PG-107.2 Jointly by the boiler Manufacturer and the assembler responsible for performing the hydrostatic test of the completed boiler, signing of the Certificate of Field Assembly Compliance on the Master Data Report, and for providing the supplemental stamping in accordance with PG-108.2, provided

PG-107.2.1 Assembly work is performed by workmen employed by the assembler.

PG-107.2.2 The assembler uses his own properly qualified welding procedures, welders and/or welding operators.

PG-107.2.3 Any work performed in the field by others, such as erection of boiler external piping or partial assembly of the boiler proper, that falls within the scope of the Code, is handled by proper Code certification.

(a) Code certification of boiler external piping installed by an organization other than the boiler Manufacturer or assembler shall be provided in accordance with PG-109.

(b) Code certification of work performed by an organization responsible for partial field assembly of a boiler shall be provided as follows:

(1) The work performed shall be described on a Form P-3. The form shall be marked as not being the Master Data Report. Lines 1 through 5 of the form shall be completed by the assembler responsible for partial field assembly of the boiler, except that the words “partial field assembly” are to be inserted on Line 4 instead of the unit identification and ID numbers. The portion of partial field assembly completed by the assembler and the location of the stamping required by (3) shall be described on Line 15, Remarks.

(2) The Certificate of Field Assembly Compliance on the form shall be completed and signed by the assembler. The Certificate of Field Assembly Inspection on the form shall be completed and signed by the assembler’s Authorized Inspector.

(3) When authorized by the Authorized Inspector, the assembler’s Certification Mark with “S” or “PP” Designator, the assembler’s name and serial number, or an acceptable abbreviation shall be stamped on the boiler or by the manufacturer’s stamping required by PG-106.

PG-107.2.4 The completed boiler unit is properly stamped with the Manufacturer’s Certification Mark with the “S” Designator and the assembler’s Certification Mark in accordance with PG-108.2.

PG-107.2.5 Data Reports are prepared in accordance with PG-113.2 and such Data Reports clearly define the work completed by the Manufacturer and the assembler.

PG-108 STAMPING FOR FIELD-ASSEMBLED BOILERS

Field assembly of a completed boiler unit may be made by anyone possessing a valid Certificate of Authorization for a power boiler stamp or an assembly stamp provided responsibility is assumed in accordance with the requirements of PG-107. Stamping for field assembled boiler units shall be completed as specified in PG-108.1 and PG-108.2.

PG-108.1 When responsibility for the completed boiler unit is assumed under PG-107.1, no additional stamping beyond that required by PG-106 is necessary.

PG-108.2 When responsibility for the completed boiler unit is assumed under PG-107.2, the Manufacturer’s [see PG-104.1, Note (1)] stamping shall be supplemented with the assembler’s stamp, together with the name of the assembler or an acceptable abbreviation. This supplementary stamping shall be applied in the field on the boiler near the stamping called for by PG-106 when authorized by the field Inspector after the required inspections and the hydrostatic test of the completed boiler unit. This supplementary stamping shall also be reproduced on a nameplate as required by PG-106.6 or PG-106.7 and attached in a location immediately adjacent to the master stamping plate, as required in PG-111.13.

PG-109 STAMPING OF PRESSURE PIPING

PG-109.1 Boiler external piping, as defined in the Preamble, may be fabricated by a manufacturer other than the Manufacturer of the boiler, provided that the manufacturer has been issued a Certificate of Authorization to use the Certification Mark with the “S” or “PP” Designator. Boiler external piping may be installed by welding by a manufacturer or contractor other than the Manufacturer of the boiler, provided such an organization has been issued a Certificate of Authorization to use the Certification Mark with the “S,” “PP,” or “A” Designator. When boiler external piping is installed by welding, the welding, including the qualification of welding procedures, welders, and welding operators, shall be done in accordance with the applicable rules of ASME B31.1. The welding shall be inspected by an Authorized Inspector at such stages of the work as he may elect. The organizations which fabricate or install such piping shall furnish proper code certification (PG-104.2) for it including a Manufacturer’s Data Report Form P-4A as required by PG-112.2.5 and PG-112.3.

PG-109.2 Welded boiler external piping included within the scope of the Code, over NPS 2 (DN 50), shall be stamped with a Certification Mark, together with the manufacturer’s or contractor’s name and serial number. Such stamping shall be on the pipe, valve, or fitting adjacent to the welded joint farthest from the boiler. For piping operating at temperatures above 800°F (425°C) the Certification Mark may be stamped on a nameplate that
is irremovably attached by welding, provided such welding is postweld heat treated, or on a circular metal band at least $\frac{1}{4}$ in. (6 mm) thick. This band around the pipe shall be secured in such a manner as to prevent it from slipping off during handling and installation.

