

## SECTION IX

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**Interpretation: IX-13-10**

Subject: QW-201

Date Issued: March 21, 2013

File: 13-119

Question: Company A owns Companies B and C. May Company B use WPSs qualified by Company C in accordance with the requirements of Section IX without requalification, provided Company C describes the process that they follow in their Quality Control System/Quality Assurance Program for the operational control of procedure qualification?

Reply: Yes.

**Interpretation: IX-13-11**

Subject: QW-409.1 and QW-409.8, Reference to Nonmandatory Appendix H

Date Issued: March 25, 2013

File: 13-274

Background: QW-409.1 and QW-409.8 variables reference Nonmandatory Appendix H as a guideline for understanding of Waveform Controlled Welding when qualifying personnel and procedures.

Question (1): Does Nonmandatory Appendix H become an essential, nonessential, or supplementary essential variable when it is referenced within the text of a variable?

Reply (1): No.

Question (2): Does either QW-409.1 or QW-409.8 require that power or energy shall be specified in the WPS when using a waveform controlled power source?

Reply (2): No.

**Interpretation: IX-13-12**

Subject: QW-410.9

Date Issued: June 10, 2013

File: 12-1529

Background: Impact testing of welding procedure qualifications is required by the Construction Code and QW-410.9 applies to the welding process used as a supplementary essential variable. QW-410.9 requires requalification for a change from multipass per side to single pass per side. Per QW/QB-492 Definitions, a pass can result in a weld bead or a layer.

Question (1): Does QW-410.9 regard multiple layer welds as multipass welds, so that a change from multiple layers per side to a single layer per side requires a requalification?

Reply (1): Yes, when the single layer is made in a single pass.

Question (2): Does QW-410.9 regard multiple beads in a single layer (as shown in beads 3, 4, 5, and 6 of Figure QW/QB-492.1) as “multipass”?

Reply (2): Yes.

Question (3): A Welding Procedure Specification is qualified with multiple layers per side. Can this WPS be used to deposit multiple beads in a single layer per side, within the limits of all other essential and supplementary essential variables?

Reply (3): Yes.

**Interpretation: IX-13-13**

Subject: QW-423.1

Date Issued: June 10, 2013

File: 12-2295

Question: In accordance with QW-423.1, may P-No. 1 base materials be substituted for P-No. 8 base materials when following a P-No. 8 to P-No. 8 WPS for the purpose of a welder qualification, when variable QW-403.18 applies?

Reply: Yes.

**Interpretation: IX-13-14**

Subject: QW-360, Welding Operator Performance Qualifications

Date Issued: June 10, 2013

File: 13-9

Question: While base metal P-Number is an essential variable for welder qualifications, QW-360 does not specify base metal P-Number as an essential variable for welding operator qualification. Is it required that welding operators be qualified separately for welding Code Case base metals when the Code Case specifies that "Separate welding procedure and performance qualifications shall be conducted for the material in accordance with Section IX"?

Reply: Yes.

**Interpretation: IX-13-15**

Subject: QW-322, Expiration and Renewal Qualification

Date Issued: June 10, 2013

File: 13-131

Background: A welder is qualified for a shop that fabricates Section VIII, Division 1 vessels as well as non-Code equipment. A welder maintains his welding process qualification for Code welds by making non-Code welds.

Question (1): May a welder maintain his welding process qualification by making non-Code welds if the welder has not made a Code weld for a period of 6 mo or more?

Reply (1): Yes, see IX-83-159.

Question (2): According to QW-322.1(a)(1), can a welder receive a 6-mo qualification extension more than once?

Reply (2): Yes.

**Interpretation: IX-13-16**

Subject: QW-202.4, Dissimilar Base Metal Thicknesses

Date Issued: June 10, 2013

File: 13-635

Question: When employing a WPS to join flat plates of dissimilar thickness in a groove-weld tee joint, is it a requirement of QW-202.4 that both the thicker and thinner members must be qualified within the range permitted by QW-451 unless the alternative provided in QW-202.4 is used?

Reply: Yes.