



SAFETY ASSESSMENT
FEDERATION

Guidance

Welding Procedure and Welder Approval Testing

BS EN ISO 15614-1: 2012,
Clause 8.3.2.2

REFERENCE: WMC 01
ISSUE: 04
DATE: 01/03/16

DOCUMENT INFORMATION:

REFERENCE:	WMC 01
ISSUE:	04
DATE:	01/03/2016
PREPARED BY:	Welding and Materials Committee
APPROVED BY:	TC 1 — Pressure Equipment and the SAFed Technical Steering Committee

DOCUMENT HISTORY RECORD:

ISSUE:	DATE:	CHANGE DETAIL:
04	01/03/2016	Document Review

© The Safety Assessment Federation Ltd

All rights reserved. Except for normal review purposes, no part of this publication may be reproduced, utilised, stored in a retrieval system or transmitted in any form by any means electronic or mechanical, including photocopying, recording or by any information, storage or retrieval system without the written permission of the publisher.

CONTENTS

SITUATION 1

GUIDANCE..... 1

SITUATION

What is the range of approval (if any) for the diameter of the main pipe/shell in a branch weld of dissimilar thickness?

GUIDANCE

The main pipe/shell or thickness is not subject to restriction in the approval of a branch weld qualification.

Referring to BS EN ISO15614-1 : 2004 + A2 : 2012: Figure 4 - Test piece for a branch connection and Table 7 - Range of qualification for pipe and branch connection diameters. Within Table 7; footnote "a" states that the applicable diameter range of approval "D" is the outside diameter of pipe or outside diameter of the branch pipe, therefore the branch pipe diameter D2 and thickness of branch pipe (t2) as shown in Figure 4 determine the approval range.