

TABLE OF CONTENTS

	Page
FOREWORD	1
Use of Language and Definitions	1
List of Abbreviations Used in the Text	1
1. SCOPE	3
2. LEGISLATION AND STANDARDS REFERENCED IN THE TEXT	5
2.1 UK Legislative Requirements	5
2.2 Codes and Standards	5
2.2.1 American Standards	5
2.2.2 British Standards	5
2.2.3 Other Codes/Standards	6
3. QUALITY ASSURANCE	7
4. DESIGN REQUIREMENTS	9
4.1 General	9
4.2 Yield Strength	9
4.3 Calculation Techniques	9
4.4 Reference Drawings	10
4.5 Validation of Design	10
4.6 Casting Geometry	10
5. MANUFACTURING PROCEDURE	11
5.1 General	11
5.2 Steelmaking	11
5.3 Casting	11
5.4 Heat Treatment	11
5.5 Welding	12
6. CHEMICAL PROPERTIES	13
6.1 Composition	13
6.2 Carbon Equivalent	13
6.3 Test Samples	13
6.4 Re-tests	13
7. MECHANICAL PROPERTIES	15
7.1 Cast Test Blocks	15
7.2 Mechanical Testing	15
7.2.1 Tensile Tests	15
7.2.2 Impact Tests	15
7.2.3 Fracture Toughness (CTOD) Tests	16
7.2.4 Metallographic Examination	16
7.2.5 Failure to Meet Acceptance Criteria	16
8. INSPECTION AND NON-DESTRUCTIVE TESTING	17
8.1 General	17
8.2 Personnel	18
8.3 Surface Preparation for Inspection and NDT	19

8.4	Visual Inspection	19
8.5	Magnetic Particle Inspection	19
8.6	Ultrasonic Testing	20
8.7	Radiographic Inspection	22
9.	RECTIFICATION AND REPAIR WELDING	25
9.1	General Requirements	25
9.2	Blending	25
9.3	Weld Repair	25
9.3.1	General	25
9.3.2	Welding Consumables	25
9.3.3	Welder Qualification	26
9.3.4	Preparation for Welding	26
9.3.5	Weld Execution	26
9.3.6	Preheating and Interpass Temperature	26
9.3.7	Weld Finish	26
9.3.8	Inspection and Non-Destructive Testing	27
APPENDIX A:	WELDABILITY OF CASTINGS	29
A1	General Requirements	29
A2	Detailed Test Requirements	29
A2.1	Heat Inputs for the Test Welds	29
A2.2	Test Assembly Geometry	29
A2.3	Heat Treatment Condition of Test Welds	29
A2.4	Non-Destructive Testing	29
A2.5	Mechanical Tests	30
A2.6	Acceptance Criteria for Weldability Tests	30
A3	Report	30
APPENDIX B:	REPAIR WELDING PROCEDURE QUALIFICATION	31
B1	Welding Procedure Qualification Requirements	31
B2	New Procedures	31
B3	Inspection and Non-Destructive Testing of the Qualification Test Assembly	31
B4	Mechanical Testing and Acceptance Criteria	31
B4.1	Transverse Tensile Tests	31
B4.2	All Weld Metal Tensile Tests	32
B4.3	Macro-Examination	32
B4.4	Hardness Survey	32
B4.5	Charpy Tests	32
B4.6	CTOD Tests	32
Fig. 1:	Location of Test Specimens for Repair Procedure Test Pieces	35
Fig. 2:	Location of Indents for Hardness Surveys	36
Fig. 3:	Location of Impact Test Specimens for Weld Repairs	37
EEMUA PUBLICATIONS—SUMMARY LIST		39