

5230.5920 QUALIFICATION OF WELDING PROCEDURES, WELDERS, AND WELDING OPERATORS.

Subpart 1. **Scope.** This part applies to welding that is part of any high pressure piping work, except where the welding is regulated by other codes or Minnesota state regulatory bodies, such as the Power Boiler and Pressure Vessel sections of the ASME Boiler and Pressure Vessel Code.

Subp. 2. **Incorporation by reference.** For purposes of this chapter, "ASME section IX" means the 2021 edition of section IX of the Boiler and Pressure Vessel Code, as approved and published by ASME, Two Park Avenue, New York, New York 10016. ASME section IX is incorporated by reference and made a part of this chapter. ASME section IX is not subject to frequent change. A copy of ASME section IX is available in the office of the commissioner of labor and industry and at the State Law Library, 25 Rev. Dr. Martin Luther King Jr. Blvd., Saint Paul, Minnesota 55155.

Subp. 3. **Welding qualifications.** Standard qualifications for welding procedures, welders, and welding operators made according to ASME section IX qualify for work under this part.

Subp. 4. **Retest and renewal of welder qualification.** Welders and welding operators must meet the standard requirements for initial welder qualification, welder continuity requirements, and retest and renewal requirements, as set forth in ASME section IX.

Subp. 5. **Weld procedure and qualification requirements.** No welding may be performed on high pressure piping systems without a welding procedure specification and an associated procedure qualification record. Welding performed on high pressure piping systems must be performed using only welders or welding operators properly qualified in accordance with ASME section IX. All welding procedures must meet the requirements of ASME section IX.

Subp. 6. **Department evaluation.** The welding procedure specifications, procedure qualification records, and welder or welding operator performance qualification and associated continuity records must be objectively evaluated by and acceptable to the administrative authority in accordance with ASME section IX.

Subp. 7. **Documentation required.** Welding performed on high pressure piping systems must be supported by the mandatory documents of the welding procedure specification and procedure qualification record. These documents, along with support for welder qualification, must be available at the work site upon request.

Subp. 8. **Welder identification requirement.** A welder or welding operator qualified for a project must be assigned an identification number, letter, or symbol unique to that welder. Each weld must be stamped or marked with the welder's unique identifier. Alternatively, the contractor shall maintain records that identify welds made by the welder or welding operator.

Subp. 9. **Contractor responsibility.** The contractor is responsible for establishing and retaining the needed documents to conform to the requirements of this part.

Statutory Authority: *MS s 326B.925*

History: *34 SR 145; 39 SR 1343; 42 SR 1423; 47 SR 741*

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