

Coded Note Number: **HC028**

Revision: **C002**

Date: **July 18, 2019**

Title: **VALVE WELDING HEAT CONTROL**

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. This is a seawater valve that requires 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.**

Revision History Table		
Rev	Description	Revision Date
C001	Original Issue	09-10-14
C002	<u>ADDED</u> : Reference to mechanized welding.	07-18-19

This revision history is provided for convenience and does not alleviate the supplier's responsibility with understanding and complying with the full coded note.