

Coded Note Number: HC018

Revision: C002

Date: July 12, 2019

Title: HC018- VALVE WELDING HEAT CONTROL

Weld in quarters using 125 F interpass temperature. Mid- position the stem / disc.  
Follow Section G (Reduced Heat Input / Cooling Methods) of W91 / 191 Appendix A or  
**W93 Appendix A, as applicable. For mechanized welding, see Appendix B.**

<b>Revision History Table</b>		
<b>Rev</b>	<b>Description</b>	<b>Revision Date</b>
C001	Original Issue	10-27-14
C002	Addition of W93 reference	07-12-19

**This revision history is provided for convenience and does not alleviate the supplier's responsibility with understanding and complying with the full coded note.**