

# Meeting Minutes: Welding Committee-Board of HPPS

Date: February 3, 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. Kent Spaulding
6. Roger Thein – Committee Chair

## DLI Staff & Visitors

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

## Committee Members Absent

None

### 1. Call to Order

- A. Roll Call – meeting was called to order at 9:05 a.m. by Chair Thein and roll call was completed by Secretary Pettit. A quorum was met with 6 of 6 voting committee members present electronically.
- B. Announcements/Introductions
  - Remote Meeting Statement from Chair
- C. WebEx instruction/procedures were read aloud

### 2. 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 6 votes in favor; the motion carried.

### 3. Approval of Previous Meeting Minutes

No previous minutes.

### 4. Approval of Expense Reports

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

### 5. Special Business

Minnesota High Pressure Piping Code: Welding

- Kincs—Shared draft of proposed changes to Minn. Rules section 5230.5920 (see “Rule 5230 proposed changes” on page three).
- Kincs—Proposed removal of term “unfired” from subpart 1 to reflect current title of code.
- Kincs—Proposed changes to subpart 5 to reflect that welders are not necessarily qualified to a specific welding procedure.
- Lebowski—Asked what standards are being applied to welder qualifications in subpart 5.
- Bain—Proposed stating that welders be qualified in accordance with ASME section IX.

- Kincs—Proposed changes to subpart 6 that would *enable* the administrative authority to request certain materials for review prior to welding.
- Green—Suggested that the administrative authority not be mandated to complete the review prior to welding as doing so adds a new requirement for the administrative authority that may be burdensome.
- Thein—Proposed adding a reference to the standard used during the review process in subpart 6.
- Kincs—Proposed removal of reference to welding procedure qualification in subpart 7 as such a document does not exist in ASME section IX.
- Kincs—Proposed adding reference to identification number and letter in subpart 8 to be consistent with the language in ASME section IX.
- Kincs—Proposed removal of reference to welding log in subpart 8 as such a document does not exist in ASME section IX.
- Bain—Proposed that the rules should not mandate that an identifier be marked on each weld.
- Pettit—Suggested that the rule requiring a mark on each weld should not be changed.
- Thein—Asked if the “s” in ASME section IX could be capitalized.
- Lebowski—Advised that the State Revisor’s Office decides how to capitalize the citations in the rules.
- Thein—Announced a ten minute break.
- Kincs—Shared updated proposed rule draft with revisions made pursuant to committee discussion (see “Rule 5230 proposed changes-Draft 2” on page four).
- Lebowski—Suggested that “ASME” appear before references to “section IX”
- Bain—Suggested that welding operators be specifically referenced in the rules
- Thein—Asked Kincs to add in the additional edits to the draft of proposed changes and asked that the updated draft be circulated after the meeting (document labeled “Rule 5230 proposed changes-Draft 3” on page five).

## 6. Board Discussion

## 7. Announcements

Next meeting-9 a.m., February 14, 2022-via WebEx

## 8. Adjournment

A motion made by Kyle Bain, seconded by Kent Spaulding, to adjourn the meeting at 10:59 a.m. The roll call vote was unanimous with 6 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 e~~**Department Evaluation 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.

**Commented [KMR2]:** Welders are not necessarily qualified to the welding procedure. They are usually qualified to a welding procedure or set of procedures having a certain set of essential variables which the welder performance qualifications must include.

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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.

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.

**Commented [KMR 1]:** "Unfired" has been removed from the name of Section VIII.

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

**Commented [KMR 2]:** Welders are not necessarily qualified to the welding procedure. They are usually qualified to a welding procedure or set of procedures having a certain set of essential variables which the welder performance qualifications must include.

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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.~~

**Commented [KMR 3]:** Suggest re-titling, to clarify and emphasize Department activity. Include welder qualification review.

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.

**Commented [KMR 4]:** Remove "welding procedure qualification"...no such document in Section IX.

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.~~

**Commented [KMR 5]:** 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.

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

## Rule 5230 Proposed Changes - Draft 3

### 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.

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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 ASME section IX according to the welding procedure. All welding procedures must meet the requirements of ASME section IX.

Subp. 6. **Department evaluation standards.** The welding procedure specifications ~~and~~ 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 ~~welding procedure qualification~~, 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 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.~~

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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