Record 17-164

Errata:

Record 12-1688 As-Approved

II-3 FLAW ACCEPTANCE STANDARDS FOR FULL PENETRATION FERRITIC WELDS IN VESSEL AND NOZZLE-TO-VESSEL JOINTS

(a) The acceptance standards shall apply for materials that meet the requirements of NB-2330 or NC-2330 and Appendix G-2110.
(b) For vessels equal to or less than 12 in. (300mm) thickness, a fabrication subsurface flaw shall not exceed the following regardless of length (see Fig. 1 and Table II-A):
   (1) For \(0.4 \leq S/d < 1.0\), maximum allowable flaw depth \(2d = (S/d)^{0.90} \times 0.04t\)
   (2) For \(S/d \geq 1.0\), maximum allowable flaw depth \(2d = 0.04t\)
   (c) For vessels equal to or greater than 16 in. (400mm) thickness, a fabrication subsurface flaw shall not exceed the following regardless of length (see Fig. 1 and Table II-A):
   (1) For \(0.4 \leq S/d < 1.0\), maximum allowable flaw depth \(2d = (S/d)^{0.90} \times 0.03t\)
   (2) For \(S/d \geq 1.0\), maximum allowable flaw depth \(2d = 0.03t\)
   (d) For vessels greater than 12 in. (300mm) and less than 16 in. (400mm) thickness, for INFO only:

Editorial Clarification:

Proposed Reformat:

Table II-1
Subsurface Flaw Acceptance Criteria

<table>
<thead>
<tr>
<th>Item Examined</th>
<th>Reference</th>
<th>(S/d) Ratio (See Figure 1)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>(0.4)</td>
<td>(0.5)</td>
</tr>
<tr>
<td>Pipe or Nozzle Butt</td>
<td>II-2(b)</td>
<td>0.083t</td>
</tr>
<tr>
<td>Vessel, (t \leq 12) in. (300 mm)</td>
<td>II-3(b)</td>
<td>0.016t</td>
</tr>
<tr>
<td>Vessel, (t \geq 16) in. (400 mm)</td>
<td>II-3(c)</td>
<td>0.012t</td>
</tr>
</tbody>
</table>

GENERAL NOTE: For vessels 12 in. (300 mm) < \(t < 16\) in. (400 mm), maximum allowable flaw depths are to be determined by linear interpolation between the II-3(b) and II-3(c) values.