

Weld in quarters using 125 F interpass temperature. Follow the requirements in paragraph "Socket Welded Valve Heat Control Technique Requirements" and section "Reduced Heat Input / Cooling Methods" of W-91 Appendix A or W-93 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.