react unfavorably with either the service fluid or the piping materials.

(b) Threaded joints which are to be seal welded shall be made up without any thread compound.

(c) Backing off to permit alignment of pipe threaded joints shall not be permitted.


Subpart 56.95—Inspection

§ 56.95–1 General (replaces 136).

(a) The provisions in this subpart shall apply to inspection in lieu of 136 of ASME B31.1 (incorporated by reference; see 46 CFR 56.01–2).

(b) Prior to initial operation, a piping installation shall be inspected to the extent necessary to assure compliance with the engineering design, and with the material, fabrication, assembly and test requirements of ASME B31.1, as modified by this subchapter. This inspection is the responsibility of the owner and may be performed by employees of the owner or of an engineering organization employed by the owner, together with the marine inspector.


§ 56.95–5 Rights of access of marine inspectors.

Marine inspectors shall have rights of access to any place where work concerned with the piping is being performed. This includes manufacture, fabrication, assembly, erection, and testing of the piping or system components. Marine inspectors shall have access to review all certifications or records pertaining to the inspection requirements of §56.95–1, including certified qualifications for welders, welding operators, and welding procedures.

§ 56.95–10 Type and extent of examination required.

(a) General. The types and extent of nondestructive examinations required for piping must be in accordance with this section and Table 136.4 of ASME B31.1 (incorporated by reference; see 46 CFR 56.01–2). In addition, a visual examination shall be made.

(1) 100 percent radiography is required for all Class I, I-L, and II-L piping with wall thickness equal to or greater than 10 mm (.375 in.).

(2) Nondestructive examination is required for all Class II piping equal to or greater than 18 inches nominal diameter regardless of wall thickness. Any test method acceptable to the Officer in Charge, Marine Inspection may be used.

(3) Appropriate nondestructive examinations of other piping systems are required only when deemed necessary by the Officer in Charge, Marine Inspection. In such cases a method of testing satisfactory to the Officer in Charge, Marine Inspection must be selected from those described in this section.

(b) Visual examination. Visual examination consists of observation by the marine inspector of whatever portions of a component or weld are exposed to such observation, either before, during, or after manufacture, fabrication, assembly or test. All welds, pipe and piping components shall be capable of complying with the limitations on imperfections specified in the product specification under which the pipe or component was purchased, or with the limitations on imperfections specified in §56.70–15(b) (7) and (8), and (c), as applicable.

(c) Nondestructive types of examinations—(1) 100 Percent radiography. Where 100 percent radiography is required for welds in piping, each weld in the piping shall be completely radiographed. If a butt weld is examined by radiography, for either random or 100 percent radiography, the method used shall be as follows:

(i) X-ray or gamma ray method of radiography may be used. The selection of the method shall be dependent upon its adaptability to the work being radiographed. The procedure to be followed shall be as indicated in PW–51 of section I of the ASME Boiler and Pressure Vessel Code (incorporated by reference; see 46 CFR 56.01–2).

1Where for some reason, such as joint configuration, radiography is not applicable, another approved examination may be utilized.