Information Bulletin No. IB25-022 **October 31, 2025**

NOTIFICATION
Use of Welding Methods 6 and 7

This information bulletin replaces IB23-041, which has been withdrawn.

The National Board Inspection Code (NB-23), Part 3, Section 2.5.3.6 “Welding Method 6” and Section 2.5.3.7 “Welding Method 7” provides guidance for the weld repair of Grade 91 boiler tube material internal to the boiler or HRSG setting using a controlled fill technique in lieu of post-weld heat treatment. This notification provides clarification on the use of Welding Method 6 and 7 in Alberta. For repairs outside of the boiler or HRSG setting, NB-23, Part 3, Supplement 8 should be referenced.

Welding Method 6 or Welding Method 7 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 or Welding Method 7 as applicable. As a minimum, the repair specification shall:
    a. define the circumstances under which Welding Method 6 or Welding Method 7 can be used,
    b. describe the requirements for developing a job-specific repair procedure for each repair,
    c. describe the administrative process to document a repair risk assessment, management repair acceptance, and the repair re-inspection scope and interval.
    d. establish the administrative controls to ensure compliance with Welding Method 6 or Welding Method 7, as applicable, and
    e. define duties and responsibilities.

2. A welding procedure specification must be prepared specifically for Welding Repair Method 6 or Welding Method 7 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 and/or Welding Method 7 repairs may be included in the scope of owner-certified repairs in accordance with AB-513 Section 6.3.

Information regarding these Welding Methods is publicly available on the Electric Power Research Institute (EPRI) website:

- *Best Practice Guideline for Well-Engineered Weld Repair of Grade 91 Steel* (3002003833),
- *Alternative Weld-Engineered Weld Repair Options for Grade 91 Steel: A Review of Service Experience for Repairs Performed to Welding Methods 6 and 7* (3002012183), and
- *Alternative Well-Engineered Weld Repair Options for Grade 91 Steel: Responses, Comments, and Concerns* (3002012182).

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