

# **AFCEN RCC-M Errata 006 – EN**

**January 2025**

**afcen**

AFCEN

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## AFCEN RCC-M Errata 006

### NOTE TO USERS

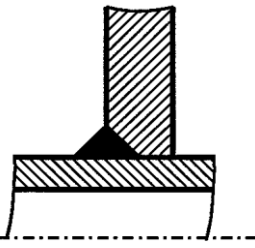
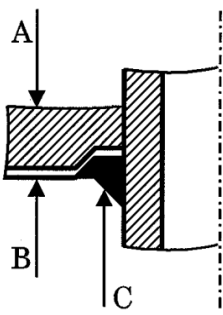
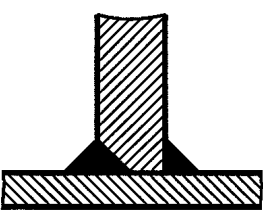
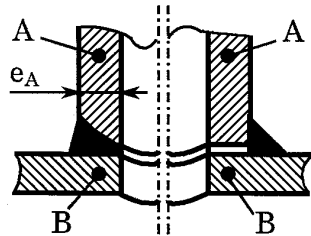
This document provides the corrections described in the table below, affecting the code editions, versions and paragraphs mentioned.

Code edition(s)	Version(s)	Errata description	Paragraph(s)
2016, 2017, 2018	French, English	<i>NDE of temporary attachment welds : Correction of an error introduced in the 2016 edition for class 1 and 2 equipment; the rows in the "general requirements" table dealing with pre/post welding examination were mistakenly deleted in the 2016 edition</i>	<i>Table S 7710.1, table S 7720.1</i>

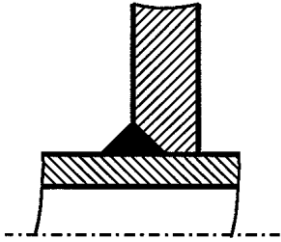
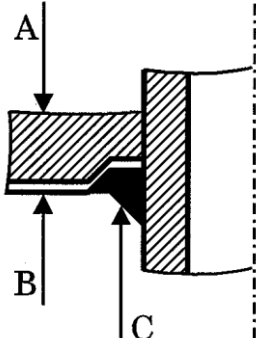
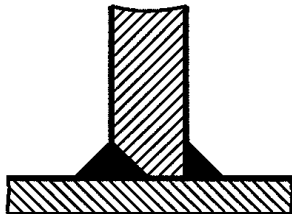
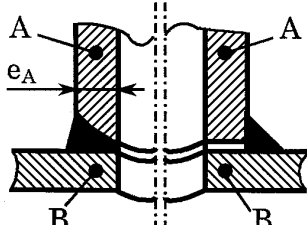
Modified pages are presented in chronological order for 2016, 2017 and 2018 editions.

Modified parts of text appear in red.

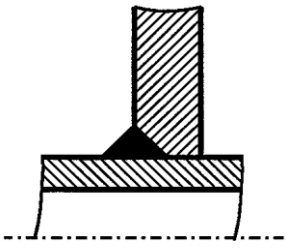
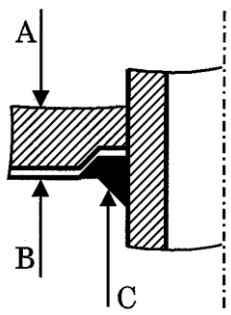
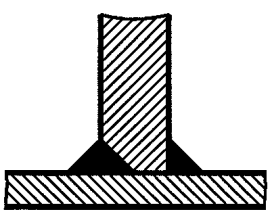
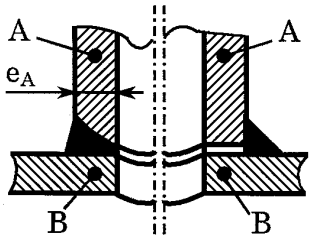
**TABLE S 7710.1**  
**GENERAL REQUIREMENTS**

TYPE	EXAMINATION ON SURFACES TO BE WELDED			
	AUSTENITIC FERRITIC	→ →	Non-destructive examination	Criteria
<b>3 : PARTIAL PENETRATION FILLET WELD</b> 3.1 Général case  (as per B 3353.3)	All thicknesses	x	RES or MAG RES	S 7363 S 7363
3.2 (with buttering for dissimilar metal joint) 	BUTTERING B Examination of spot facing on part (A) before buttering (B)	x	RES or MAG	S 7363
	WELD C Examination before welding (C) on finished buttering (B)	x	RES	S 7714.1
3.3 Minor permanent attachment  (Suivant B 3354)	All thicknesses	x	RES or MAG RES	S 7363 S 7363
<b>4 : TEMPORARY ATTACHMENTS</b> 	On part A ( $e_A \geq 10$ mm)	x	RES or MAG RES	S 7363 S 7363
	On part B (required only for handling attachments)	x	RES or MAG RES	S 7363 S 7363

