

Either disassemble prior to welding or weld in quarters using 125 F interpass temperature. If heat controls are utilized, follow the requirements in paragraph "Socket Welded Valve Heat Control Technique Requirements" and section "Reduced Heat Input / Cooling Methods" of W-91 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 W-91 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.