to monitor growth of existing flaws in accordance with IWA-2234. For vessel welds, the successive inspection is not required if the following conditions are met:

1. The flaw is characterized as subsurface in accordance with Figure IWA-3320-2.

2. The weld containing the flaw is acceptable for continued service in accordance with IWC-3600, and the flaw is demonstrated acceptable for the intended service life of the component.

(c) If a component is accepted for continued service in accordance with IWC-3132.3(a), successive examinations shall be performed, if determined necessary, based on an evaluation by the Owner. The evaluation shall be documented and shall include the cause of the relevant condition, if known. If the cause of the relevant condition is unknown or if the relevant condition has previously occurred, successive examinations shall be performed during each successive inspection period until the relevant condition remains essentially unchanged from the previous inspection.

(d) If the reexaminations required by (b) above reveal that the flaws remain essentially unchanged, or that flaw growth is within the growth predicted by the analytical evaluation, for the next inspection period, then the component examination schedule may revert to the original schedule of successive inspections or the inspection interval defined by the analytical evaluation, whichever is limiting.

(e) If the reexaminations required by (b) or (c) above reveal new flaws or relevant conditions that exceed the applicable acceptance standards of Table IWC-3410-1, or growth of existing flaws in excess of the growth predicted by the analytical evaluation, then

1. The entire weld, area, or part \(^{34}\) shall be examined during the current outage
2. Additional examinations shall be performed in accordance with IWC-2430

(f) If welded attachments are examined as a result of identified component support deformation and the results of these examinations exceed the acceptance standards of Table IWC-3410-1, successive examinations shall be performed, if determined necessary, based on an evaluation by the Owner. The evaluation shall be documented and shall include the cause of the welded attachment damage if known. If the cause of the welded attachment damage could recur or is unknown, successive examinations shall be performed in accordance with (1) above. No subsequent examinations are required if either of the following applies:

1. There are no other welded attachments subject to the same apparent or root cause conditions.
2. The designation mechanism no longer exists.

### IWC-2430 ADDITIONAL EXAMINATIONS

(a) Examinations performed in accordance with Tables IWC-2500-1 (C-A) through IWC-2500-1 (C-F-2) that reveal flaws or relevant conditions exceeding the acceptance standards of Table IWC-3410-1 shall be extended to include additional examinations during the current outage in accordance with (1) or (2) below.

1. Additional examinations shall be performed in accordance with the following requirements:
   1. The additional examinations shall include an additional number of welds, areas, or parts \(^{34}\) included in the inspection item \(^{35}\) equal to 20% of the number of welds, areas, or parts included in the inspection item that are scheduled to be performed during the interval. The additional examinations shall be selected from welds, areas, or parts of similar material and service. This additional selection may require inclusion of piping systems other than the one containing the flaws or relevant conditions.

   (b) If the additional examinations required by (a) above reveal flaws or relevant conditions exceeding the acceptance standards of Table IWC-3410-1, the examinations shall be further extended to include additional examinations during the current outage. These additional examinations shall include the remaining number of welds, areas, or parts of similar material and service subject to the same type of flaws or relevant conditions.

   2. Additional examinations shall be performed in accordance with the following requirements:
      1. An evaluation shall be performed. Topics to be addressed in the evaluation shall include the following:
         1. A determination of the cause of the flaws or relevant conditions
         2. An evaluation of applicable service conditions and degradation mechanisms to establish that the affected welds, areas, or parts \(^{34}\) will perform their intended safety functions during subsequent operation
         3. A determination of which additional welds, areas, or parts \(^{34}\) are subject to the same service conditions and degradation mechanisms that caused the flaws or relevant conditions

   (b) Additional examinations shall be performed on all those welds, areas, or parts \(^{34}\) subject to the same service conditions and degradation mechanisms that caused the flaws or relevant conditions. This additional selection might require inclusion of piping systems other than the one containing the original flaws or relevant conditions. No additional examinations are required if the evaluation concludes that

   1. There are no additional welds, areas, or parts subject to the same service conditions that caused the flaws or relevant conditions or
   2. No degradation mechanism exists

   (c) The evaluation shall be retained in accordance with Article IWA-6000.

