

**INTERPRETATION**  
**Tack Welding (that is to be completely removed)**  
**on a Pressure Piping System**

**Subject**

Interpretation of Section 2(1) of the Pressure Welders Regulation (169/2002) with respect to pressure piping tack welds which are completely removed prior to the completion of the pressure piping fabrication

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 a pressure piping system is not considered as welding under Section 2(1), provided the tack welds are completely removed prior to the completion of the pressure piping 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.

Paragraph 328.5.1(c) of ASME B31.3 requires tack welds to be made by qualified welders.

ASME Section VIII Code does not require qualified welders to perform tack welding in the fabrication of a pressure vessel, provided the tack welds are completely removed prior to the fabrication of the pressure vessel.

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 Pressure Piping Standard 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 piping fabrication;
- (ii) This interpretation is for piping fabrication for installation 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, 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 nor to the compliance of ASME B31.3 Standard.

*<original signed by>*

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