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Addendum/Errata :	Addendum 2 (May 2020)
Number:	653-2021-F2
Section Referenced:	12.2.1.6
Subject:	RT Tracer requirement for door sheet Extent of radiography at weld repairs in door sheet reinstallation
Background:	We have an existing API 650 Tank, for which door sheet will be removed and re-installed to perform repairs inside the tank.
Question:	Based on para 12.2.1.6 from API 653 any time we have a repair(defect identified by RT) in a door sheet intersection with an existing tank shell butt weld, the penalty is; a) 100 % radiography of the entire door sheet weld. (Horizontal or vertical joint as applicable) Or b) Tracer shots in accordance with API 650 section 8.1.2. And 100% RT only refers to the defective area. This is supported by 12.1.3.2 too. If (a) is indeed right – one wonders why door sheet would be treated so differently then the rest of the shell butt welds as addressed in 12.2.1.1, 12.2.1.2 & 12.2.1.3.
DGM question restatement	<ol style="list-style-type: none"> 1. When a rejectable defect is found in the weld used to reinstall a door sheet and a repair weld is made at that defect, then does section 12.2.1.6 require 100% radiography of all the welds used to reinstall the doorsheet? 2. For the situation just described, does section 12.2.1.6 require only the repaired weld in the defective area to be radiographed?
Draft reply	<ol style="list-style-type: none"> 1. <i>No. The “repaired weld” named in 12.2.1.6 refers just to replacement of defective welds. It is not a reference to all welds required to reinstall the door sheet.</i> 2. <i>Yes</i>
Need agenda item?	Yes, 653-2053 established to consider ways to improve clarity.

SGF Chair Note: The question as-presented also gets into “tracers” (i.e. radiographs used to explore the limits of a defective area). I left out that topic since tracer radiographs are not actually addressed in section 12.2.1.6. The subject section assumes that you already know the local extent of the required repair. I also changed the subject line that I propose we publish to get rid of the inaccurate “tracer” term.