(b) The examination method for additional examinations may be limited to the examination method that originally identified the flaws or relevant conditions, provided use of the method is supported by an evaluation. The evaluation shall determine the cause of the flaws or relevant conditions.
(c) If the reexaminations required by (b) above reveal that the flaws or relevant conditions remain essentially unchanged, or that the flaw growth is within the growth predicted by the analytical evaluation, for the next inspection period, then the component examination schedule may revert to the original schedule of successive inspections or the inspection interval defined by the analytical evaluation, whichever is limiting.

(d) If the reexaminations required by (b) above reveal new flaws or relevant conditions that exceed the applicable acceptance standards of Table IWC-3410-1, or growth of existing flaws in excess of the growth predicted by the analytical evaluation, then:

(1) the entire weld, area, or part\(^1\) shall be examined during the current outage

(2) additional examinations shall be performed in accordance with IWC-2430

(e) If welded attachments are examined as a result of identified component support deformation and the results of these examinations exceed the acceptance standards of Table IWC-3410-1 successive examinations shall be performed, if determined necessary, based on an evaluation by the Owner. The evaluation shall be documented and shall include the cause of the welded attachment damage if known. If the cause of the welded attachment damage could recur or is unknown, successive examinations shall be performed in accordance with the requirements of (b) above. No successive examinations are required if either of the following applies:

(1) There are no other welded attachments subject to the same apparent or root cause conditions.

(2) The designation mechanism no longer exists.

(10) **IWC-2430 ADDITIONAL EXAMINATIONS**

(a) Examinations performed in accordance with Table IWC-2500-1, except for Examination Category C-H, that reveal flaws or relevant conditions exceeding the acceptance standards of Table IWC-3410-1 shall be extended to include additional examinations during the current outage in accordance with (1) or (2) below.

(1) Additional examinations shall be performed in accordance with the following requirements:

(a) The additional examinations shall include an additional number of welds, areas, or parts\(^1\) included in the inspection item\(^2\) equal to 20% of the number of welds, areas, or parts included in the inspection item that are scheduled to be performed during the interval. The additional examinations shall be selected from welds, areas, or parts of similar material and service. This additional selection may require inclusion of piping systems other than the one containing the flaws or relevant conditions.

(b) If the additional examinations required by (a)(1)(a) above reveal flaws or relevant conditions exceeding the acceptance standards of Table IWC-3410-1, the examinations shall be further extended to include additional examinations during the current outage. These additional examinations shall include the remaining number of welds, areas, or parts of similar material and service subject to the same type of flaws or relevant conditions.

(2) Additional examinations shall be performed in accordance with the following requirements:

(a) An engineering evaluation shall be performed. Topics to be addressed in the engineering evaluation shall include the following:

(1) a determination of the cause of the flaws or relevant conditions

(2) an evaluation of applicable service conditions and degradation mechanisms to establish that the affected welds, areas, or parts\(^1\) will perform their intended safety functions during subsequent operation

(3) a determination of which additional welds, areas, or parts\(^1\) are subject to the same service conditions and degradation mechanisms that caused the flaws or relevant conditions

(b) Additional examinations shall be performed on all those welds, areas, or parts\(^1\) subject to the same service conditions and degradation mechanisms that caused the flaws or relevant conditions. This additional selection might require inclusion of piping systems other than the one containing the original flaws or relevant conditions. Additional examinations are required if the engineering evaluation concludes that

(1) there are no additional welds, areas, or parts subject to the same service conditions that caused the flaws or relevant conditions or

(2) no degradation mechanism exists

(c) The engineering evaluation shall be retained in accordance with IWA-6000.

(b) The examination method for additional examinations may be limited to the examination method that originally identified the flaws or relevant conditions, provided use of the method is supported by an engineering evaluation. The engineering evaluation shall determine the cause of the flaws or relevant conditions and the appropriate method to be used as part of the additional examination scope. The engineering evaluation shall be retained in accordance with IWA-6000.

