

Table 1—Applicable P-numbers (Continued)

P-num.	Base Metal Description (Strength and Chemistry)
41	50 ksi (345 MPa) ± 70 ksi (483 MPa) TS carbon—unalloyed
42	70 ksi (483 MPa) TS carbon—0.07 % Cu, 30 % Ni
43	110 ksi (758 MPa) ± 120 ksi (828 MPa) TS NiCrFe alloys (47 % Ni to 72 % Ni, 10 % Cr to 20 % Cr, 0 % Mn to 16 % Mn, 0 % Pb to 10 % Pb, 14 % Ni, 12 % Cu, 3.0 % Zn, Cu, Al, Fe)
44	45 ksi (310 MPa) ± 110 ksi (758 MPa) TS NiMo, NiMoCr alloys (50 % Ni to 70 % Ni, 10 % Mo to 20.0 % Mo, 1.0 % Cr to 7 % Cr, 20 % Pb, 10 % Cu, 3.0 % Zn, Cu, Al, Fe)
45	60 ksi (414 MPa) ± 120 ksi (828 MPa) TS NiCuCr alloys (21 % Ni to 40 % Ni, 10 % Cu to 40 % Cu, 20 % Cr to 30 % Cr, 1.0 % Mn to 7 % Mn, 10 % Cu, 3 % Ni, 2.0 % Cu to 8 % Cu, Cu, Al, Ti, Fe)
46	70 ksi (483 MPa) ± 90 ksi (620 MPa) TS NiCrFe alloys (30 % Ni to 37 % Ni, 10 % Cr to 20 % Cr, 1.20 % Mn to 2.7 % Mn, 30 % Ni)
47	deleted
48	120 ksi (828 MPa) carbon alloys (C), 20 % Cr, 0 % Ni, 0 % Mn, 0 % Pb, 0 % Fe, 0 % Ni
51	30 ksi (207 MPa) ± 50 ksi (345 MPa) TS titanium—unalloyed (alpha) (Ti, Pd, Nb)
52	45 ksi (310 MPa) ± 70 ksi (483 MPa) TS titanium—unalloyed and alloyed (alpha) (Ti, 0.2 % Mn, 0.05 % Ni)
53	50 ksi (345 MPa) TS titanium alloys (alpha-beta) (Ti, 1 % Al, 2.0 % V)
54	70 ksi (483 MPa) TS titanium—alloyed (alpha) (Ti, 0.2 % Mn, 0.05 % Ni) general P-52
55	50 ksi (345 MPa) TS zirconium—unalloyed
56	50 ksi (345 MPa) TS zirconium—alloyed (Zr, 0.2 % Cu)

4 General Welding Requirements

4.1 Structural (pressure boundary) welding requirements shall comply with either AWS D1.1 or AWS D1.6. When approved by the purchaser (engineer) welding procedures may be qualified per ASME BPVC Section IX.

4.2 Prequalified welding procedures per AWS D1.1 and AWS D1.6 will be accepted for structural welding.

4.3 All welding procedure specifications (WPSs) and procedure qualification records (PQRs) shall be submitted to the purchaser for review and approval prior to the start of fabrication or construction unless submitted as required by the purchaser. Weld maps, similar guides or fabrication drawings which clearly identify the application of each WPS, indicating where and how these WPSs will be used, shall be included in the submittal.

4.4 Weld maps, similar guides, drawings or other documentation shall be updated during fabrication to clearly indicate the weld(s) or welding operator(s) that made each weld. Similarly, record the location of any NDT performed and update the information during fabrication.

5 Welding Processes

5.1 Acceptable Welding Processes

Acceptable welding processes are as follows:

- shielded metal arc welding (SMAW);
- gas tungsten arc welding (GTAW) and pulsed GTAW (GTAW-P);

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Table of Contents Api 582 Online Bijaky

1. Understanding the eBook Api 582 Online Bijaky
 - The Rise of Digital Reading Api 582 Online Bijaky
 - Advantages of eBooks Over Traditional Books
2. Identifying Api 582 Online Bijaky
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Api 582 Online Bijaky
 - User-Friendly Interface
4. Exploring eBook Recommendations from Api 582 Online Bijaky
 - Personalized Recommendations
 - Api 582 Online Bijaky User Reviews and Ratings
 - Api 582 Online Bijaky and Bestseller Lists
5. Accessing Api 582 Online Bijaky Free and Paid eBooks
 - Api 582 Online Bijaky Public Domain eBooks
 - Api 582 Online Bijaky eBook Subscription Services

- Api 582 Online Bijaky Budget-Friendly Options
- 6. Navigating Api 582 Online Bijaky eBook Formats
 - ePub, PDF, MOBI, and More
 - Api 582 Online Bijaky Compatibility with Devices
 - Api 582 Online Bijaky Enhanced eBook Features
- 7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Api 582 Online Bijaky
 - Highlighting and Note-Taking Api 582 Online Bijaky
 - Interactive Elements Api 582 Online Bijaky
- 8. Staying Engaged with Api 582 Online Bijaky
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Api 582 Online Bijaky
- 9. Balancing eBooks and Physical Books Api 582 Online Bijaky
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Api 582 Online Bijaky
- 10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
- 11. Cultivating a Reading Routine Api 582 Online Bijaky
 - Setting Reading Goals Api 582 Online Bijaky
 - Carving Out Dedicated Reading Time
- 12. Sourcing Reliable Information of Api 582 Online Bijaky
 - Fact-Checking eBook Content of Api 582 Online Bijaky
 - Distinguishing Credible Sources
- 13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
- 14. Embracing eBook Trends

- Integration of Multimedia Elements
- Interactive and Gamified eBooks

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