

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.**