

SECTION IX

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Interpretation: IX-10-21

Subject: QW-402 and QW-404 Through QW-410

Date Issued: March 11, 2011

File No.: 10-496

Question: When impacts are waived by a book section for the base metal (HAZ notch toughness is not required), but are required for the weld metal, do the supplementary essential variables of QW-402 and QW-404 through QW-410 apply per the applicable tables QW-252 through QW-265?

Reply: Yes.

Interpretation: IX-10-22

Subject: QW-200.2, Use of Preliminary WPS

Date Issued: March 14, 2011

File No.: 10-1158

Question: Does ASME Section IX require a preliminary WPS be used during procedure qualification testing, or that a WPS number be recorded on the PQR?

Reply: No.

Interpretation: IX-10-23

Subject: QW-433 and QW-452.1(b)

Date Issued: March 14, 2011

File No.: 10-1918

Background: A welder tests on an NPS 6 Sch. 80 (0.432 in. wall) coupon, depositing 0.100 in. of E6010 and the balance of 0.332 in. using E7018.

Question (1): Using E6010, is the welder qualified to deposit 0.864 in. maximum of weld metal?

Reply (1): Yes.

Question (2): Using E7018, is the welder qualified to deposit 0.664 in. maximum of weld metal?

Reply (2): Yes.

Question (3): Is the welder qualified to deposit 0.864 in. of weld metal using E6010 plus 0.664 in. of E7018 weld metal deposit thickness for a total of 1.528 in. in the same groove?

Reply (3): No. See QW-452.1(b).

Interpretation: IX-10-24

Subject: QW-409.2, Combination of Processes

Date Issued: March 14, 2011

File No.: 11-216

Background: A welder was tested on an SA-516 Gr. 70 plate, using the GMAW process. Short arc mode was used for depositing the root, and spray arc mode was used for depositing the balance of the weld in a single coupon.

Question: Is it permissible, according to ASME Section IX, QW-409.2, to use two modes of metal transfer in a single test coupon?

Reply: Yes; the deposit thickness for each transfer mode shall be recorded as required by QW-306.

Interpretation: IX-10-25

Subject: QW-201, Manufacturer's or Contractor's Responsibility

Date Issued: May 23, 2011

File No.: 11-44

Question: May an organization with more than one ASME Certificate of Authorization, under different names and in different locations, describe in its quality assurance programs the operational control of procedure qualifications and the use of welding procedures properly qualified under one certificate holder, under another certificate holder within the organization, but without separate qualification, as permitted by Section IX, QW-201?

Reply: Yes.

Interpretation: IX-10-26

Subject: QW-304, Volumetric Examination

Date Issued: June 13, 2011

File No.: 09-744

Question: Does Section IX require a welder to qualify for small diameter butt welds by preparing more than one small diameter pipe coupon to provide a minimum circumferential weld length when qualified by volumetric examination under the provisions of QW-304?

Reply: Yes.