

Coded Note Number: **HC018**

Revision: **C003**

Date: **July 16, 2019**

Title: **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.**

Revision History Table		
Rev	Description	Revision Date
C001	Original Issue	09-10-14
C002	<u>ADDED</u> : Reference to W93	07-12-19
C003	<u>REVISED</u> : Reformatted	07-16-19

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