

Table 1—Applicable P-numbers (Continued)

| P-num. | Base Metal Description (Strength and Chemistry) |
|--------|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| 41 | 50 ksi (345 MPa) ± 70 ksi (483 MPa) TS carbon—unalloyed |
| 42 | 70 ksi (483 MPa) TS carbon—0.07 % Cu, 30 % Ni |
| 43 | 110 ksi (758 MPa) ± 120 ksi (828 MPa) TS NiCrFe alloys (47 % Ni to 72 % Ni, 10 % Cr to 20 % Cr, 0 % Mn to 16 % Mn, 0 % Pb to 10 % Pb, 0 % Ti, 0 % Cu, 0.0 % Zn, Al, Fe) |
| 44 | 45 ksi (310 MPa) ± 110 ksi (758 MPa) TS NiMo, NiMoCr alloys (50 % Ni to 70 % Ni, 10 % Mo to 20.0 % Mo, 1.0 % Cr to 3.7 % Cr, 0 % Ti, 0.0 % Pb, 0.0 % Cu, 0.0 % Zn, Al, Fe) |
| 45 | 60 ksi (414 MPa) ± 120 ksi (828 MPa) TS NiCuCr alloys (21 % Ni to 40 % Ni, 10 % Cr to 40 % Cr, 20 % Cu to 30 % Cu, 0.0 % Ti to 7 % Ti, 0 % Pb, 0 % Zn, 0.0 % Cu, 0.0 % Al, Fe) |
| 46 | 70 ksi (483 MPa) ± 90 ksi (620 MPa) TS NiCrFe alloys (40 % Ni to 57 % Ni, 10 % Cr to 20 % Cr, 1.00 % Mn to 2.7 % Mn, 0 % Cu) |
| 47 | untested |
| 48 | 120 ksi (828 MPa) carbon alloys (0% Cu, 20 % Cr, 0 % Ni, 0 % Mn, 0 % Pb, 0 % Ti, 0 % Zn) |
| 51 | 30 ksi (207 MPa) ± 30 ksi (207 MPa) TS titanium—unalloyed (alpha) (Ti, Fe, Pb) |
| 52 | 45 ksi (310 MPa) ± 70 ksi (483 MPa) TS titanium—unalloyed and alloyed (alpha) (Ti, 0.0 % Mn, 0.0 % Ni) |
| 53 | 50 ksi (345 MPa) TS titanium alloys (alpha-beta) (Ti, 0 % Ni, 0.0 % V) |
| 54 | 70 ksi (483 MPa) TS titanium—alloyed (alpha) (Ti, 0.0 % Mn, 0.0 % Ni) general P-52 |
| 55 | 50 ksi (345 MPa) TS zirconium—unalloyed |
| 56 | 50 ksi (345 MPa) TS zirconium—alloyed (Zr, 0.0 % Cu) |

4. General Welding Requirements

4.1 Structural (pressure boundary) welding requirements shall comply with either AWS D1.1 or AWS D1.6. When approved by the purchaser (engineer) welding procedures may be qualified per ASME BPVC Section IX.

4.2 Prequalified welding procedures per AWS D1.1 and AWS D1.6 will be accepted for structural welding.

4.3 All welding procedure specifications (WPSs) and procedure qualification records (PQRs) shall be submitted to the purchaser for review and approval prior to the start of fabrication or construction unless submitted as required by the purchaser. Weld maps, similar guides or fabrication drawings which clearly identify the application of each WPS, indicating where and how these WPSs will be used, shall be included in the submitted.

4.4 Weld maps, similar guides, drawings or other documentation shall be updated during fabrication to clearly indicate the weld(s) or welding operator(s) that made each weld. Similarly, record the location of any NDT performed and update the information during fabrication.

5. Welding Processes

5.1 Acceptable Welding Processes

Acceptable welding processes are as follows:

- shielded metal arc welding (SMAW);
- gas tungsten arc welding (GTAW) and pulsed GTAW (GTAW-P);

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JR Anderson



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