(c) For the inspection period following the period in which the examinations of IWC-2430(a) were completed, the examinations shall be performed as originally scheduled in accordance with IWC-2400.

---

1 Welds, areas, or parts are those described or intended in a particular inspection item of Table IWC-2500-1.

2 An inspection item, as listed in Table IWC-2500-1, may comprise a number of welds, areas, or parts of a component required to be examined in accordance with the inspection plan and schedule (IWC-2420).
(c) If the reexaminations required by (b) above reveal that the flaws or relevant conditions remain essentially unchanged, or that the flaw growth is within the growth predicted by the analytical evaluation, for the next inspection period, then the component examination schedule may revert to the original schedule of successive inspections or the inspection interval defined by the analytical evaluation, whichever is limiting.

(d) If the reexaminations required by (b) above reveal new flaws or relevant conditions that exceed the applicable acceptance standards of Table IWC-3410-1, or growth of existing flaws in excess of the growth predicted by the analytical evaluation, then

(1) the entire weld, area, or part\(^1\) shall be examined during the current outage

(2) additional examinations shall be performed in accordance with IWC-2430

(e) If welded attachments are examined as a result of identified component support deformation and the results of these examinations exceed the acceptance standards of Table IWC-3410-1 successive examinations shall be performed, if determined necessary, based on an evaluation by the Owner. The evaluation shall be documented and shall include the cause of the welded attachment damage if known. If the cause of the welded attachment damage could recur or is unknown, successive examinations shall be performed in accordance with the requirements of (b) above. No successive examinations are required if either of the following applies:

(1) There are no other welded attachments subject to the same apparent or root cause conditions.

(2) The degradation mechanism no longer exists.

IWC-2430 ADDITIONAL EXAMINATIONS

(a) Examinations performed in accordance with Table IWC-2500-1, except for Examination Category C-H, that reveal flaws or relevant conditions exceeding the acceptance standards of Table IWC-3410-1 shall be extended to include additional examinations during the current outage. The additional examinations shall include an additional number of welds, areas, or parts\(^2\) included in the inspection item equal to 20% of the number of welds, areas, or parts included in the inspection item that are scheduled to be performed during the interval. The additional examinations shall be selected from welds, areas, or parts of similar material and service. This additional selection may require inclusion of piping systems other than the one containing the flaws or relevant conditions.

(b) If the additional examinations required by (a) above reveal flaws or relevant conditions exceeding the acceptance standards of Table IWC-3410-1, the examinations shall be further extended to include additional examinations during the current outage. These additional examinations shall include the remaining number of welds, areas, or parts of similar material and service subject to the same type of flaws or relevant conditions.

(c) For the inspection period following the period in which the examinations of (a) or (b) above were completed, the examinations shall be performed as originally scheduled in accordance with IWC-2400.

(d) If welded attachments are examined as a result of identified component support deformation and the results of these examinations exceed the acceptance standards of Table IWC-3410-1 additional examinations shall be performed, if determined necessary, based on an evaluation by the Owner. The evaluation shall be documented and shall include the cause of the welded attachment damage if known. If the cause of the welded attachment damage could recur or is unknown, additional examinations shall be performed in accordance with the requirements of (a) above. No additional examinations are required if either of the following applies:

(1) There are no other welded attachments subject to the same apparent or root cause conditions.

(2) The degradation mechanism no longer exists.

IWC-2500 EXAMINATION AND PRESSURE TEST REQUIREMENTS

(a) Components shall be examined and pressure tested as specified in Table IWC-2500-1. The method of examination for the components and parts of the pressure retaining boundaries shall comply with those tabulated in Table IWC-2500-1, except where alternate examination methods are used that meet the requirements of IWA-2240.

(b) Table IWC-2500-1 is organized as follows.

