

Approval Date: October 11, 2005

The ASME Boiler and Pressure Vessel Standards Committee took action to eliminate Code Case expiration dates effective March 11, 2005. This means that all Code Cases listed in this Supplement and beyond will remain available for use until annulled by the ASME Boiler and Pressure Vessel Standards Committee.

**Case 2235-9****Use of Ultrasonic Examination in Lieu of Radiography  
Section I; Section VIII, Divisions 1 and 2; and  
Section XII**

**Inquiry:** Under what conditions and limitations may an ultrasonic examination be used in lieu of radiography, when radiography is required in accordance with Section I, para. PW-11; Section VIII, Division 1, para. UW-11(a); Section VIII, Division 2, Table AF-241.1; and Section XII, TE-230.1?

**Reply:** It is the opinion of the Committee that all welds in material  $\frac{1}{2}$  in. (13 mm) or greater in thickness in pressure vessels and power boilers may be examined using the ultrasonic (UT) method in lieu of the radiography (RT) method, provided that all of the following requirements are met:

(a) The ultrasonic examination area shall include the volume of the weld, plus 2 in. (50 mm) on each side of the weld for material thickness greater than 8 in. (200 mm). For material thickness 8 in. (200 mm) or less, the ultrasonic examination area shall include the volume of the weld, plus the lesser of 1 in. (25 mm) or  $t$  on each side of the weld. Alternatively, examination volume may be reduced to include the actual heat affected zone (HAZ) plus  $\frac{1}{4}$  in. (6 mm) of base material beyond the heat affected zone on each side of the weld, provided the following requirements are met:

(1) The extent of the weld HAZ is measured and documented during the weld qualification process.

(2) The ultrasonic (UT) transducer positioning and scanning device is controlled using a reference mark (point or low stress stamp adjacent to the weld) to ensure that the actual HAZ plus an additional  $\frac{1}{4}$  in. (6 mm) of base metal is examined.

(b) A documented examination strategy or scan plan shall be provided showing transducer placement, movement, and component coverage that provides a standardized and repeatable methodology for weld acceptance.

The scan plan shall also include ultrasonic beam angle used, beam directions with respect to weld centerline, and vessel volume examined for each weld. The documentation shall be made available to the Owner/User upon request.

(c) The ultrasonic examination shall be performed in accordance with a written procedure conforming to the requirements of Section V, Article 4.<sup>1</sup> The procedure shall have been demonstrated to perform acceptably on a qualification block(s). The qualification block(s) shall be prepared by welding or the hot isostatic process (HIP) and shall contain a minimum of three flaws, oriented to simulate flaws parallel to the production weld's fusion line as follows:

- (1) one surface flaw on the side of the block representing the vessel OD surface
- (2) one surface flaw on the side of the block representing the vessel ID surface
- (3) one subsurface flaw
- (4) If the block can be flipped during UT examination, then one flaw may represent both the ID and OD surfaces. Thus only two flaws may be required.

Flaw size shall be no larger than the flaw in Table 1, 2, or 3 for the thickness to be examined. Acceptable performance is defined as response from the maximum allowable flaw and other flaws of interest demonstrated to exceed the reference level. Alternatively, for techniques that do not use amplitude recording levels, acceptable performance is defined as demonstrating that all

<sup>1</sup> Sectorial scans (S-scans) with phased arrays may be used for the examination of welds, provided they are demonstrated satisfactorily in accordance with para. (c). S-scans provide a fan beam from a single emission point, which covers part or all of the weld, depending on transducer size, joint geometry, and section thickness. While S-scans can demonstrate good detectability from side drilled holes, because they are omnidirectional reflectors, the beams can be misoriented for planar reflectors (e.g., lack of fusion and cracks). This is particularly true for thicker sections, and it is recommended that multiple linear passes with S-scans be utilized for components greater than 1 in. (25 mm) thick. An adequate number of flaws should be used in the demonstration block to ensure detectability for the entire weld volume.

The Committee's function is to establish rules of safety, relating only to pressure integrity, governing the construction of boilers, pressure vessels, transport tanks and nuclear components, and in-service inspection for pressure integrity of nuclear components and transport tanks, and to interpret these rules when questions arise regarding their intent. This Code does not address other safety issues relating to the construction of boilers, pressure vessels, transport tanks and nuclear components, and the in-service inspection of nuclear components and transport tanks. The user of the Code should refer to other pertinent codes, standards, laws, regulations or other relevant documents.



# Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361

**ASME Boiler and Pressure Vessel  
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## **Table of Contents Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361**

1. Understanding the eBook Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
  - The Rise of Digital Reading Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
  - Advantages of eBooks Over Traditional Books
2. Identifying Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
  - User-Friendly Interface
4. Exploring eBook Recommendations from Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
  - Personalized Recommendations
  - Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361 User Reviews and Ratings
  - Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361 and Bestseller Lists
5. Accessing Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361 Free and Paid eBooks
  - Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361 Public Domain eBooks
  - Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361 eBook Subscription Services
  - Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361 Budget-Friendly Options
6. Navigating Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361 eBook Formats

- ePub, PDF, MOBI, and More
- Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361 Compatibility with Devices
- Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361 Enhanced eBook Features
- 7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
  - Highlighting and Note-Taking Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
  - Interactive Elements Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
- 8. Staying Engaged with Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
- 9. Balancing eBooks and Physical Books Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
- 10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
- 11. Cultivating a Reading Routine Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
  - Setting Reading Goals Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
  - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
  - Fact-Checking eBook Content of Case Cases Of Asme Boiler And Pressure Vessel Code 2235 9 201361
  - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
- 14. Embracing eBook Trends
  - Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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