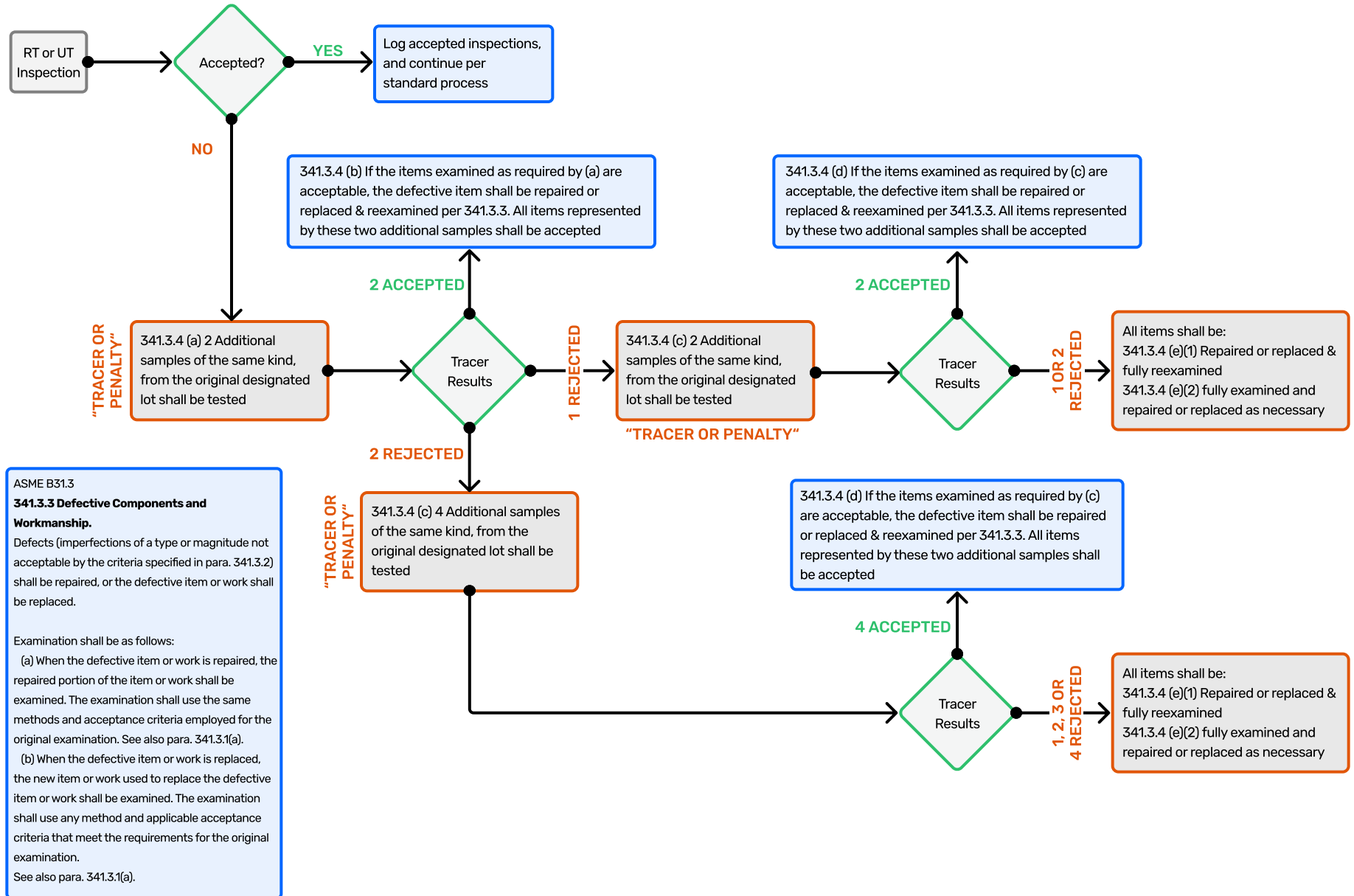


# PROGRESSIVE WELD SAMPLING

## PIPING PER ASME B31.3 PARA. 341.3

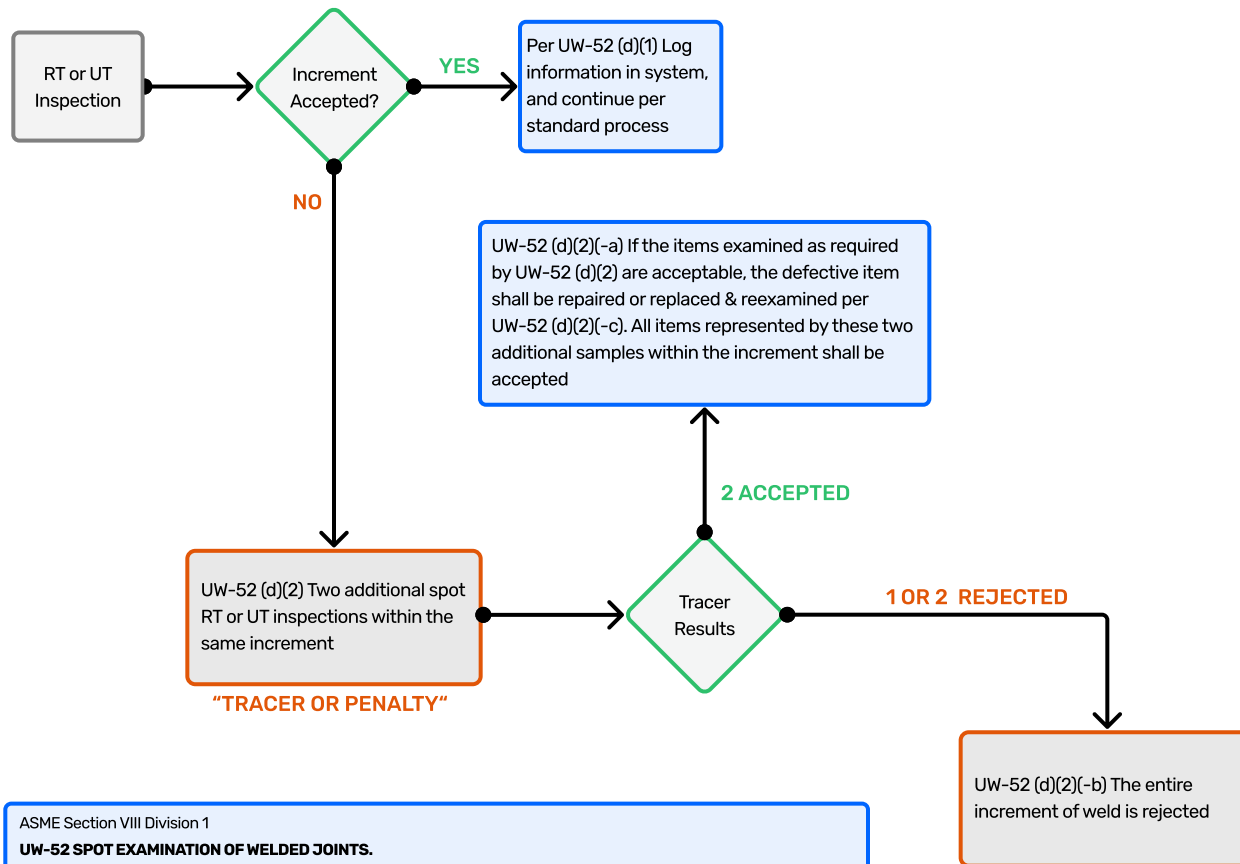


# PROGRESSIVE WELD SAMPLING

## VESSEL PER ASME SECTION VIII DIVISION 1



WELDING QA/QC & PROJECT CONTROLS SOFTWARE



ASME Section VIII Division 1

### UW-52 SPOT EXAMINATION OF WELDED JOINTS.

**NOTE:** Spot radiography of a welded joint is recognized as an effective inspection tool. The spot radiography rules are also considered to be an aid to quality control. Spot radiographs made directly after a welder or an operator has completed a unit of weld proves that the work is or is not being done in accordance with a satisfactory procedure. If the work is unsatisfactory, corrective steps can then be taken to improve the welding in the subsequent units, which unquestionably will improve the weld quality.

Spot radiography in accordance with these rules will not ensure a fabrication product of predetermined quality level throughout. It must be realized that an accepted vessel under these spot radiography rules may still contain defects which might be disclosed on further examination. If all radiographically disclosed weld defects must be eliminated from a vessel, then 100% radiography must be employed.

ASME Section VIII Division 1

### UW-52 SPOT EXAMINATION OF WELDED JOINTS.

(a) Butt welded joints which are to be spot radiographed shall be examined locally as provided herein.

(b) Minimum Extent of Spot Radiographic Examination

