

650-2059

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

Date: November 03, 2021

Revision: 1

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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:

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~~ **in the qualification of each welding procedure specification (WPS) to be used on the coated materials**. Procedure qualification tests shall be required for each coating brand formulation and for the maximum thickness of coating to be applied. **Any WPS qualified with a specific coating is also qualified to weld materials without any coating applied.**