

SECTION IX

<u>Subject</u>	<u>Interpretation</u>	<u>File No.</u>
QG-108 (2013 Edition)	IX-13-21	13-1044
QW-200 and QW-300	IX-13-20	13-939
QW-261, Stud Welding Procedure Qualification	IX-13-18	13-568
QW-404.4 and QW-404.30, Change in F-Number and Base Metal Thickness Range	IX-13-17	13-161
QW-404.12, Hard-Facing Filler Metal Classification	IX-13-19	13-727
QW-405.2 and QW-410.1, Stringer/Weave Technique	IX-13-23	13-1559
QW-452.3, Groove-Weld Diameter Limits	IX-13-22	13-1154

Interpretation: IX-13-17

Subject: QW-404.4 and QW-404.30, Change in F-Number and Base Metal Thickness Range

Date Issued: August 27, 2013

File: 13-161

Background: A WPS with supporting PQR was written and qualified without impact testing in 1978 to the 1977 Code without addenda, on a NPS 2 (EN50) diameter \times 0.432 in. (11 mm) wall thickness pipe. The procedure was qualified in 6G position using an E6011 (F-No. 3) electrode on the root pass and completed with two fill passes with E7018 (F-No. 4) electrodes. The deposit thickness for the root and fill passes was not recorded on the PQR or specified individually on the WPS.

Question (1): Provided the WPS and PQR meet all requirements of the 1977 Edition of ASME Section IX Code, may the WPS continue to be used without revision for work being completed to the 1977 ASME Code?

Reply (1): Yes.

Question (2): May a new WPS be written or revised without specifying weld metal thickness range for each welding electrode (E6011 and E7018) with the WPS prepared to the 2010 Edition of ASME Section IX Code with 2011a Addenda, using the PQR qualified to the 1977 Code?

Reply (2): No.

Question (3): Is the deposit thickness required to be recorded individually on the PQR and WPS for each F-Number electrode used for the root pass deposited with the E6011 electrode and the fill passes deposited with E7018 electrodes qualified to the 2010 Edition of ASME Section IX Code with 2011a Addenda?

Reply (3): Yes.

Interpretation: IX-13-18

Subject: QW-261, Stud Welding Procedure Qualification

Date Issued: August 27, 2013

File: 13-568

Background: The requirements in QW-261, Stud Welding: essential variable QW-402.8 addresses the stud size and shape, and essential variable QW-403.17 addresses base metal and stud metal P-Numbers. However, there are no requirements regarding base metal thickness.

Question: Is the base metal thickness a variable for stud welding?

Reply: No.

Interpretation: IX-13-19

Subject: QW-404.12, Hard-Facing Filler Metal Classification

Date Issued: August 27, 2013

File: 13-727

Question: A PQR shows SFA-5.21 metal cored filler metal classification ERCCoCr-A was used to qualify GTAW hard-facing overlay WPS. Does this PQR support a GTAW hard-facing overlay WPS using SFA-5.21 bare (solid) filler metal classification ERCoCr-A?

Reply: No.

Interpretation: IX-13-20

Subject: QW-200 and QW-300

Date Issued: August 27, 2013

File: 13-939

Question (1): When preparing Procedure Qualification Records (PQR) and Welding Performance Qualification (WPQ) test records in accordance with the requirements of QW-200 and QW-300, is it required to use the word "Certify" on the PQR and WPQ documents?

Reply (1): Yes.

Question (2): Are Welding Procedure Specifications (WPSs) required to be certified?

Reply (2): No.

Question (3): Is it required that a manufacturer or contractor be an ASME certificate holder in order to certify qualification records?

Reply (3): No.

Interpretation: IX-13-21

Subject: QG-108 (2013 Edition)

Date Issued: August 27, 2013

File: 13-1044

Question: In the 2013 Edition of Section IX, QG-108 requires that all new qualifications of joining processes and personnel be in accordance with the current edition. In previous editions of Section IX, the foreword indicated that new editions became mandatory 6 months after date of issue. Does that requirement apply to the 2013 Edition?

Reply: Yes.

Interpretation: IX-13-22

Subject: QW-452.3, Groove-Weld Diameter Limits

Date Issued: August 27, 2013

File: 13-1154

Question (1): Does QW-452.3 apply to welding operators?

Reply (1): No.

Question (2): Does QW-452.3 apply to welders?

Reply (2): Yes.

Question (3): If a welder qualifies by making a groove weld on NPS 2 pipe, is the welder qualified to weld NPS $\frac{3}{4}$ pipe (outside diameter 1.04 in.)?

Reply (3): Yes.

Interpretation: IX-13-23

Subject: QW-405.2 and QW-410.1, Stringer/Weave Technique

Date Issued: December 5, 2013

File: 13-1559

Background: A procedure qualification test coupon is performed in the 6G position, using a manual or semi-automatic welding process, with weld progression being vertical uphill.

Question (1): When notch toughness qualification is not applicable, does a change from stringer bead to weave technique require requalification?

Reply (1): No.

Question (2): When notch toughness qualification is applicable, does a change from stringer bead to weave technique require requalification?

Reply (2): Yes.