specification

### 7.0 EXHIBITS

None