SECTION IX

Interpretation: IX-13-24

Subject: QW-404.14, Essential Variables

Date Issued: February 20, 2014

File: 14-370

Background: A welding procedure was qualified to Section IX for the GTAW process using ER70S-2 filler metal, a double V-groove joint design, and with multiple passes as specified in the PQR.

Question: Does listing the filler metal classification, double V-groove joint design, and that multiple passes are required on both the WPS and PQR satisfy the requirement to address the addition or deletion of filler metal in QW-404.14?

Reply: Yes.

Interpretation: IX-13-25

Subject: QW-301.4, Record of Tests

Date Issued: February 20, 2014

File: 14-371

Background: Welders are qualified using a qualified WPS at the time of their welding tests, in accordance with the requirements specified in QW-300.2 and QW-301.2.

Question: Is it a requirement of Section IX that the WPS followed at the time of a welder's qualification test be listed on the welder performance qualification report for that welder?

Reply: No.

Interpretation: IX-13-26

Subject: Table QW-461.9

Date Issued: February 27, 2014

File: 11-2192

Question: May special positions as addressed in Table QW-461.9 be used to establish welding positions for welder and welding operator performance qualification where the pipe, instead of the torch, is rotated during welding?

Reply: Yes.

Interpretation: IX-13-27

Subject: QW-202.2, WPS Qualification Using Bar Stock Test Coupon

Date Issued: February 27, 2014

File: 13-634

Background: A test coupon is prepared using a 2-in. diameter round bar stock with a $^{3}/_{8}$-in. deep circumferential groove that is welded flush with the O.D. of the bar. A $1^{1}/_{4}$-in. diameter hole is bored into the center, effectively making the test coupon a 2-in. O.D. pipe having a $^{3}/_{8}$-in. wall thickness.

Question: Does Section IX address the qualified base metal thickness range for test coupons prepared using round bar stock?

Reply: No.

Interpretation: IX-13-28

Subject: QW-161.1, QW-161.5, and QW-462.2; Bend Testing

Date Issued: March 3, 2014

File: 14-438

Question (1): Does QW-161.1 require that the entire length of the weld of a corrosion-resistant weld metal overlay bend test specimen be within the bent portion of the specimen after testing?

Reply (1): No.

Question (2): Does QW-161.5 permit the use of longitudinal bend specimens in lieu of the transverse side bends for procedure qualification of a corrosion-resistant weld metal overlay in which the weld metal and base metal differ markedly in bending properties?

Reply (2): No; see Figure QW-462.5(d).

Question (3): Does the General Note of QW-462.2 apply to corrosion-resistant weld metal overlays?

Reply (3): No.

Interpretation: IX-13-29

Subject: QW-304, Volumetric Examination of Welder or Welding Operator Performance Qualification Tests for Unassigned Base Metals

Date Issued: May 29, 2014

File: 13-598

Question: A welder performance qualification is performed using two coupons of the same unassigned base metal with the manual GTAW process. The unassigned base metal is a similar composition (same UNS number) as a P-No. 61 base metal. May the completed test coupon be examined by a volumetric NDE method?

Reply: No.

Interpretation: IX-13-30

Subject: QW-322.1(a), Expiration of Qualification

Date Issued: May 29, 2014

File: 14-255

Background: A welder/welding operator is required to weld with a process within a 6-month period, in order to maintain qualification to use that process. A welder/welding operator takes a performance qualification test using a process for which the welder is already qualified (e.g., SMAW), but with different essential variables (e.g., different F-number, progression, etc.). During the performance of the test, the organization responsible for supervising and controlling the test visually examines the weld and determines that it meets the visual acceptance criteria of QW-194. Subsequently, the test coupon is subjected to volumetric NDE or mechanical testing, and fails to meet the acceptance criteria.

Question: May a failed performance qualification test, utilizing a process for which the welder/welding operator is currently qualified, satisfy the requirements of QW-322.1(a) for maintaining continuity?

Reply: Yes.

Interpretation: IX-13-31

Subject: Table QW/QB-422, P-Number Assignment

Date Issued: May 29, 2014

File: 14-510

Background: Prior to the 2007 Edition, Table QW/QB-422 listed SA-336 F304H UNS S30409 with P-No. 8, Group No. 1. SA-336 F304H UNS S30409 was replaced by SA-965 F304H UNS S30409 in the 2007 Edition of Section IX in order to reflect the Section II, Part A material specification changes.

Question: Is SA-336 F304H UNS S30409 considered P-No. 8, Group No. 1?

Reply: Yes.

Interpretation: IX-13-32

Subject: QW-163, Acceptance Criteria – Bend Tests

Date Issued: May 29, 2014

File: 14-557

Question (1): Does the acceptance criteria for the convex surface of guided bend test specimens, which states a maximum acceptable discontinuity length of $^1/_8$ in. (3 mm), apply to each specimen individually?

Reply (1): Yes.

Question (2): Is the acceptance criteria for the convex surface of guided bend test specimens, which states a maximum acceptable discontinuity length of $^1/_8$ in. (3 mm), the cumulative total length permitted on all of the specimens required for a single qualification?

Reply (2): No.