

# **AFCEN RCC-M Errata 014 – EN**

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**afcen**

AFCEN

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# AFCEN RCC-M Errata 014

## NOTE TO USERS

This document provides the corrections described in the table below, affecting the code editions, versions and paragraphs mentioned.

Code edition(s)	Version(s)	Errata description	Paragraph(s)
2018, 2020	English, French	<i>Correction of a typographic error concerning thicknesses in table H 4500</i>	<i>H 4500</i>

Modified pages are presented in chronological order for 2018 and 2020 editions.

Modified parts of text appear in red.

TABLE H 4500 - WELDING EXAMINATION OF SUPPORTS

C A T E G O R Y	C L A S S O F S U P P O R T	T Y P E S O F W E L D S	T H I C K N E S S	E X A M I N A T I O N O F S U R F A C E S T O B E W E L D E D		E X A M I N A T I O N D U R I N G W E L D I N G			P O S T W E L D E D E X A M I N A T I O N S	
				Examination (5)	Criteria		Examination (5)	Criteria	Examination (5)	Criteria
1	S 1	1 -FULL PENERATION WELDS a) Corner welds (1)	on part A $e > 10$ mm	PT or MT (2)	H 4430	after back side machining	PT or MT	H 4430	PT or MT (2) UT or RT (3)	SEE H4530
		on part B $e > 10$ mm	PT or MT (2)	H 4430						
		(4)						PT 10 %		
		$e \leq 10$ mm								
	2 - OTHER WELDS (6)	(4) $e > 10$ mm	PT or MT (2)	H 4430	after back side machining	PT or MT	H 4430	PT or MT (2) UT or RT (3)		
		(4) $e \leq 10$ mm						PT 10 %		
		(4) $e > 10$ mm	PT or MT (2)	H 4430				PT or MT (2)		
S 2	PARTIAL OR FULL PENETRATION BUTT WELDS WHERE $e \geq 25$ mm AND FILLET WELDS WITH THROAT DIMENSIONS GREATER THAN 25 mm			PT or MT (2)	H 4430				PT or MT (2)	
		OTHER WELDS								
2	S 1 ou S 2	ALL WELDS								

NOTA 1 : In the non-destructive examination of corner welds, a full penetration weld shall be understood as welded from both side with interpenetration at root level

NOTA 2 : Magnetic particle examination (MT) is recommended in the case of ferritic steel

NOTA 3 : Ultrasonic examination (UT) is recommended in the case of ferritic steel, radiographic examination in the case of austenitic steel

NOTA 4 : In the case of piping support welds, required thickness is 20mm instead of 20 mm

NOTA 5 : Visual examination is required in all cases; examination of surfaces to be welded and backing run in accordance with the criteria of H 4430 and postweld examination in accordance with H 4520

NOTA 6 : For corner welds, other than full penetration welds, the minimum thickness should be taken into account for postweld examination

TABLE H 4500 - WELDING EXAMINATION OF SUPPORTS

C A T E G O R Y	C L A S S O F S U P P O R T	T Y P E S O F W E L D S	T H I C K N E S S	E X A M I N A T I O N O F S U R F A C E S T O B E W E L D E D		E X A M I N A T I O N D U R I N G W E L D I N G			P O S T W E L D E D E X A M I N A T I O N S	
				Examination (5)	Criteria		Examination (5)	Criteria	Examination (5)	Criteria
1	S 1	1 -FULL PENERATION WELDS a) Corner welds (1)	on part A $e > 10$ mm	PT or MT (2)	H 4430	after back side machining	PT or MT	H 4430	PT or MT (2) UT or RT (3)	SEE H4530
		on part B $e > 10$ mm	PT or MT (2)	H 4430						
		(4)							PT 10 %	
		$e \leq 10$ mm								
		b) Butt welds	(4) $e > 10$ mm	PT or MT (2)	H 4430	after back side machining	PT or MT	H 4430	PT or MT (2) UT or RT (3)	
			(4) $e \leq 10$ mm						PT 10 %	
		2 - OTHER WELDS (6)	(4) $e > 10$ mm	PT or MT (2)	H 4430				PT or MT (2)	
		(4) $e \leq 10$ mm						PT 10 %		
	S 2	PARTIAL OR FULL PENETRATION BUTT WELDS WHERE $e \geq 25$ mm AND FILLET WELDS WITH THROAT DIMENSIONS GREATER THAN 25 mm		PT or MT (2)	H 4430				PT or MT (2)	
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