

	Tech Gram NDT For Scotch Marine Boiler Flush Patch	Implementation Date	04/04/2025
		Last Reviewed/Update Date	04/04/2025
		SOP Owner	Chief Boiler Inspector

BOILER TECHNICAL GRAM

Number: 2025-01

Date: 04 April 2025

To: Authorized Inspection Agencies (AIAs)
Texas In-Service Commissioned Deputy Boiler Inspectors (DBIs)

From: Office of the Chief Boiler Inspector
Texas Department of Licensing and Regulation (TDLR), Compliance Division, Building Safety, Boiler Program

Subject: Required NDE for Scotch Marine Boilers
installing a flush patch to tube sheet

References: Texas Boiler Law and Rules: 65.612 Enforcement of Rules for Repairs and Alterations.

Purpose: When repairing Scotch Marine Boiler Firetubes normal procedures are to cut a hole in the tubesheet just large enough to remove the old boiler tube from the boiler. This tech gram is specifically for use only when repairing the hole in the tubesheet.

Applicability: All active boilers.

Texas Administrative Code, Ch 65 Boilers, §65.612 (a) states:

The Nondestructive Testing (NDT) for the flush patch installation weld area shall follow the requirements of the original code of construction Per the National Board Inspection code Part 3. Where this is not practicable Progressive Liquid Penetrant (PT) (PT performed after each weld pass) in lieu of Volumetric NDT shall be required by the Jurisdiction.

Questions regarding this Technical Gram should be addressed to the Chief Boiler Inspector or an Inspection Specialist.

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Sincerely,

A handwritten signature in blue ink, appearing to read "R. D. Troutt", with a stylized flourish at the end.

Robby D. Troutt
Chief Boiler Inspector
TDLR – Boiler Program