REPAIR PROCEDURE FOR NOTCHES OR GOUGES

Notches and gouges not more than 3/16” (5mm) deep shall be removed by grinding.

Notches that exceed 3/16” (5mm) may be repaired by grinding if the nominal cross-sectional area is not reduced by more than 2%. Ground surfaces shall be faired to the original surface with a slope not exceeding one in ten.

Cut surfaces and adjacent edges shall be left free of slag.

In thermal cut surfaces, if the cross-sectional area is reduced by more than 2% and the occasional notches or gouges exceed 3/16” (5mm), the areas may be repaired by welding after the approval from the engineer. If any repairs by welding shall be done, the following steps shall be taken:

1. Prepare the weld repair area
2. Weld using an approved low hydrogen process
3. Grind the completed weld smooth and flush with the adjacent surface to produce a workmanlike finish.

If you have any questions, contact project manager or shop superintendent for more details.