<table>
<thead>
<tr>
<th>Examination Category</th>
<th>Examination Area</th>
</tr>
</thead>
<tbody>
<tr>
<td>C-A</td>
<td>Pressure Retaining Welds in Pressure Vessels</td>
</tr>
<tr>
<td>C-B</td>
<td>Pressure Retaining Nozzle Welds in Pressure Vessels</td>
</tr>
<tr>
<td>C-C</td>
<td>Welded Attachments for Pressure Vessels, Piping, Pumps, and Valves</td>
</tr>
<tr>
<td>C-D</td>
<td>Pressure Retaining Bolting Greater Than 2 in. (50 mm) in Diameter</td>
</tr>
<tr>
<td>C-F-1</td>
<td>Pressure Retaining Welds in Austenitic Stainless Steel or High Alloy Piping</td>
</tr>
<tr>
<td>C-F-2</td>
<td>Pressure Retaining Welds in Carbon or Low Alloy Steel Piping</td>
</tr>
<tr>
<td>C-H</td>
<td>All Pressure Retaining Components</td>
</tr>
</tbody>
</table>

(c) Alternatively, for Examination Categories C-F-1 and C-F-2, the provisions of Appendix R may be applied to all Class 2 piping or to one or more individual piping systems.
View Component Record# 07-1200

* Required field

A. Record Information

1. Record# 07-1200
2. Primary Committee Responsible BPV XI
3. Record Level Board Approved
4. Record Sub-Type Revision

Committees Involved in This Record

5. Board
   Boards Included
   Board on Nuclear C&S

6. Standards Committee
   BPV Standards Comm. BPV XI

7. Sub-Tier Committee
   None

9. Last Updated By: CraneR
10. Last Updated On: 03/23/2009

B. Record Description

1. Subject *
Imprecise Language – Welded Attachment Evaluation Requirements IWX-2420 and IWX-2430 for Successive and Additional Examinations

2. Proposal
Add Requirements to Define “Evaluation” Under IWX-2420 and IWX-2430 for Welded Attachments and Change “root cause” Under IWD-2430(b) to “apparent or root cause.”

3. Explanation *
Currently, the requirements for successive and additional examinations of welded attachments in IWB-2420(e), IWB-2430(e), IWC-2420(d), IWC-2430(d), IWD-2420(d) and IWD-2430(d) all state that successive and additional examinations will be determined based on an evaluation by the Owner. What this action is proposing is a Code change that will provide the needed clarity to state what the evaluation is required to determine and then what action has to be taken. Additionally, the action Changes “root cause” to “apparent or root cause” under IWD-2430(b) to be consistent with an Owner’s use of these terms in a corrective action program.

4. Summary of Changes
Added requirements for welded attachment evaluations to determine successive and additional examinations and revised IWD-2430(b).

C. File Attachments

1. Proposal File
   (55KB) View Current Proposal File

2. Background Material File
   (1681KB) View Current Background Material File

3. Committee Correspondence File
D. Project Administrative Manager

1. Staff Contact
Ryan Crane, PE
craner@asme.org
1(212)591-7004

2. Staff Notes
None

E. Record Creator

F. Project Technical Manager

1. Project Manager
West, Raymond (Ray)
Raymond_A_West@sbcglobal.net
1(423)877-2471

2. Project Manager Notes
Note action and background information was revised based on responses to negatives under Letter Ballot 08-595.

G. Sub-Tier Committee Level

1. Original Inquirer Contact Information
None

2. Project Team Name
SGWCS

3. Project Team Members
None

4. Subcommittee Item History
08/07/08: A motion was made, seconded, and PASSED (29-0-0-0) to approve this item for a first consideration ballot.

H. Additional Committee information

1. Codes Affected by Proposed Revision
BPVC-XI

2. Related Committee Records
None

3. Proposal Keywords
None

4. Secondary Committee[s] w/Related Actions
Pending Committees

Committees Responded
None

5. Type (Nuclear Only)
None

6. Text of Subordinate Group Negatives
None

7. Subordinate Group Action Date
08/07/2008

I. Additional Standards Committee information

2. Standards

3. [Continued...]

https://cstools.asme.org/csconnect/SearchAction.cfm?TrackingNumber=1200&YearOpened=7&NoToolbar=yes
1. Standards Committee Description 1

There were neither negatives nor substantive comments on this item requiring technical changes. The proposal proceeds to publication in the 2009 Addenda or a future Code Case Supplement.

