

Coded Note Number: **HC025**

Revision: **C003**

Date: **July 18, 2019**

Title: **VALVE WELDING HEAT CONTROL**

Weld in quarters using 125 F interpass temperature. Follow the recommendations provided in Section D (**Valves That Require Disassembly Prior to Welding**) and Section G (Reduced Heat Input / Cooling Methods) of W91 / 191 Appendix A or **W93 Appendix A, as applicable, and** ensure the end piece fasteners are in the required torque range following welding. If the heat controls identified above are not followed, the valve must be disassembled prior to welding. **For mechanized welding, valve must be disassembled prior to welding.**

| <b>Revision History Table</b> |   |                      |
|-------------------------------|---|----------------------|
| <b>Rev</b>                    | <b>Description</b>  | <b>Revision Date</b> |
| C002                          | Option to disassemble or use heat control.                            | 11-23-15             |
| C003                          | <u>ADDED</u> :<br>Reference to W93 Appendix A and mechanized welding. | 07-18-19             |

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