

Meeting Minutes: Welding Committee-Board of HPPS

Date: February 14, 2022
Time: 9 a.m.
Minutes by: Jake Pettit
Location: WebEx Event

Committee Members Present

1. Kyle Bain
2. Todd Green – CO’s Designee
3. Mark Kincs
4. Jake Pettit
5. Roger Thein – Committee Chair

DLI Staff & Visitors

Brittany Wysokinski (Gen. Counsel, DLI)
Lyndy Logan (DLI)
Mike Little (HPP Inspector)

Committee Members Absent

Kent Spaulding

Call to Order

- A. Roll Call – meeting was called to order at 9:00 a.m. by Chair Thein and roll call was completed by Secretary Pettit. A quorum was met with 5 of 6 voting committee members present electronically.
- B. Announcements/Introductions
 - Remote Meeting Statement from Chair
- C. WebEx instruction/procedures were read aloud

Approval of Meeting Agenda

A motion was made by Mark Kincs, seconded by Kyle Bain, to approve the agenda as presented. The roll call vote was unanimous with 5 votes in favor; the motion carried.

Approval of Previous Meeting Minutes

Mark Kincs amended the previous meeting minutes to replace the word “required” with “enabled” on page 2. A motion was made by Jake Pettit, seconded by Mark *Kincs*, to approve the previous meeting minutes as amended. The roll call vote was unanimous with 5 votes in favor; the motion carried.

Approval of Expense Reports

Electronic expense reports will be sent by Lyndy to Financial Services for payment.

Special Business

Minnesota High Pressure Piping Code: Welding

- Kincs—suggests adding the term “Welding Operator” to subpart 5.
- Kincs—makes a motion to make that change
- Bain—asks whether we need motions to change the draft at this point
- Thein—ultimately determines that motions will not be needed at this point
- Kincs—Rescinds motion.
- Bain—Asks how removing the welding log requirement in subpart 8 effect enforcement

- Green—States that the Department has permitted the submission of a welding log
- Thein—Asks what counts as marking, as stated in the rules
- Kincs—Welding log is not defined in the code
- Wysokinski—Explains that the definition of welding log would be up to the industry standards
- Green—Removal of the welding log requirement would not affect enforcement because the language of the rule would still permit a welding log to be submitted.
- Bain—Asks whether subpart 8 could be removed entirely
- Green—Reads language from ASME B31.1-2020, section 127.6 and suggest incorporating similar language in subpart 8
- Thein—Suggests addition of sentence to end of subpart 8 allowing contractors to maintain records that identify welds made by the welder or welding operator.
- Bain—Asks whether committee should vote on draft as a whole or each subpart individually. Also asks what happens if the Board wants to make changes and whether the rules will come back to the committee.
- Wysokinski—The Board will decide if the draft needs to return to committee, or whether the Board wants to make its own changes
- Thein—Decides to vote on each subpart, including subparts that were not changed

A motion was made by Thein, seconded by Bain, to approve subpart 1 as it appears in Attachment A, Draft 4. The vote was unanimous with 5 votes in favor; the motion carried.

A motion was made by Kincs, seconded by Bain, to approve subpart 2 as it appears in Attachment A, Draft 4. The vote was unanimous with 5 votes in favor; the motion carried.

A motion was made by Bain, seconded by Pettit, to approve subpart 3 as it appears in Attachment A, Draft 4. The vote was unanimous with 5 votes in favor; the motion carried.

A motion was made by Pettit, seconded by Bain, to approve subpart 4 as it appears in Attachment A, Draft 4. The vote was unanimous with 5 votes in favor; the motion carried.

A motion was made by Pettit, seconded by Kincs, to approve subpart 5 as it appears in Attachment A, Draft 4. The vote was unanimous with 5 votes in favor; the motion carried.

A motion was made by Pettit, seconded by Bain, to approve subpart 6 as it appears in Attachment A, Draft 4. The vote was unanimous with 5 votes in favor; the motion carried.

A motion was made by Kincs, seconded by Bain, to approve subpart 7 as it appears in Attachment A, Draft 4. The vote was unanimous with 5 votes in favor; the motion carried.

A motion was made by Bain, seconded by Kincs, to approve subpart 8 as it appears in Attachment A, Draft 4. The vote was unanimous with 5 votes in favor; the motion carried.

A motion was made by Bain, seconded by Pettit, to approve subpart 9 as it appears in Attachment A, Draft 4. The vote was unanimous with 5 votes in favor; the motion carried.

A motion was made by Bain, seconded by Kincs, to reaffirm the affirmative vote on subpart 1 so that the Chair Thein was not involved in the motion. The vote was unanimous with 5 votes in favor; the motion carried.

Board Discussion

Kincs asked whether there was anything in particular that should be discussed related to the Statement of Need and Reasonableness (SONAR) and stated that there did not appear to be any major costs associated with this proposal.

Announcements

N/A

Adjournment

A motion made by Kincs, seconded by Bain, to adjourn the meeting at 10:09 a.m. The roll call vote was unanimous with 5 votes in favor; the motion carried.

Respectfully Submitted,

JAKE PETTIT
Committee Secretary

Green meeting practices

The State of Minnesota is committed to minimizing in-person environmental impacts by following a green meeting practices. DLI is minimizing the environmental impact of its events by following green meeting practices. DLI encourages you to use electronic copies of handouts or to print them on 100% post-consumer processed chlorine-free paper, double-sided.

Rule 5230 Proposed Changes

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 ~~Unfired~~ 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 ~~2017~~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 properly qualified ~~according to~~ the essential variables associated with the welding procedure. All welding procedures must meet the requirements of ASME section IX.

Subp. 6. **Department eEvaluation standards.** ~~The~~ Upon request by the administrative authority, welding procedure specifications, ~~and~~ procedure qualification records, and welder performance qualification and continuity records shall ~~must~~ be provided for objectively review evaluated by and acceptance prior to welding ~~ble to the administrative authority~~.

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

Subp. 8. **Welder identification and log requirement.** A welder ~~or welding operator~~ qualified for a project must be assigned an identification number, letter, symbol unique to that welder. Each weld must be stamped or marked with the welder's identification symbol. ~~A welding log must be maintained as set forth in ASME section IX.~~

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

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Commented [KMR1]: "Unfired" has been removed from the name of Section VIII.

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Commented [KMR3]: Suggest re-titling, to clarify and emphasize Department activity. Include welder qualification review. Emphasize that when evaluation is done, it should be prior to welding. Consider removing the word "objective" or "objectively"...this is open to interpretation.

Commented [KMR4]: Remove "welding procedure qualification"...no such document in Section IX.

Commented [KMR5]: Add "welding operator" as in Subp. 3&4. Add "number, letter..." as identification options to reflect Section IX language. Delete "welding log"...no such document in Section IX.

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Rule 5230 Proposed Changes - Draft 2

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

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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 properly qualified ~~in accordance with section IX, according to the welding procedure.~~ All welding procedures must meet the requirements of ASME section IX.

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

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

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Subp. 8. **Welder identification and log 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, identification symbol. A welding log must be maintained as set forth in ASME section IX.~~

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Rule 5230 Proposed Changes - Draft 3

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Rule 5230 Proposed Changes - Draft 4

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

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