4. Standards Committee Description 2

None

7. Addenda/Edition Year

2009

J. Editor Input

1. Editor Acceptance of Proposed Revision Attachment
N/A

2. Editorial Review
(Activated only if ItemLevel = Board Approved)
Has not yet been reviewed by the editor for publication

3. Editor Notes

K. Latest Ballot

Ballot#: 09-39
Ballot Level: Board Procedural
Final Record Status: Approved
Date Opened: 01/12/09
Date Closed: 01/26/09
Record Status Date: 01/30/2009
Description:
BNCS Procedural Review of Records from BPV Standards Committee Ballots 08-1150, 08-1581 and 08-1582 for Publication in the 2009 Addenda to the ASME Boiler and Pressure Vessel Code

Voting Results:
All items approved. There were no objections.

Comments & Negatives Posted for Ballot#: 09-39

L. Ballot History

1. Board Ballot History
Ballot#: 09-39
Ballot Level: Board Procedural
Final Record Status: Approved
Date Opened: 01/12/09
Date Closed: 01/26/09
Record Status Date: 01/30/2009
Description:
BNCS Procedural Review of Records from BPV Standards Committee Ballots 08-1150, 08-1581 and 08-1582 for Publication in the 2009 Addenda to the ASME Boiler and Pressure Vessel Code

Voting Results:
All items approved. There were no objections.

2. Standards Committee Ballot History

https://cstools.asme.org/csconnect/SearchAction.cfm?TrackingNumber=1200&YearOpened=7&NoToolbar=yes
Ballot#: 08-1150 Please click on the Ballot# button to view comments / negatives for this ballot.
Ballot Level: Standards Committee
Final Record Status: Approved
Date Opened: 08/25/08
Date Closed: 10/01/08
Record Status Date: 01/08/2009
Description:
BPV Standards Committee Ballot on SC III and XI Nuclear Records from the August 4 to 8, 2008 Code Week

3. SC Ballot History

Ballot#: 08-595 Please click on the Ballot# button to view comments / negatives for this ballot.
Ballot Level: Subcommittee
Final Record Status: Disapproved
Date Opened: 04/29/08
Date Closed: 06/09/08
Description:
Section XI Items from the April 24, 2008 Subcommittee XI Meeting

Voting Results:
06-1555
Approved, 22
Disapproved, 1 (Yonekawa)
Abstain, 0
Not Voting, 0
Not Returned, 11 (Bamford, Cipolla, Dyle, Kulat, Lamond, Newton, Schaar, Spanner, Staffiera, Swayne, Yuhara)
Total, 34

06-855
Approved, 22
Disapproved, 1 (Park)
Abstain, 0
Not Voting, 0
Not Returned, 11 (Bamford, Cipolla, Dyle, Kulat, Lamond, Newton, Schaar, Spanner, Staffiera, Swayne, Yuhara)
Total, 34

07-1200
Approved, 17
Disapproved, 5 (Davis, Gimple, Park, Stevens, Waskey)
Abstain, 1 (Farrow)
Not Voting, 0
Not Returned, 11 (Bamford, Cipolla, Dyle, Kulat, Lamond, Newton, Schaar, Spanner, Staffiera, Swayne, Yuhara)
Total, 34

07-1630
Approved, 15
Disapproved, 5 (Davis, Gimple, Park, Waskey, West)
Abstain, 1 (Lindberg)
Not Voting, 0
Not Returned, 11 (Bamford, Cipolla, Dyle, Kulat, Lamond, Newton, Schaar, Spanner, Staffiera, Swayne, Yuhara)
Total, 34

07-1722
Approved, 23
Disapproved, 0
Abstain, 0
Not Voting, 0
Not Returned, 11 (Bamford, Cipolla, Dyle, Kulat, Lamond, Newton, Schaar, Spanner, Staffiera, Swayne, Yuhara)
Total, 34

07-1815
Approved, 20
Disapproved, 2 (Gimple, Norris)
Abstain, 1 (Farrow)
Not Returned, 11 (Bamford, Cipolla, Dyle, Kulat, Lamond, Newton, Schaar, Spanner, Staffiera, Swayne, Yuhara)
Total, 34

