Item: 22-2156

Code Case XXXX

Single side weld for fittings, nozzles, for construction water heating boiler Section IV.

Inquiry:
Is it permissible to perform fillet weld deposited from the outside only for fittings, nozzles, or equivalent bolting pads not exceeding NPS 4 (DN 100) in the construction of hot water heating boilers and hot water supply boilers.

Reply:
It is the opinion of the Committee that it is permissible to perform fillet weld deposited from the outside only for fittings, nozzles, or equivalent bolting pads not exceeding NPS 4 (DN 100) in the construction of hot water heating boilers and hot water supply boilers provided the following requirements are met:

(a) Fittings, nozzles, or equivalent bolting pads shall not exceed NPS 4 (DN 100).
(b) The fillet weld deposited from the outside, having the minimum dimensions shown in Section IV Figure HW-731, sketches (o) through (t).
(c) The boiler wall thickness shall not exceed 3/8 in. (10 mm).
(d) Design of the connection, including required opening reinforcement, shall be calculated using applicable Section IV Code formulas. In cases where design rules do not exist the proof test in accordance with HG-502.3 shall be performed.
(e) All other requirements of Section IV shall be met.
(f) This Code Case number shall be shown on Manufacturer’s Data Report.