

# SECTION IX

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**Interpretation: IX-07-07**

Subject: QW-404.22, Use of Consumable Inserts (2007 Edition)

Date Issued: February 12, 2008

File: 08-40

Background: QW-356 lists the essential variables for Welder Performance Qualification for manual GTAW. QW-404.22, the use of consumable inserts, is an essential variable for Welder Performance Qualification within QW-356.

An individual performs the following two qualification tests:

(a) Groove weld using the GTAW-machine process on a NPS 6 (DN 150) Schedule 40 pipe coupon with a consumable insert.

(b) Groove weld using the GTAW-machine process on a NPS 6 (DN 150) Schedule 40 pipe coupon with an open root.

Each qualification test is performed independently and welded full thickness by the process used to make the root weld.

Question (1): Is this individual qualified to weld a NPS 6 (DN 150) Schedule 40 pipe groove weld by making the root weld with the GTAW-machine process with a consumable insert and then completing the weld using the GTAW-manual process?

Reply (1): Yes.

Question (2): Is this individual qualified to make non-through-wall weld repairs using the GTAW-manual process to a NPS 6 (DN 150) Schedule 40 pipe groove weld that was originally performed using the GTAW-machine process with a consumable insert?

Reply (2): Yes.

Question (3): Is this individual qualified to make through-wall repairs using the GTAW-manual process to the root of a NPS 6 (DN 150) Schedule 40 pipe groove weld that was originally performed using the GTAW-machine process with a consumable insert if the defect removal results in a repair cavity with an open root?

Reply (3): Yes.

**Interpretation: IX-07-08**

Subject: QW-200.2(c), Changes to PQR (2007 Edition)

Date Issued: February 12, 2008

File: 08-209

Question (1): Can additional tests and data that are not required by Section IX (i.e., hardness ferrite, corrosion, etc.) be added to a PQR at a later date when the testing was not performed as part of the original PQR, but followed the conditions of the original qualification?

Reply (1): Yes.

Question (2): If the tests and data noted in Question (1) are added to the PQR, would recertification, including date, be required?

Reply (2): Yes. All changes to a PQR require recertification (including date) by the manufacturer or contractor per QW-200.2(c).

**Interpretation: IX-07-09**

Subject: QW-401.3 and QW-403.6, Thickness Range Qualified for Impact Testing (2007 Edition)

Date Issued: May 1, 2008

File: 08-576

Background: A welding procedure qualification was performed on a 1-in. (25-mm) thick test coupon. Tension and bend tests were performed on the 1-in. (25-mm) plate. A second welding procedure qualification was performed on a 0.24-in. (6-mm) plate and only impact testing was performed. All of the essential and supplementary essential variables remained the same except for the coupon thickness.

Question: May the above PQRs be used to support a WPS for material requiring notch toughness with a qualified thickness range of 0.1875 in. (5 mm) to 2 in. (50 mm)?

Reply: Yes.