Figure CC-4542.2-2
Typical Category D Joints for Nozzle Diameters NPS 3 (DN 80) and Less (Cont'd)

Either method of attachment is satisfactory

Either method of attachment is satisfactory

1/4 in. (6 mm) minimum

1/2t min.

GENERAL NOTE: For definition of symbols, see CC-3042.10.

(b) The finished surface of the reinforcement of all butt welded joints may be flush with the base material or may have reasonably uniform crowns, the maximum on each side not to exceed the thicknesses of Table CC-4542.8.1-1.

CC-4542.9 Fillet Welds. Fillet welds may vary from convex to concave. The size of the weld shall be determined in accordance with Figure CC-4542.9-1.

CC-4543 Welding of Attachments

CC-4543.1 Material for Permanent Structural Attachments. Material for lugs, brackets, stiffeners, and other permanent structural attachments that are permanently welded to liners shall meet the requirements of liner material (CC-2500 except CC-2530). If the welds are exempt from postweld heat treatment (CC-4522), the attachments shall meet the fracture toughness requirements of CC-2520 if required by CC-2521.1.

CC-4543.2 Welding of Permanent Structural Attachments. The rules of CC-4532.1 governing welding qualifications shall apply to the welding of both internal and external permanent structural attachments to liner material. Welds shall meet the postweld heat treatment requirements of CC-4552.

CC-4543.3 Lugs and Fitting Attachments. All lugs, brackets, saddle type nozzles, manhole frames, reinforcement around openings, and other appurtenances shall conform reasonably to the curvature of the shell or surface to which they are attached.

CC-4543.4 Welding of Nonstructural and Temporary Attachments. Nonstructural attachments, such as lifting lugs, insulation supports, nameplates, locating lugs, and temporary attachments may be noncertified material and may be welded directly to the liner with continuous or intermittent fillet or partial penetration welds, provided the requirements of (a) through (e) below are met.