

Agenda Item: 620-2070

Title: Production Welding Procedures API 620 R 4.3 c)
Date: 6 January 2026
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Purpose: Clarify API 620 R 4.3 c)
Source: Agenda Item is based on previous agenda item 620-2053 an identical requirement in Annex Q 4.6 c.
Revision: 0
Impact: The business impact of this item is neutral.
Rationale: R 4.3 c) currently states that the nominal preheat and interpass temperature shall be the same as the preheat and interpass temperature on the PQR. These variables should be minimum and maximum variables, respectively, in accordance with Section IX of the ASME Code.

Proposal:

R.4.3 Original Wording

R.4.3 Production Welding Procedures

The production welding procedures and the production welding shall conform to the requirements of the procedure qualification tests within the following limitations.

- a) Individual weld layer thickness shall not be substantially greater than that used in the procedure qualification test.
- b) Electrodes shall be of the same AWS classification and shall be of the same nominal size or smaller.
- c) The nominal preheat and interpass temperatures shall be the same.

R.4.3 Proposal

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- a) Individual weld layer thickness shall not be substantially greater than that used in the procedure qualification test.
- b) Electrodes shall be of the same AWS classification and shall be of the same nominal size or smaller.
- c) The ~~nominal~~ preheat and interpass temperatures shall be ~~the same~~. in accordance with the required essential, and when required, supplementary essential variables of Section IX of the ASME Code.

NOTES: