

Ranges of Approval for Joint Types in Welding Procedure Approval

Amended Rules

Rules for the Survey and Construction of Steel Ships Part M

Reason for Amendment

With respect to the approval of welding procedures and related specifications, Chapter 4 of the Rules for the Survey and Construction of Steel Ships Part M requires that tensile tests, impact tests, etc. be satisfactorily carried out under representative conditions described in welding procedure specifications.

Under the current rules, it is specified that tests of one-side butt welded joints with backing are to be carried out. If said tests are passed, it is possible to extend the range of approval of said joints so that it also includes both side butt welded joints with gouging and both side butt welded joint without gouging.

However, in order to properly ensure the quality of both side butt welded joints without gouging, it is very important to make sure that no imperfections, especially in root pass welding, are created. For this reason, IACS proposed holding special discussions to review the appropriateness of including both side butt welded joints without gouging within the range of approval for one side butt welded joints with backing.

During this review, it was agreed that in order to further ensure the soundness of both side butt welded joints without gouging, such joints are to be removed from the range of approval of one side butt welded joints with backing. The aforementioned change was adopted by IACS as UR W28(Rev.2) in March 2012. Accordingly, relevant requirements were amended in accordance with UR W28(Rev.2).

Outline of Amendment

For the approval of welding procedures, relevant requirements were amended to exclude both side welded joints without gouging from the range of approval of one side welded joints with backing.