

Installation of Stainless Chromium-Nickel Steel and Nickel-Alloy Roll-Bonded and Explosion-Bonded Clad Plate in Air Pollution Control Equipment

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ABSTRACT

This standard practice provides technical and quality assurance guidelines for the fabrication, welding, and installation of clad plate bonded in air pollution control or other equipment such as flue gas desulfurization (FGD) systems, ducts, and stacks. Also included are procedures for the qualification of welders and the inspection and repair of welds, as well as an appendix on handling clad plate components. Detailed figures on weld joint design are included.

This standard is intended for use by architect-engineers, designers, fabricators, and personnel from electric utilities.

KEYWORDS

Welding, FGD, air pollution, chromium-nickel steel alloys, explosion-bonded clad plate, nickel alloys, TG 199.

Foreword

In NACE standards, the terms “shall,” “must,” “should,” and “may” are used in accordance with the definitions of these terms in the NACE Publications Style Manual. The terms “shall” and “must” are used to state a requirement, and are considered mandatory. The term “should” is used to state something good and is recommended, but is not considered mandatory. The term “may” is used to state something considered optional.

The purpose of this standard practice is to provide technical and quality assurance guidelines for the fabrication, welding, and installation of stainless chromium-nickel steel and nickel-alloy roll-bonded and explosion-bonded clad plate in air pollution control equipment. It is intended for use by personnel including architect-engineers, designers, fabricators, and personnel from electric utilities.

This standard was originally prepared in 1999 by NACE Task Group T-5F-6, a component of Unit Committee T-5F, “Corrosion Problems Associated with Pollution Control.” It was revised in 2004, 2009, and 2018 by Task Group (TG) 199, “Stainless Chromium-Nickel Steel and Nickel-Alloy Roll-Bonded and Explosion-Bonded Clad Plate for Air Pollution Control Equipment, Installation: Review of NACE SP0199.” TG 199 is administered by Specific Technology Group (STG) 45, “Pollution Control, Waste Incineration, and Process Waste.” This standard is issued by NACE International under the auspices of STG 45.

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