

PRODUCT CARD

Repairs to pressure vessels

Inevitably, throughout its life, an item of plant within a pressure system will require some form of repair. It's essential that any repair is carried out by a person who is competent to do so and that nothing in the way it is repaired gives rise to danger or impairs the operation of any protective device or inspection activity.

Responsibilities and requirements

In accordance with Regulation 13 of The Pressure Systems Safety Regulations (PSSR), when designing any repair, the following points should be taken into account:

- The original design specification of the item of plant
- The duty for which the item is to be used following the repair
- The effects that such work may have on the integrity of the pressure system

- Whether the protective devices are still adequate
- Continued suitability of the Written Scheme of Examination.

The responsibility to ensure that any repair is carried out in an appropriate manner rests with the employer of the person engaged to carry out the repair.

Where repairs are to be carried out which might increase the risk of system failure, the user should contact a Competent Person who is able to advise before work begins, not only to ensure that the repair is being carried out appropriately, but also to establish the root cause of the defect requiring repair with the intent of avoiding the need for future repair.

The Competent Person will also need to have an involvement in the repair to establish whether or not the Written

Scheme of Examination remains valid. This may involve reduced inspection frequencies and additional Non Destructive Testing (NDT) requirements.

How we can help you

We apply the guidance in the Safety Assessment Federation; PSG15, Guidelines for Competent Person; Repairs or Modifications to Pressure Systems. This is recognised as best practice within industry and is used by other UKAS appointed Inspection Bodies. As an independent and impartial inspection company we're able to provide our clients with help and support throughout the repair process.

Our national team of engineer surveyors acting as the Competent Person, together with our technical specialists, will be on hand to review your repairer's proposals which should include (but not be limited to):

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- **Job Method Statement** – detailing a step-by-step procedure for the work being carried out
- **Welding Procedures** – detailing the weld procedure that will be adopted during the repair
- **Welder Certification** – the welders approvals and scope for applying that weld during repair
- **Material Certification** – provided by the supplier of the material being used in the repair and should indicate the material grade and thickness
- **Consumable Certification** – the welding consumables should be selected so that the mechanical and chemical properties are compatible with the base material.

During the repair process there may be 'hold points' where additional inspections or NDT are required before work may continue.

On completion of all work we will, subject to contract:

- Witness the hydraulic pressure test
- Carry out final post weld Non-Destructive Examination of the repair (as applicable)
- Review and reissue the existing Written Scheme of Examination to ensure that it remains suitable.

For further information

To discuss how we can help you with your engineering needs, please contact:

Tel: 0345 076 0146

Email: special.services@allianz.co.uk

Alternatively, visit us online at allianz.co.uk/specialservices for our full list of engineering services.