

## 650-2059

### Title: Clarify Requirements for Welding over Protective Coatings in Section 9.2.1.6

Date: March 31, 2021

Revision: 0

Handled By: Steve Scheffler  
CBI Services, LLC  
5500 South 1<sup>st</sup> Ave.  
Everett, WA 98203  
832-326-4660 (mobile)  
[Steve.Scheffler@mcdermott.com](mailto:Steve.Scheffler@mcdermott.com)

Doug Miller  
CB&I Storage Solutions  
14105 S. Route 59  
Plainfield, IL 60544-8984  
630-809-9801  
[Doug.Miller@mcdermott.com](mailto:Doug.Miller@mcdermott.com)

---

**Purpose:** Add wording in section 9.2.1.6 to clarify that when a procedure qualification record (PQR) is qualified for welding material with a protective coating applied, it is also qualified for welding when there is no coating applied.

**Source:** D Miller email to S Scheffler dated March 29, 2021

**Impact:** Eliminate misinterpretation of this section and the potential for generating unnecessary PQRs

**Discussion:**

It is understood that the intent of this section is not to prohibit a PQR qualified with a coating from being used on material without any coating (bare metal).

The current wording in Section 9.2.1.6 can be interpreted as a PQR that is qualified to weld over a specific coating is qualified only with that coating applied, since the coating is deemed an essential variable. See below:

**9.2.1.6** If a protective coating has been applied to surfaces to be welded, the coating shall be included as an essential variable of the welding procedure specification. Procedure qualification tests shall be required for each coating brand formulation and for the maximum thickness of coating to be applied.

**Proposal:**

Add the verbiage below to the end of Section **9.2.1.6**:

A procedure qualification record (PQR) qualified with a specific coating is also qualified for materials without any coating applied.