08-63
Approved, 15
Disapproved, 5 (Davis, Park, Scarth, Waskey, Yonekawa)
Abstain, 0
Not Voting, 3 (Henry, Rogers, Withers)
Not Returned, 11 (Bamford, Cipolla, Dyle, Kulat, Lamond, Newton, Schaaf, Spanner, Staffiera, Swayne, Yuhara)
Total, 34

M. ANSI Level

1. BSR-8 Record#: 1212
2. Date Submitted: 12/09/08
3. Designation: ASME BPV Revision - 20XX
4. Start Date: 12/19/08
5. End Date: 02/02/09

6. BSR-9 Record#: 937
7. Date Submitted: 06/19/09
8. Designation: ASME BPV Revision - 20XX
9. ANSI Approval Date: 07/10/09

N. Publications Level

<table>
<thead>
<tr>
<th>Publication Event</th>
<th>Date</th>
</tr>
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</table>

Minimum Site Requirements: IE 6.0+ • Firefox 2.0+ • Chrome 4.0+
<table>
<thead>
<tr>
<th></th>
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</thead>
<tbody>
<tr>
<td><strong>IWB-2420 SUCCESSIVE INSPECTIONS</strong></td>
<td><strong>INSERT NEW WORDS</strong></td>
</tr>
<tr>
<td>(a) The sequence of component examinations which was established during the first inspection interval shall be repeated during each successive inspection interval, to the extent practical.</td>
<td>The evaluation shall be documented and shall include the cause of the welded attachment damage if known. If the cause of the welded attachment damage could recur or is unknown, successive examinations shall be performed in accordance with the requirements of IWB-2420(b). No successive examinations are required if either of the following applies. (1) There are no other welded attachments subject to the same apparent or root cause conditions. (2) The degradation mechanism no longer exists.</td>
</tr>
<tr>
<td>(b) If a component is accepted for continued service in accordance with IWB-3132.3 or IWB-3142.4, the areas containing flaws or relevant conditions shall be reexamined during the next three inspection periods listed in the schedule of the inspection program of IWB-2400. Alternatively, acoustic emission may be used to monitor growth of existing flaws in accordance with IWA-2234.</td>
<td></td>
</tr>
<tr>
<td>(c) If the reexaminations required by IWB-2420(b) reveal that the flaws or relevant conditions remain essentially unchanged for three successive inspection periods, the component examination schedule may revert to the original schedule of successive inspections.</td>
<td></td>
</tr>
<tr>
<td>(d) For steam generator tubing, the successive examinations shall be governed by the plant Technical Specification.</td>
<td></td>
</tr>
<tr>
<td>(e) If welded attachments are examined as a result of identified component support deformation, and the results of these examinations exceed the acceptance standards of Table IWB-3410-1, successive examinations shall be performed, if determined necessary, based on an evaluation by the Owner.</td>
<td></td>
</tr>
<tr>
<td><strong>IWB-2430 ADDITIONAL EXAMINATIONS</strong></td>
<td></td>
</tr>
<tr>
<td>(a) Examinations performed in accordance with Table IWB-2500-1, except for Examination Category B-P, that reveal flaws or relevant conditions exceeding the acceptance standards of Table IWB-3410-1 shall be extended to include additional examinations during the current outage. The additional examinations shall include an additional number of welds, areas, or parts included in the inspection item equal to the number of welds, areas, or parts included in the inspection item that were scheduled to be performed during the present inspection period. The additional examinations shall be selected from welds, areas, or parts of similar material and service. This additional selection may require inclusion of piping systems other than the one containing the flaws or relevant conditions.</td>
<td></td>
</tr>
<tr>
<td>(b) If the additional examinations required by</td>
<td></td>
</tr>
</tbody>
</table>
PROPOSED CODE CHANGE

Current Code 2007 Edition

IWB-2430(a) reveal flaws or relevant conditions exceeding the acceptance standards of Table IWB-3410-1, the examinations shall be further extended to include additional examinations during the current outage. These additional examinations shall include the remaining number of welds, areas, or parts of similar material and service subject to the same type of flaws or relevant conditions.

