

Information Bulletin No. IB07-002

March 23, 2007

## INTERPRETATION

### Random Radiography for a Designated Lot of ASME B31.3 Piping

Paragraph 344.1.3 of ASME B31.3-2004 defines random examination as "*complete examination of a percentage of a specified kind of item in a designated lot of piping*". Note 2 of the same paragraph further clarifies a "designated lot" as the quantity of piping to be considered in applying the requirements for examination in the Code. These requirements apply to any type of examination under Chapter VI of the Code. In all cases, the examination must be conducted as soon as practicable after completion of welding of the designated lot.

As an example, if random radiographic examination is a requirement for welds, radiographic examination must be done as soon as practicable after completion of welding of the designated lot and the results of the radiographic examination can not, and must not, be applied to any welds that have not been completed at the time of the radiographic examination. It is also not permissible to pre-designate a welder's first production weld for radiographic examination, and then use that radiograph to qualify production welds made after the radiographic examination.

For all random examinations, the quantity and extent of a designated lot must be established by agreement between the contracting parties, prior to the welding and the examination.

#### Background

ASME B31.3, *Process Piping Code* is adopted in the *Pressure Equipment Safety Regulation (AR49/2006)* under Section 6(e)(ii). Misapplication of Paragraph 344.1.3 of the Code by considering results of examination to qualify work yet to be completed may lead to inferior quality and pressure equipment safety hazards.

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