

Coast Guard, Dept. of Homeland Security

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- 59.10-30 Seal welding.
- 59.10-35 Wrapper plates and back heads.

Subpart 59.15—Miscellaneous Boiler Repairs

- 59.15-1 Furnace repairs.
- 59.15-5 Stayed furnaces and combustion chambers.
- 59.15-10 Bagged or blistered shell plates.

Subpart 59.20—Welding Repairs to Castings

- 59.20-1 Carbon-steel or alloy-steel castings.
- AUTHORITY: 46 U.S.C. 3306, 3703; E.O. 12234, 45 FR 58801, 3 CFR, 1980 Comp., p. 227; Department of Homeland Security Delegation No. 0170.1.

SOURCE: CGFR 68-82, 33 FR 18887, Dec. 18, 1968, unless otherwise noted.

Subpart 59.01—General Requirements

§ 59.01-1 Scope.

The regulations in this part apply to the repairs of all boilers, appurtenances and pressure vessels subject to inspection by the Coast Guard.

§ 59.01-2 Incorporation by reference.

(a) Certain material is incorporated by reference into this part with the approval of the Director of the Federal Register in accordance with 5 U.S.C. 552(a). To enforce any edition other than that specified in paragraph (b) of this section, the Coast Guard must publish notice of change in the FEDERAL REGISTER and make the material available to the public. All approved material is on file at the U.S. Coast Guard, Office of Design and Engineering Standards (G-MSE), 2100 Second Street SW., Washington, DC 20593-0001 and is available from the sources indicated in paragraph (b) of this section or at the National Archives and Records Administration (NARA). For information on the availability of this material at NARA, call 202-741-6030, or go to: http://www.archives.gov/federal_register/code_of_federal_regulations/ibr_locations.html.

(b) The material approved for incorporation by reference in this part and the sections affected are:

American Society of Mechanical Engineers (ASME) International

- Three Park Avenue, New York, NY 10016-5990
- Boiler and Pressure Vessel (B&PV) Code Section I, Power Boilers, July 1989 with 1989 addenda59.10-5
- Boiler and Pressure Vessel Code Section VII, Recommended Guidelines for the Care of Power Boilers, July 1989 with 1989 addenda59.01-5
- Boiler and Pressure Vessel Code Section VIII, Division 1, Pressure Vessels July 1989 with 1989 addenda59.10-5; 59.10-10
- Boiler and Pressure Vessel Code Section IX, Welding and Brazing Qualifications, July 1989 with 1989 addenda.....59.10-5

[CGD 88-032, 56 FR 35824, July 29, 1991, as amended by CGD 95-072, 60 FR 50462, Sept. 29, 1995; CGD 96-041, 61 FR 50728, Sept. 27, 1996; USCG-1999-6216, 64 FR 53225, Oct. 1, 1999]

§ 59.01-3 Adoption of the ASME Code.

(a) *General.* The portions of the ASME (American Society of Mechanical Engineers) Code listed in this part for various subjects are adopted and shall be the governing requirements except as limited, modified, or replaced by specific requirements in this subchapter.

(Sec. 552, 80 Stat. 383, as amended; 5 U.S.C. 552)

§ 59.01-5 Repairs, replacements, or alterations.

(a) No repairs, replacements, or alterations, except emergency repairs, shall be made to boilers, pressure vessels, their mountings or internal fittings, safety valves, piping systems, or pressure appliances without prior approval by the Officer in Charge, Marine Inspection.

(b) Emergency repairs, replacements, or alterations shall be reported as soon as practicable to the Officer in Charge, Marine Inspection, at or nearest the first port where the vessel may call after such repairs are made.

(c) Plan approval shall be obtained from the Officer in Charge, Marine Inspection, for all alterations to systems in service as listed in § 56.01-10(c) of this subchapter and those items listed in paragraph (a) of this section.

(d) Repairs, replacements, or alterations to machinery or items not covered by other sections of this part shall

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be made in a manner consistent with the part of this subchapter containing the construction standards for the item in question.

(e) Where applicable, manufacturers' instruction books, manuals, etc., and the Mechanical Injury Section, paragraphs C4.401 through C4.427 of section VII of the ASME Code, shall be used for guidance.

Subpart 59.10—Welding Repairs to Boilers and Pressure Vessels in Service

§ 59.10-1 Scope.

(a) Repairs to boilers or pressure vessels in service may be performed by welding provided the welding meets the applicable requirements of part 57 of this subchapter.

(b) No repairs by welding shall be made except temporary emergency repairs without prior approval of the Officer in Charge, Marine Inspection. Emergency repairs shall be replaced with permanent repairs meeting the requirements of this subchapter when the vessel returns to a port in which an Officer in Charge, Marine Inspection, is located except in the case of minor repairs which in the opinion of the Officer in Charge, Marine Inspection, do not materially affect the safety of the boiler or pressure vessel.

(c) Repair welding of power boilers, not meeting the requirements of subpart 52.05 of this subchapter, is prohibited unless the stress is carried by such other type(s) of construction complying with the requirements of this subchapter, and where the adequacy of the boiler design is not solely dependent upon the strength of the welds.

(d) Only welded repairs as specified in this subchapter are permitted on boilers and pressure vessels. The welding repairs allowed by this subpart apply only to boilers and pressure vessels fabricated of carbon steel. Welding repairs to boilers and pressure vessels fabricated of alloy steel will be given special consideration by the Commandant. Such other method of repairs by means of welding not covered in this subchapter shall be referred to the Commandant and may be authorized by him, if in his opinion, it meets the intent of this subchapter.

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§ 59.10-5 Cracks.

(a) Cracks extending from the calking edge of plates to the rivet holes of circumferential joints may be welded provided the cracks are veed out so that complete penetration of the weld metal is secured.

(b) Circumferential cracks from rivet hole to rivet hole in girth joints may be welded provided there are not more than three consecutive cracked ligaments nor more than a total of six cracked ligaments in any one girth joint.

(c) Cracks in staybolted plates may be welded provided they are located entirely within staybolted areas and the total length of any crack or series of consecutive cracks does not exceed two staybolt pitches.

(d) Cracks in plain, circular or Adamson ring or similar type furnaces may be welded provided any one crack does not exceed 12 inches in length and after completion the weld is stress-relieved. Cracks in corrugated furnaces may be repaired by welding provided any one crack does not exceed 20 inches in length.

(e) Fire cracks may be welded at riveted door openings extending from the edge of the plate, but not more than 2 inches beyond the centerline of the rivet holes.

(f) Cracks may be welded between tube holes in the shell of water tube boiler drums, provided there are not more than two cracks in any one row in any direction, nor more than a total of four cracks in a drum, and further provided the welding meets the requirements of this subchapter for Class I welded pressure vessels and is approved by the Commandant.

(g) Cracks that occur in superheater manifolds, water wallheaders, water drums, sectional headers, and other appurtenances including steam manifolds of water tube boilers may be repaired in accordance with paragraph (h) of this section if the repair is approved.

(h) All cracks permitted to be repaired under this subpart shall be excavated to sound metal by grinding, flame or arc gouging or chipping out the defective metal to form a clean welding groove. The first two methods of excavation are preferable. Either a V groove or U groove wherein complete