



CCE COORDINATION BULLETIN

BULLETIN NUMBER 2007-2

Inspection of Permanently Welded Joints

The following guidance shall be used by the CCE when performing TPV evaluations. This guidance is effective immediately upon receipt and shall be used until revoked or included in an up-date of the TPV Manual.

The current Format and Style Manual, Number 00-01 states in Section E1.2.2:

“Permanent joints in sanitary tubing shall be welded in accordance with either AWS/ANSI D18.1 (Refer to B4, Reference No. 13) or EHEDG Doc. 9 (Refer to B4, Reference No. 14).”

Older standards may also reference pipelines welded in accordance with *3-A Accepted Practices for Permanently Installed Product and Solution Pipelines and Cleaning Systems, Number 605-04*.

However, currently, there are not any corresponding criteria under E1.1, Surface Texture, to allow for the pipelines and fittings welded in accordance with E1.2.2 or the 3-A Accepted Practice 605-04 to be accepted as welded, without additional grinding and polishing. There is a proposal currently out for public comment under the Format and Style Manual, Amendment 00-02, to correct this deficiency.

Until such time as the Format and Style Manual and the individual Standards are up-dated, CCE are instructed that fittings welded to pipelines and for the joints and fittings of piping that are integral to a piece of equipment, which are welded in accordance with the AWS/ANSI D18.1, EHEDG Doc. 9, or 3-A Accepted Practice 605-04, are acceptable without additional grinding or polishing.