

Repair of Boilers

Introduction

Boiler repairs are similar to vessel repairs except that State law mandates all work done to boilers be performed by Code approved contractors, witnessed by an ASME Code Inspector, and stamped per Section 1 of the ASME Code.

Repair Process

The following chart explains the process for repairing boilers.

Stage	Who Does It	Description
1	Owner	Contacts a qualified designer and describes the work to be performed. The designer and owner develop the scope of work to be done.
2	Owner	Contacts the contractor and informs him of the job scope.
3	Contractor	Begins to make any required preparations for the job.
4	Designer	Performs the necessary design, calculations, and drawings and completes sections 1 and 5 of the Vessel Status Change Report (VSCR).
5	Designer	Forwards the original VSCR form to the Vessel Inspection Group who will assign a Vessel Inspector to the job and forwards a copy to the owner.
6	Vessel Inspector	Forwards a copy of the VSCR to the Welding Services Group.
7	Welding Services Group	Assigns a Welding Inspector to the job to work with the owner and the contractor in completing the work described in the scope.
8	Owner	Forwards a copy of the VSCR to the contractor.
9	Contractor	Contacts the Authorized Inspector (AI) and informs him of the job scope. Any arrangements which need to be worked out with the AI is the responsibility of the contractor.
10	Contractor	Completes section 6 of the VSCR
11	Contractor	Obtains approval of the proposed welding procedures, specifications, etc. from the Dow welding inspector assigned to the job prior to beginning fabrication.
12	Contractor	Performs the work as described in section 5B of the VSCR including drawings, specifications, or other standards which Dow may supply.
13	Dow Welding Inspector and/or Vessel Inspector	Must be available for inspection and approval of the work in progress.
14	Vessel Inspector	Completes section 9 of the VSCR.

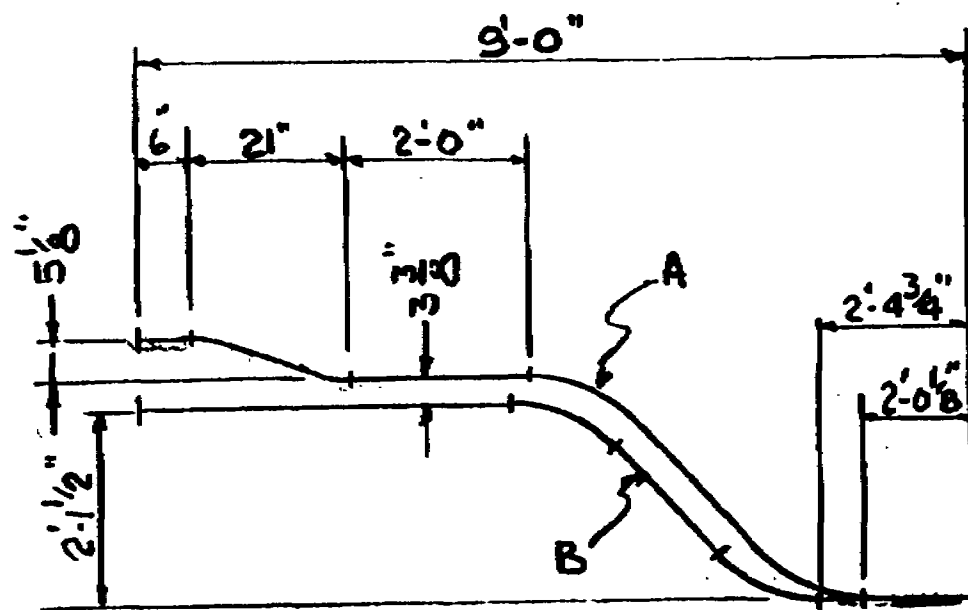
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Repair of Boilers, Continued

Repair Process,
continued

Stage	Who Does It	Description
15	Contractor	Completes Form R-1, Report of Welded Repair or Alteration, as required by the provisions of the National Board Inspection Code and obtains the AI's signature at the completion of the job including all testing and examinations. For those repairs which are considered routine by the AI, no "R-1" form is required, but the contractor shall provide Dow with a "Letter of Compliance" stating the repair was of a routine nature and complies with all requirements of the Louisiana Boiler Inspection Law.
16	Contractor	Files documents with State Fire Marshall as required by law and provides a copy of all documents to owner.
17	Vessel Inspector	Reviews the completed VSCR with the owner and gives him the original.
18	Owner	Obtains the proper signatures and forwards the signed VSCR and "R" form to the Vessel Records Section. The owner shall keep copies for their plant files.
19	Vessel Records Section	Files the forms.



ALL BENDS 18"R.

3/4" O.D. X 0.240" WALL

(MAT'L. - T22, T-91 OR 304H = SUPP.)

} MINIMUM SAFETY - YAT.

REAR - WATER WALL (SECTION)

Ⓐ - 36 REQ'D.

Ⓑ - 71 REQ'D.

WATER TUBE SECTION

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