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Table 341.3.2

Acceptance criteria are those stated in Table 341.3.2 for radiography under Normal Fluid Service. (b) Circumferential Butt Welds and Other Welds. It is recommended that the extent of examination be not less than one shot on one in each 20 welds for each welder or welding operator. Unless otherwise specified, accept- Table 341.3.2 Acceptance Criteria for Welds and ... Table 341.3.2 Acceptance Criteria for Welds and Examination ... (1) All fabrication shall be examined. (2) All threaded, bolted, and other joints shall be examined. (3) All piping erection shall be examined to verify Table 341.3.2 Acceptance

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Criteria for Welds and ... (14) Table 341.3.2 Acceptance Criteria for Welds — Visual and Radiographic Examination (Cont'd) NOTES: (1) Criteria given are for required examination. More stringent criteria may be specified in the engineering design. ASME B31.3 - 2014 - Table 341.3.2 - Acceptance | Welding ... Table 341.3.2 Acceptance Criteria for Welds and Examination Methods for Evaluating Weld Imperfections (Cont'd) NOTES: (1) Criteria given are for required examination. More stringent criteria may be specified in the engineering design. See also paras. 341.5 and 341.5.3. (2) Longitudinal groove weld includes straight and spiral seam. Table 341.3.2 Acceptance Criteria for Welds and ... Getting the books table 341.3.2 acceptance

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para. 341.3.2 and in Table 341.3.2, for Normal Fluid Service unless otherwise specified. (a) Visual Examination. At least the following shall be examined in accordance with para. 344.2: (1) sufficient materials and components, selected at random, to satisfy the examiner that they conform to 341.3.3 Defective Components and Workmanship. 341.3.4 ... ASME B31.3-1996, Table 341.3.2, symbol K for the depth of root surface concavity (suck back), gives the acceptable value limit as total joint thickness incl. weld reinf., greater than or equal to nominal wall thickness. Lets take a NPS 2" schedule 80, 0.218 wall pipe with 1/16 external reinforcement and 1/16 internal reinforcement. ASME B31.3-1996, Table

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341.3.2 Acceptance Criteria for
Welds Described in Table 341.3.2

See page 83 of the supplement.

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13. Inspection, Examination and

Testing BECHT ENGINEERING

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Examination and Testing -27

Testing Testing is performed to

assure that ASME B31.3 Process

Piping - PSIG Ok, in Table 341.3.2

Acceptance Criteria for Welds —

Visual and Radiographic

Examination Determine services of

piping process such Normal and

Category M Fluid Service, or Severe

Cyclic Conditions, or Category D

Fluid Service. B31.3 table 341.3.2

acceptance criteria - Support

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Date 05-23-2005 09:43 Hello All: I
reading AMSE B31.3 1996, Table
341.3.2 Criterion Value Notes
Symbol "L" concerning height of
reinforcement. AMSE B31.3 Table
341.3.2 341.3.2 Typical Weld
Imperfections 80 Table 341.3.2
Acceptance Criteria for Welds and
Examination Methods for Evaluating
Weld Imperfections 77 Chapter
VII Nonmetallic Piping and Piping
Lined With Nonmetals ASME
B31.3-2002 PROCESS
PIPING Question (I): In accordance
with ASME B31.3-1993 Edition,
Table 341.3.2A and para. 341.3.4,
when the engineering design
specifies more stringent acceptance
criteria for normal fluid service, do
the requirements of para. 341.3.4,
Progressive Examination, still
apply? Reply (I): Yes. ASME B31.3

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INTERPRETATIONS NO. 16 ASME
831.3 INTERPRETATIONS

Interpretation: 22-01 Subject: ASME
B31.3-2006, Para. 323.3, Impact
Testing Methods and Acceptance
Criteria Date Issued: April 29,
2008 ASME 831.3

INTERPRETATIONS LANLEngineering
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Chapter 13, Welding & Joining
Section WFP 2-01 - Welding

Fabrication Procedure Rev. 1,
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Criteria for Welds and

Examination... [http://ndt.net/forum/f
iles/rt-asmeb31.3-withoutsecure.pdf](http://ndt.net/forum/files/rt-asmeb31.3-withoutsecure.pdf)

Asme Acceptance Criteria For
Welds The ASME B31.3 Code

defines unlisted components as
components not in Tables 326.1,
A326.1, or K326.1. Unlisted

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components can have pressure ratings but the owner and/or the designer has the responsibility to verify that the design, materials, fabrication, examination, and testing of the component meet the requirements of ASME B31.3. ASME B31.3 Process Piping Guide ASME B31.3-2006 (Revision of ASME B31.3-2004) Process Piping ASME Code for Pressure Piping, B31 AN AMERICAN NATIONAL STANDARD Three Park Avenue • New York, NY 10016 Process

Piping Interpretation: 17-03 Subject: ASME B31.3b-1997 Addenda, Table 341.3.2, Acceptance Criteria for Welds Date Issued: May 19, 1998 File: B31-97-047 Question: In accordance with ASME B31.3b-1997, Table 341.3.2, is the maximum allowable height of

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reinforcement or internal protrusion, in any plane through the weld, listed in "L" for each face of the weld? ASME B31.3 interpretation -

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PD342 Chapter 17 Pressure Safety

Section D20-B31.3-G, ASME B31.3

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3/10/09 4 The Owner and Designer

are responsible for compliance with the personnel and process

qualification requirements of the

codes and standards. In particular,

the application of ASME B31.3

requires compliance with the

Inspector qualification

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