

# **The Welding Position for Welding Procedure Qualification Tests and Welding Consumables**

## **Amended Rules and Guidance**

Rules for the Survey and Construction of Steel Ships Part M

Guidance for the Survey and Construction of Steel Ships Part M

## **Reason for Amendment**

(1) ClassNK requirements regarding welding procedures and related specifications are partially primarily based on IACS Unified Requirements W28. There are provisions of UR W28 regarding the requirements of welding positions for welding procedure qualification tests still have not been incorporated into the ClassNK Rules because of the many years required to consider relevant approval results.

In recent years, many other Classification Societies have made efforts to incorporate all of the provisions of UR W28 into their Rules. Therefore, in order to keep the ClassNK Rules in line with those of other Classification Societies, this amendment has been introduced in order to fully incorporate IACS Unified Requirements W28 in the ClassNK Rules.

(2) Although it is current practice for the Society to consider the definition of welding consumable brand to include a combination of electrode numbers, flux, fillers and backing etc., this practice is not clearly specified in the Rules. Therefore, all relevant requirements have been amended to clarify the definition of a welding consumable brand.

(3) Although it is current practice for the Society to consider backing to be part of a welding consumable brand as in (2) above, there are materials used for backings that do not need to be treated as such. Therefore, all relevant requirements have been amended to permit the use of materials used only for backings which differ from those combinations consisting of welding consumables approved by the Society.

## **Outline of Amendment**

(1) The requirements of welding positions for welding procedure qualification tests have been amended.

(2) The requirements of the notch positions for impact test specimens in cases where welding heat input is greater than  $50kJ/cm$  have been amended.

(3) The requirements specifying that “brand” refers to combinations consisting of electrode numbers, flux, filler and backing etc. have been added.

(4) The requirements specifying that it is permissible to use materials which differ from those combinations consisting of welding consumables approved by the Society for backings have been added.