The Repair Welding Subcommittee was called to order at 1:30 PM on January 22, 2014 and adjourned at 3:30 PM. Approximately 20 participants (members and non-members) attended the meeting. This was the initial meeting for the Repair Welding Subcommittee since its formation after completion of Section 10.0 revisions by the disbanded Repair Welding Task Group.

The following is a description of the significant items that were discussed:

Interpretation Requests – No formal requests for interpretation had been received, but there was considerable discussion on proposed errata comments to the initial publication of the 21st Edition.

Errata Discussions – The following comments to Section 10.0 were reviewed for errata to the 21st Edition. The final approved disposition is shown in brackets.

10.2 – It seems the numbering system is incorrect for items under the 10.2.X.X designation. Did we really intend for section like repair area length and minimum deposited repair weld length to fall under company authorization? Should crack repairs actually be section 10.3? [No change required.]

10.2.2 – Remove the word “when the” in the sentence, “Cracked welds shall be cut out unless permitted by 9.3.10 or when the repair is authorized by the company.” To read, “Cracked welds shall be cut out unless permitted by 9.3.10 or repair is authorized by the company.” [Editorial change per errata.]

10.2.6 – The note in this section repeats two words “by the”. [Delete duplicate words “by the” by errata.]

10.3.3 and 10.4.2 – Within the paragraphs this sentence, “As noted in Table 5, when wall thickness is over 0.500 in. (12.7 mm), the side bend tests shall be substituted for face bend or root bend tests” is redundant with the notes in Tables 5 and 7. [Delete redundant sentences in 10.3.3 and 10.4.2 by errata.]
10.3.4 a) – Should this section more closely match what is currently stated in 5.3.2.13? [No Action.]

10.3.4 h) – Remove 2nd sentence, “The time delay specified in 10.3.3 is not required for repair welding.” [Delete erroneous sentence by errata.]

10.3.4 h) – Consider rewording the sentence, “Time delay, if any, before final inspection” to read, “Time delay before final inspection, when required.” [Change wording for clarification per errata.]

10.3.6 – Does not address the welding of a fillet weld test joint, only references a full circumference weld. [Agree; propose change for next addenda/revision.]

10.3.7.2.1 – The word macrosections should be macrosection in, “The transverse macrosections test specimens for hardness tests should be at least 1/2 in.” [Editorial change per errata.]

10.3.7.2.2 – Macrosection is referred to as macrospecimen only in this paragraph. The term macrosection is used everywhere else. [Change macrospecimen to macrosection per errata.]

10.3.7.3 – The note in this section requires chemical analysis. [Editorial committee changed the original note wording to an imperative statement and the words test materials to base materials. It is not intended to require mandatory chemical analysis of base materials for hardness testing. Propose this section be revised for next addenda/revision.]

10.3.7.3 – Figure 21, 22, 23, 24, 25, and 26 add US units to drawings. [Add additional units per errata.]

10.3.7.4.2 – Change wording in sentence, “Each test (of weld metal or HAZ) shall consist of at least three valid specimen tests performed at or below the minimum design temperature.” to read, “Each test (of weld metal or HAZ) shall consist of at least three valid test specimens performed at or below the minimum design temperature.” [Change wording per errata.]

Table 6 – In Note remove space in the word “the.” [Editorial change per errata.]

Figure 25 – Figure 25 is erroneous as a duplicate to Figure 24. It needs to be replaced with original figure shown below per the description. [Editorial correction to replace erroneous figure per errata.]
10.4.2 – Delete erroneous reference “and 10.3.7.2” from, “For a repair welder qualification test weld, the repair weld shall meet the visual examination requirements of 6.4 and 10.3.7.2.” [Editorial correction per errata.]

10.6 – Change sentence, “Repair areas shall be inspected and evaluated by the same NDT methods previously used to determine a defect.” to read, “Repaired areas shall be inspected and evaluated by the same NDT methods previously used to discover the original defect.” [Change wording to clarify intent per errata.]

Other Discussion Items – No action was taken to review proposed changes or disposition comment resolutions to Section 10 from the 21st Edition rebaloting comment resolution matrix dated 4/18/2013. This review will be addressed as a work topic for 2015 subcommittee business.

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Alan S. Beckett
Chairman
Repair Welding Subcommittee