(c) For the inspection period following the period in which the examinations of IWB-2430(a) or (b) were completed, the examinations shall be performed as originally scheduled in accordance with IWB-2400.

(d) For steam generator tubing, additional examinations shall be governed by plant Technical Specifications.

(e) If welded attachments are examined as a result of identified component support deformation, and the results of these examinations exceed the acceptance standards of Table IWB-3410-1, additional examinations shall be performed, if determined necessary, based on an evaluation by the Owner.

IWC-2420 SUCCESSIVE INSPECTIONS

(a) The sequence of component examinations which was established during the first inspection interval shall be repeated during each successive inspection interval, to the extent practical.

(b) If a component is accepted for continued service in accordance with IWC-3122.3 or IWC-3132.3, the areas containing flaws or relevant conditions shall be reexamined during the next inspection period listed in the schedule of the inspection programs of IWC-2400. Alternatively, acoustic emission may be used to monitor growth of existing flaws in accordance with IWA-2234.

(c) If the reexaminations required by IWC-2420(b) reveal that the flaws or relevant conditions remain essentially unchanged for the next inspection period, the component examination schedule may revert to the original schedule of successive inspections.

Proposed Changes

The evaluation shall be documented and shall include the cause of the welded attachment damage if known. If the cause of the welded attachment damage could recur or is unknown, additional examinations shall be performed in accordance with the requirements of IWB-2430(a). No additional examinations are required if either of the following applies.

(1) There are no other welded attachments subject to the same apparent or root cause conditions.

(2) The degradation mechanism no longer exists.

1 Welds, areas, or parts are those described or intended in a particular inspection item of Table IWB-2500-1.
2 An inspection item, as listed in Table IWB-2500-1, may comprise a number of welds, areas, or parts of a component required to be examined in accordance with the inspection plan and schedule (IW.4-2420).

INSERT NEW WORDS
<table>
<thead>
<tr>
<th></th>
<th></th>
</tr>
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<tbody>
<tr>
<td>(d) If welded attachments are examined as a result of identified component support deformation and the results of these examinations exceed the acceptance standards of Table IWC-3410-1 successive examinations shall be performed, if determined necessary, based on an evaluation by the Owner.</td>
<td>INSERT NEW WORDS The evaluation shall be documented and shall include the cause of the welded attachment damage if known. If the cause of the welded attachment damage could recur or is unknown, successive examinations shall be performed in accordance with the requirements of IWC-2420(b). No successive examinations are required if either of the following applies. (1) There are no other welded attachments subject to the same apparent or root cause conditions. (2) The degradation mechanism no longer exists.</td>
</tr>
</tbody>
</table>

**IWC-2430 ADDITIONAL EXAMINATIONS**

(a) Examinations performed in accordance with Table IWC-2500-1, except for Examination Category C-H, that reveal flaws or relevant conditions exceeding the acceptance standards of Table IWC-3410-1 shall be extended to include additional examinations during the current outage. The additional examinations shall include an additional number of welds, areas, or parts¹ included in the inspection item² equal to 20% of the number of welds, areas, & parts included in the inspection item that are scheduled to be performed during the interval. The additional examinations shall be selected from welds, areas, or parts of similar material and service. This additional selection may require inclusion of piping systems other than the one containing the flaws or relevant conditions.

¹ Welds, areas, or parts are those described or intended in a particular inspection item of Table IWC-2500-1.
² An inspection item, as listed in Table IWC-2500-1, may comprise a number of welds, areas, or parts of a component required to be examined in accordance with the inspection plan and schedule (IW.4-2420).

(b) If the additional examinations required by IWC~2430(a) reveal flaws or relevant conditions exceeding the acceptance standards of Table IWC-3410-1, the examinations shall be further extended to include additional examinations during the current outage. These additional examinations shall include the remaining number of welds, areas, or parts of similar material and service subject to the same type of flaws or relevant conditions.

