Alberta Municipal Affairs

ABSA the pressure equipment safety authority

Information Bulletin No. IB23-041 WITHDRAWN 2025-10-31 REPLACED BY IB25-022 **October 5, 2023**

NOTIFICATION
Use of Welding Method 6

This Information Bulletin replaces IB18-009, which has been withdrawn.

The National Board Inspection Code (NB-23), Part 3, Section 2.5.3.6 “Welding Method 6” provides guidance for welded repair of Grade 91 boiler tube material using a controlled fill technique in lieu of post-weld heat treatment. This notification provides clarification on the use of Welding Method 6 in Alberta.

Welding Method 6 may be used, provided the following are satisfied:

1. A repair specification (e.g. generic procedure, process, etc.) shall be developed and implemented to ensure compliance with all requirements and limitations described in Welding Method 6. As a minimum, the repair specification shall:
    a. define the circumstances under which Welding Method 6 can be used,
    b. describe the requirements for developing a job-specific repair procedure for each repair,
    c. establish the administrative controls to ensure compliance with Welding Method 6, and
    d. define duties and responsibilities.
2. A welding procedure specification must be prepared specifically for Welding Repair Method 6, and registered in accordance with Section 21 of the Pressure Equipment Safety Regulation.
3. The repair must be carried out and inspected in accordance with the applicable requirements specified in ABSA document AB-513 *Pressure Equipment Repair and Alteration Requirements*.

Welding Method 6 repairs may be included in the scope of owner-certified repairs in accordance with AB-513 Section 6.2.

Information regarding Welding Method 6 is publicly available on the Electric Power Research Institute (EPRI) website: *Best Practice Guideline for Well-Engineered Weld Repair of Grade 91 Steel* (3002003833).

<original signed by>

Djordje Srnic, M.Sc., P.Eng.
Administrator, Province of Alberta Pressure Equipment Safety
Chief Inspector, ABSA the pressure equipment safety authority