

## Agenda Item: 620-2065

**Title:** Q.5.10 Repairs to Welded Joints

**Date:** 29 September 2023

**Contact:** Name : Chuck Kolb  
Company : Matrix Project Services Quality, A Matrix Service Company  
Phone : (918) 624-6266  
E-mail : [ckolb@matrixpdm.com](mailto:ckolb@matrixpdm.com)

**Purpose:** Clarify the intent of API 620, Q.5.10, and move the requirement for weld repair to Q.4 Welding Procedures

**Source:** "SUGGESTION FOR CHANGE"

**Revision:** 0

**Impact:** The business impact of this item is neutral.

**Rationale:** Q.5.10 states that repairs shall be carried out in accordance with a qualified welding procedure. The original wording can be misinterpreted to suggest that a procedure in addition to the original WPS is required for making weld repairs. There is nothing achieved technically for a new WPS/PQR to repair welds, due to the fact that the same requirements applicable to the original WPS/PQR used to weld the joint would apply. The mechanical tests with the same essential and supplementary essential variables are required. This requirement should be moved to "Q.4 Welding Procedures", as it applies to all welding repairs in Q.

**Proposal:**

**Original:**

**Q.5.10 Repairs to Welded Joints**

When repairs are made to welded joints, including the welds in Q.5.9, the repair procedure shall be in accordance with a qualified welding procedure.

**Proposed Change:**

*Delete –*

~~**Q.5.10 Repairs to Welded Joints**~~

*Add –*

**Q.4.8 Repairs to Welded Joints**

When repairs are made to welded joints, the welding procedure specification used for repairs shall meet the applicable requirements of Q.4.

**NOTES:**