

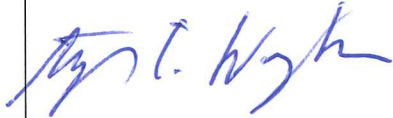






Standard Operating Procedure
Post-Weld Heat Treatment

SOP #: 5.052 Rev. 0

Page #: 1 of 3

Approval

Approving Authority	Name	Signature	Date
Quality Assurance Manager	Steve Washington		07 DEC 2018
Process Systems Manager	Michael Delgado		07 JAN 2019
V.P. Engineering	Steve Rusconi		11 DEC 2018
Operations Manager	Steve Hansen		11 DEC 2018
President	Joseph Parisi		12/11/18

Revision History

Revision #	Description of Change	Effective Date	DCR#
0	New Procedure	07 JAN 2019	14006
1			



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SOP #: 5.052 Rev. 0

Page #: 2 of 3

- 1 Purpose
 - 1.1 To establish guidelines for the preparation of Post-Weld Heat Treatment (PWHT) procedures and associated forms.
- 2 Scope
 - 2.1 Heat Treatment referred to herein is that required by the code or specification and shall be limited to Post Weld Heat Treatment (PWHT) of welds.
 - 2.2 It is not anticipated that PWHT will be a routine operation. However, if required, it shall be performed by a subcontractor in accordance with an approved procedure.
 - 2.3 To describe the procedures and documentation necessary, should heat treatment be within the scope of the Code of Fabrication.
 - 2.4 This procedure application may vary based on project and/or client requirements.
- 3 Responsibilities
 - 3.1 Department Managers: Shall be responsible for the review of customer requirements and communications with customer, sub-contractor and Quality Control Manager.
 - 3.2 Engineering: This department shall be responsible for providing technical advice for Post-Weld Heat Treatment as needed.
 - 3.3 The Quality Control Manager (QCM) shall be responsible for assigning the applicable Welding Procedure Specification (WPS) for the scope of work.
 - 3.4 The QCM shall be responsible for specifying the Post Weld Heat Treatment requirements to the sub-contractor.
- 4 Procedures
 - 4.1 The QCM shall provide the PWHT vendor with Code requirements, review and approve the vendor's procedures for compliance.
 - 4.2 Coordinate with PWHT sub-contractor to modify procedures and forms as needed to meet project specifications and codes.



Standard Operating Procedure
Post-Weld Heat Treatment

SOP #: 5.052 Rev. 0

Page #: 3 of 3

- 4.3 The QCM shall verify the calibration status of temperature recording instruments, number and placement of thermocouples and time at temperature recording.
- 5 Documentation / Records
 - 5.1 Records submitted by the PWHT vendor shall be representative of actual conditions regarding duration and time exposure relative to temperature.
 - 5.2 PWHT records shall be reviewed by the QCM and signed and dated to denote acceptance.
 - 5.3 All documentation pertaining to PWHT for ASME or National Board code work shall be presented to the Authorized Inspector before or during final review of all documentation for verification of Code compliance, including any vendor's PWHT procedures.
- 6 Receiving Inspection
 - 6.1 Items sent to a sub-contractor for heat treating shall be inspected by the Quality Control Examiner (QCE) or QCM for identification and damage when returned.
- 7 Review and Approval
 - 7.1 The QCM shall review and approve all new and revised Post-Weld Heat Treatment Procedures and Forms from sub-contractors.
 - 7.2 The QCM shall maintain the current approved PWHT SOPs and Forms from sub-contractors in secure QCM files and the corporate data network.