(1) **One spot shall be examined on each vessel for each 50 ft (15 m) increment of weld or fraction thereof** for which a joint efficiency from column (b) of Table UW-12 is selected. However, for identical vessels or parts, each with less than 50 ft (15 m) of weld for which a joint efficiency from column (b) of Table UW-12 is selected, 50 ft (15 m) increments of weld may be represented by one spot examination.

(2) For each increment of weld to be examined, **a sufficient number of spot radiographs shall be taken to examine the welding of each welder or welding operator.** Under conditions where two or more welders or welding operators make weld layers in a joint, or on the two sides of a double-welded butt joint, one spot may represent the work of all welders or welding operators.

(3) **Each spot examination shall be made as soon as practicable after completion of the increment of weld to be examined.** The location of the spot shall be chosen by the Inspector after completion of the increment of welding to be examined, except that when the Inspector has been notified in advance and cannot be present or otherwise make the selection, the Manufacturer may exercise his own judgment in selecting the spots.

(4) Radiographs required at specific locations to satisfy the rules of other paragraphs, such as UW-9(d), UW-11(a)(5)(-b), and UW-14(b), shall not be used to satisfy the requirements for spot radiography.

(c) Standards for Spot Radiographic Examination. Spot examination by radiography shall be made in accordance with the technique prescribed in UW-51(a). **The minimum length of spot radiograph shall be 6 in. (150 mm).**..... CONTINUED..... Read the remainder from the code book to know and understand all the provisions of the code and how they apply to each situation.