

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.