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OPERATING PROCEDURES

VISUAL INSPECTION OF WELDS

04/25/11

HIS SECTION PROVIDES STANDARD PROCEDURES for visual inspection of steel welds.

GENERAL

Although ASME B31.3 refers to inspection as verification that all required examinations and testing have been completed; henceforth, this manual refers to visual inspection of welds as the visual examination of welds defined by ASME 31.3. Both ASME 31.3 Paragraph 343 and 344 and ASME BPV Section V Article 9 are used as the basis for this procedure.

Visual inspection of welds will be performed by individual(s) qualified by training and experience commensurate with the needs of the specified examinations. The welding inspector (inspector) must:

- Be able to verify that welding is being performed in accordance with the construction specifications and the welding procedures (see <u>Section 2.20: "Qualified Welding</u> <u>Procedure Specifications (QWPS)"</u>)
- Understand the specifications before arriving on the job site in order to be able to respond quickly and appropriately if the work or procedures are not being followed
- Be equipped with the proper inspection equipment to check and monitor the welding parameters listed in the welding procedure

All field welds are subject to visual inspection and/or non-destructive testing to:

- Verify weld integrity
- Provide for the correction of improper welding techniques when indicated by recurring defects
- Verify welder qualification in the production weld process

Records of individual visual inspections are not required; except for those of in-process examinations described in <u>Section 3.02 "Non-Destructive Testing Requirements"</u>. The visual inspection report at the end of this procedure will be utilized for in-process welding inspection.

Qualified welders are responsible for the quality of their work. The Company will assign inspection personnel as necessary to verify contractor and Company weld quality and conformance to applicable procedures.

If upon visual inspection it is determined the weld may be defective, it must be repaired or removed from the piping system and re-examined by the same methods, to the same extent and by the same acceptance criteria as necessary to meet the requirements of the code. The inspection may be made before, during, or after the weld has been completed. The Company has the right to accept or reject any weld for any reason.

Visual Inspection Of Welds Manual

Michael Rajnik

Visual Inspection Of Welds Manual:

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