

GUIDANCE

WELDING PROCEDURE AND WELDER APPROVAL TESTING

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Reference: **BS EN ISO 15614-1: 2012, Clause 8.3.2.2**

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.