

Either disassemble prior to welding or weld in quarters using 125 F interpass temperature. If heat controls are utilized, follow the recommendations provided in Section D and Section G (Reduced Heat Input / Cooling Methods) of W91 / 191 Appendix A and ensure the end piece fasteners are in the required torque range after welding. Seawater valves, as identified by CCPP-8005, require disassembly for additional lubrication. Seawater valves may be welded assembled per W91 / 191 Appendix A, but shall still be disassembled either prior to, or subsequent to welding for lubrication. For mechanized welding, valve must be disassembled prior to welding.