

Information Bulletin No. IB13-013 Rev.2

November 7, 2014

**INTERPRETATION  
Temporary Tack Welds**

**Subject**

Interpretation of Section 2(1) of the Pressure Welders Regulation (169/2002) with respect to tack welds which are completely removed prior to the completion of construction of a boiler, pressure vessel, pressure piping system or fitting (“pressure equipment”).

Information Bulletin **IB14-010** provides interpretations regarding permanent tack welds that may be included in the final weld.

Section 2(1) of the Pressure Welders Regulation states:

*No person shall weld a boiler, pressure vessel, pressure piping system or fitting by any method, unless the person holds a certificate of competency, including a performance qualification card, that specifically authorizes the person to weld the pressure vessel, boiler, pressure piping system or fitting and authorizes the method used by the person.*

**Interpretation**

Tack welding on pressure equipment is not considered as welding under Section 2(1), provided the tack welds are completely removed prior to the completion of the pressure equipment fabrication. Tack welding that is to be completely removed may be performed by a person not holding a pressure welder certificate of competency and performance qualification card.

**Background**

Tack welds are small welds used to hold the parts in alignment in preparation for welding.

- ASME Section I paragraph PW 31.3, Section VIII, Division 1 paragraph UW 31(c), and ASME B31.1 paragraph 127.4.1 (c) all require that tack welds that remain in place must be made by welders qualified in accordance with Section IX. These same codes require tack welds made by unqualified welders to be removed.
- ASME B31.3 paragraph 328.5.1(c) also requires tack welds that remain in place must be made by welders qualified in accordance with Section IX. B31.3 does not directly address tack welds made by unqualified welders, but B31.3 Interpretation 22-35 requires that all tack welds, including temporary tack welds must be made by qualified welders.

This interpretation of the Section 2(1) of the Pressure Welders Regulation allows for better alignment of the requirements of the ASME Boiler and Pressure Vessel Code and the ASME B31 Code for Pressure Piping providing equivalent level of safety under the Alberta Pressure Welders Regulation.

**Important Clarifications**

- (i) All the tack welds performed with the use of this interpretation must be completely removed prior to the completion of the pressure equipment fabrication;
- (ii) This interpretation is for fabrication in Alberta that is installed in Alberta only. For installation outside of Alberta, all concerned parties (the purchaser (owner/user), and the fabricator

- (contractor/manufacturer) involved should confirm its acceptability with the local jurisdiction having authority where the piping system is to be installed;
- (iii) Prior to the use of welders not holding a pressure welder certificate of competency to deposit tack welds for B31.3 construction, the purchaser (owner/user) and the fabricator (contractor/manufacturer) of the pressure piping system should reach an agreement on tack welding requirements including welding procedures, etc. and,
  - (iv) This is an interpretation to Section 2(1) of the Pressure Welders Regulation and is not an interpretation with respect to qualified welders under ASME B31.3 or to compliance with ASME B31.3.

*<Original signed by>*

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