Welded piping NPS 2 (DN 50) or less included within the scope of this Code shall be marked with an identification acceptable to the Inspector and traceable to the required Data Report. Such marking shall be of a type that will remain visible until the piping has been installed.

### PG-109.3 A manufacturer in possession of the pressure piping Certification Mark may

(a) design and fabricate welded piping. Such fabrications shall be stamped and reported on a Form P-4A, Manufacturer’s Data Report for Fabricated Piping, as called for in PG-112.2.5.

(b) fabricate other parts of boilers, such as superheater, waterwall, or economizer headers, where complete design requirements are provided by others. Such parts shall be stamped or marked as required by PG-106.8 and reported on a Form P-4, Manufacturer’s Partial Data Report, as called for in PG-112.2.4.

### PG-109.4 Mechanically assembled boiler external piping which contains no pressure boundary welds does not require stamping, and as such may be assembled by a nonstamp holder. Note that the responsibility for documentation and hydrostatic testing of a mechanically assembled boiler external piping must be assumed by a holder of a valid Certification Mark with the “S,” “A,” or “PP” Designator (see PG-112.2.5).

### PG-110 STAMPING OF BOILER PRESSURE RELIEF VALVES

Each pressure relief valve shall be plainly marked with the required data by the Manufacturer or Assembler (see PG-73.4.4) in such a way that the marking will not be obliterated in service. The marking shall be placed on the valve or on a metal nameplate securely fastened to the valve. The other required data may be stamped, etched, impressed, cast, or applied by other means acceptable to the ASME Designated Organization on the valve or nameplate. For units other than those included below, see PG-4. The marking shall include the following:

(a) the name (or an acceptable abbreviation) of the Manufacturer and Assembler, as applicable

(b) Manufacturer’s design or type number

(c) NPS (DN) (the nominal pipe size of the valve inlet)

(d) set pressure _____ psi (MPa), and if applicable per PG-73.5.2, cold differential test pressure _____ psi (MPa)

(e) Capacity

(1) capacity _____ lb/hr (kg/h) (for saturated steam service in accordance with PG-69.2) or

(2) capacity _____ lb/hr (kg/h) at _____ °F (°C) (for power-actuated pressure-relieving valves in accordance with PG-69.4, or for pressure relief valves for superheated steam service in accordance with PG-68.7 or supercritical steam service in accordance with PG-67.5)

(3) capacity at an overpressure of _____ psi (MPa) is greater, for valves of

(4) capacity (°C) (fluid identification) (for organic fluid vaporizers in accordance with PVG-12.4)

(f) year built, or alternatively, a coding may be marked on the valve such that the valve Manufacturer or Assembler can identify the year the valve was assembled and tested

(g) Certification Mark as shown in Figure PG-105.1 with a “V” Designator placed under the Certification Mark. A marking method other than the stamp issued by the Society may be used, provided that it is acceptable to the ASME Designated Organization.

(h) The pilot of a pilot-operated pressure relief valve shall be plainly marked by the Manufacturer or Assembler showing the name of the Manufacturer, the Manufacturer’s design or type number, the set pressure psi (MPa), and the year built, or alternatively, a coding may be marked with a coding that the Manufacturer can use to identify the year the valve was assembled and tested.

### Note to the Editor: Insert the following after PG-112.2.5

when the organization certifying Form P-4A retains the responsibility for the Code design.

These stampings shall be left uncovered or an easily removable marked cover may be provided over the stamping when a boiler is covered with insulation, or jacketed. No piping, boiler appliance, or other obstructions shall interfere with reading of the stamping.

### PG-N11 Horizontal-return tubular boilers — on the front head above the central rows of tubes.

### PG-N12 Horizontal-flue boilers — on the front head above the flues.

### PG-N13 Traction, portable, or stationary boilers of the locomotive type or Star watertube boilers — on the furnace end above the handhole. Or on traction boilers of the locomotive type — on the left wrapper sheet forward of the driving wheel.

### PG-N14 Vertical firetube and vertical submerged tube boilers — on the shell above the firedoor and handhole opening.

### PG-N15 Watertube Boilers.

#### PG-N15.1 Drum type — on a head of the steam outlet drum near and above the manhole.

#### PG-N15.2 Forced-flow steam generator with no fixed steam and waterline — the master stamping (PG-106.3) shall be located on a major pressure part, located near the main operating floor where readily visible. The Data Report Form shall record the location of the master stamping.