

Approval of Welding Procedures and Related Specifications for T-joints with Partial Penetration

Amended Rules and Guidance

Rules for the Survey and Construction of Steel Ships Part M

Guidance for the Survey and Construction of Steel Ships Part M

Reason for Amendment

Requirements related to approval tests for welding procedures and related specifications of representative welded joints such as butt welded joints, fillet welded joints and T-joints with full penetration are specified in Chapter 4, Part M of the Rules for the Survey and Construction of Steel Ships.

However, specific treatments for the approval of T-joints with partial penetration, a type of weld joint commonly used in hull construction, are not specified. Accordingly, relevant requirements were amended based upon the actual results of previously approval and ISO standards, etc., to clarify requirements related to the approval tests for the welding procedures and related specifications for T-joints with partial penetration.

In addition, relevant requirements related to the approval tests of T-joints with full penetration do not clearly specify the type of weld joint such as backing, without backing, with gouging or without gouging. However, it is believed that the range of approval for the tests of representative welding methods of such joints is to be determined by the type of weld joint as is the case for butt welded joints. Accordingly, relevant requirements were amended to clarify the ranges of approval for the type of weld joints.

Outline of Amendment

- (1) Specified requirements related to the approval tests for the welding procedures and related specifications of T-joints with partial penetration.
- (2) Clarified the ranges of approval according to type of weld joint for butt welded joints, fillet welded joints, T-joints with full penetration and T-joints with partial penetration.

Amended Requirements

Rules for the Survey and Construction of Steel Ships

Part M: 4.1.3, 4.1.4, Table M4.1, Table M4.2, 4.2.1, 4.3.1, 4.4.1, 4.5

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Part M: M4.1.4, Table M4.1.4-2