(c) For the inspection period following the period in which the examinations of IWC-2430(a) or (b) were completed, the examinations shall be performed as originally scheduled in accordance with IWC-2400.
|--------------------------|------------------|
| *(d)* If welded attachments are examined as a result of identified component support deformation and the results of these examinations exceed the acceptance standards of Table IWC-3410-1, additional examinations shall be performed, if determined necessary, based on an evaluation by the Owner. | INSERT NEW WORDS  
The evaluation shall be documented and shall include the cause of the welded attachment damage if known. If the cause of the welded attachment damage could recur or is unknown, additional examinations shall be performed in accordance with the requirements of IWC-2430(a). No additional examinations are required if either of the following applies.  
*(1)* There are no other welded attachments subject to the same apparent or root cause conditions.  
*(2)* The degradation mechanism no longer exists. |

**IWD-2420 SUCCESSIVE INSPECTIONS**  
*(a)* The sequence of component examinations which was established during the first inspection interval shall be repeated during each successive inspection interval, to the extent practical.  
*(b)* If components are accepted for continued service may require inclusion of piping systems other than the by evaluation in with IWD-3000, the areas containing the flaws or relevant conditions shall be reexamined during the next inspection period listed in the schedule of the Inspection Program of IWD-2400.  
*(c)* If the reexaminations required by IWD-2420(b) reveal that the flaws or relevant conditions remain essentially unchanged for the next inspection period, the component examination schedule may revert to the original schedule of successive inspections.  
*(d)* If welded attachments are examined as a result of identified component support deformation, and the results of these examinations exceed the acceptance standards of IWD-3000, successive examinations shall be performed, if determined necessary based on an evaluation by the Owner.  

**IWD-2430 ADDITIONAL EXAMINATIONS**  
*(a)* Examinations performed in accordance with Table IWD-2500-1, except for Examination Category D-B, that reveal flaws or relevant conditions exceeding the acceptance standards of IWD-3000 shall be extended to include additional examinations during the current outage. The additional examinations shall include an additional number of welds, areas, or parts \(^1\) included in the inspection item \(^2\) equal to 20% of the number of welds, areas, or parts included in the inspection item that are scheduled to be performed during the interval. The additional examinations shall be selected from welds, areas, or parts of similar material and service. This additional selection may  

**INSERT NEW WORDS**  
The evaluation shall be documented and shall include the cause of the welded attachment damage if known. If the cause of the welded attachment damage could recur or is unknown, additional examinations shall be performed in accordance with the requirements of IWC-2430(a). No additional examinations are required if either of the following applies.  
*(1)* There are no other welded attachments subject to the same apparent or root cause conditions.  
*(2)* The degradation mechanism no longer exists.

require inclusion of piping systems other than the one containing the flaws or relevant conditions.  
(b) If the additional examinations required by IWD-2430(a) reveal flaws or relevant conditions exceeding the acceptance standards of IWD-3000 the examinations shall be further extended to include additional examinations during the current outage. The extent of the additional examinations shall be determined by the Owner based upon an engineering evaluation of the root cause of the flaws or relevant conditions. The Owner’s corrective actions shall be documented in accordance with IWA-6000.

1 Welds, areas, or parts are those described or intended in a particular inspection item of Table IWD-2500-1.  
2 An inspection item, as listed in Table IWD-2500-1, may comprise a number of welds, areas, or parts of a component required to be examined in accordance with the inspection plan and schedule (IWA-2420).

(c) For the inspection period following the period in which the examinations of IWD-2430(a) or (b) were completed, the examinations shall be performed as originally scheduled in accordance with IWD-2400.  
(d) If welded attachments are examined as a result of identified component support deformation and the results of these examinations exceed the acceptance standards of IWD-3000, additional examinations shall be performed, if determined necessary, based on an evaluation by the Owner.

The evaluation shall be documented and shall include the cause of the welded attachment damage if known. If the cause of the welded attachment damage could recur or is unknown, additional examinations shall be performed in accordance with the requirements of IWD-2430(a). No additional examinations are required if either of the following applies.  
(1) There are no other welded attachments subject to the same apparent or root cause conditions.  
(2) The degradation mechanism no longer exists.