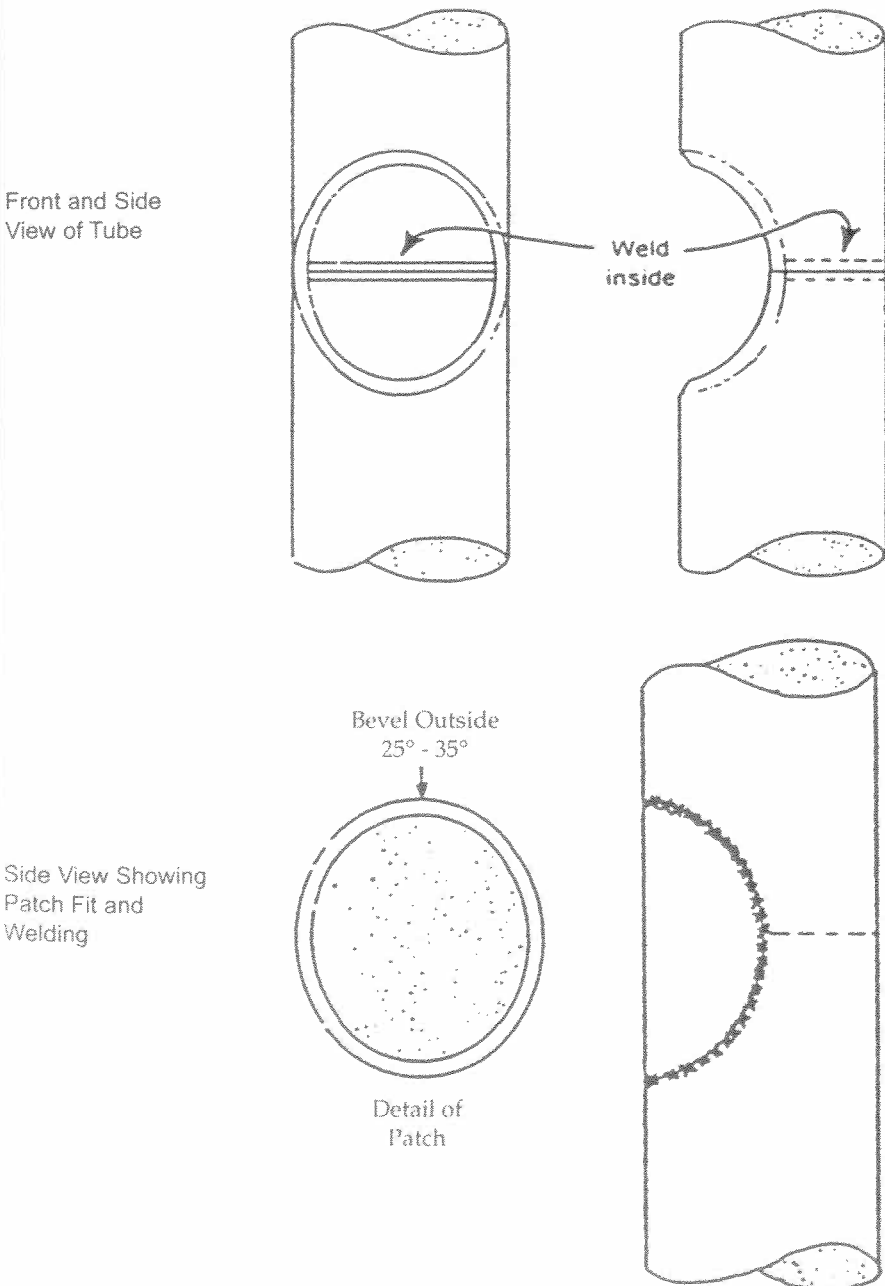


**FIGURE 3.3.4.6-b**

**Tube Window Patching Method**

It may be necessary to weld a flush patch on a tube since, in some situations, accessibility around the complete circumference of the tube is restricted. Listed below are the suggested methods for making window patches:

- a) The patch should be made from tube material of the same type, diameter, and thickness as the one being repaired.
- b) Fit-up of the patch is important to weld integrity. The root opening should be uniform around the patch.
- c) The gas tungsten-arc welding process should be used for the initial pass on the inside of the tube and for the initial pass joining the patch to the tube.
- d) The balance of the weld may be completed by any appropriate welding process.



SECTION 3