



## TECHNICAL CIRCULAR No. 646 of 8<sup>th</sup> August 2020

To	All Surveyors/Auditors. All flags
Title	<b>Welding repairs</b>
Reference	CONARINA - Instructions

### **Repairs of Underwater Shell Fractures Afloat by Welding**

For repairs requiring welding of underwater shell fractures made afloat, the Owners and/or repair firm is to submit a repair plan to the Surveyor. The plan should include condition of the ship, NDE, materials, welding procedures and welding qualifications, etc.

Where it is proposed to conduct only one-sided welding from inside the vessel, then the attending Surveyor it to submit the weld procedure to CONARINA Head Office for review prior to commencing welding.

If the welding is satisfactory, then the repair may be considered a permanent repair.

If repair is considered permanent, it should be stated in the Damage Report with no requirement for further exam.

In some cases, a follow up examination and NDE should be done at the next dry-docking survey. If the only reason for the follow up examination and NDE is preventative, it is to be recorded as an Additional Requirement.

If the root pass is not complete, or any other problem is found regarding the repair's continued effectiveness, then this must be stated in the report for follow up survey and NDE at the vessel's next dry-docking survey.

#### REFERENCES:

- CONARINA – Instructions. Courtesy of ABS.
- ATTACHMENTS: No

Kindest Regards,

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Naval Architect – Conarina Technical Director

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