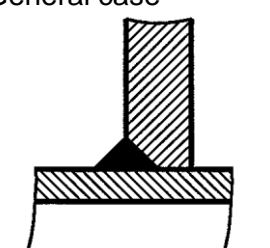
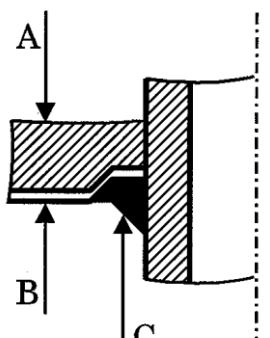
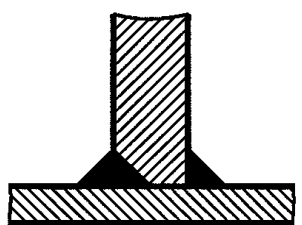
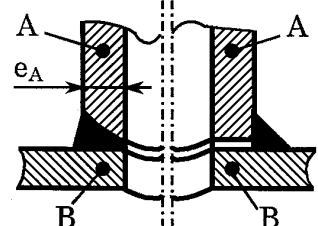
**TABLE S 7710.1 (cont. 2)**  
**GENERAL REQUIREMENTS**

TYPE	EXAMINATION AFTER WELDING				
	AUSTENITIC FERRITIC	→ →	<div><div></div><div>X</div></div> <div><div></div><div>X</div></div>	Non-destructive examination	Criteria
3 : PARTIAL PENETRATION FILLET WELD			X	MAG or RES (if MAG cannot be performed)	S 7714.2 S 7714.1
3.1 General case			X	RAD*	S 7714.3
(as per B 3353.3)			X	RES	S 7714.1
			X	RAD*	S 7714.3
3.2 (with buttering for dissimilar joint)		On finished buttering (B) before welding (C)	X	RES	S 7714.1
		If UT cannot be performed : inside surface of hole after drilling to defined diameter on buttering base metal weld junction	X	US	S 7714.4
			X	RES	S 7714.1
		On finished weld (C)	X	RES	S 7714.1
			X	RAD*	S 7714.3
* If RAD cannot be performed, carry out US If neither RAD or US can be performed, see « Examination during operation »					
3.3 Minor permanent attachment			X	MAG or RES (if MAG cannot be performed)	S 7714.2 S 7714.1
(Suivant B 3354)			X	RES	S 7714.1
4 : TEMPORARY ATTACHMENTS		On part B after elimination and surface finishing	X	MAG	S 7714.2
			X	US (5)	See TOME II S 7714.1
			X	RES	
			X	US (5)	See TOME II

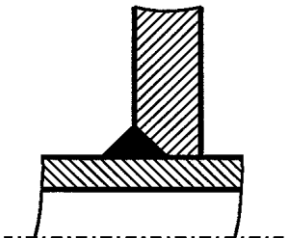
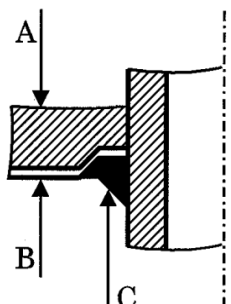
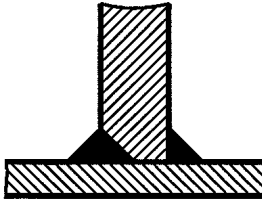
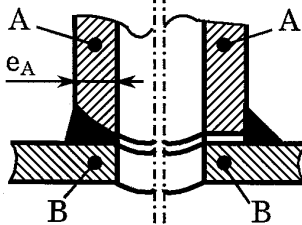
**TABLE S 7720.1**  
**GENERAL REQUIREMENTS**

TYPE	EXAMINATION ON SURFACES TO BE WELDED			
	AUSTENITIC $\longrightarrow$ FERRITIC $\longrightarrow$	<div style="border: 1px solid black; padding: 2px; display: inline-block;"> <b>X</b> </div>	Non-destructive examination	Criteria
3 : PARTIAL PENETRATION FILLET WELD 3.1 Général case  (as per C 3353.3)	All thicknesses	<div style="border: 1px solid black; padding: 2px; display: inline-block;"> <b>x</b> </div>	<div style="border: 1px solid black; padding: 2px; display: inline-block;"> <b>x</b> </div>	RES S 7363
3.2 (with buttering for dissimilar metal joint) 	BUTTERING B  Examination of spot facing on part (A) before buttering (B)	<div style="border: 1px solid black; padding: 2px; display: inline-block;"> <b>x</b> </div>	RES or MAG	S 7363
	WELD C  Examination before welding (C) on finished buttering (B)	<div style="border: 1px solid black; padding: 2px; display: inline-block;"> <b>x</b> </div>	RES	S 7724.1
3.3 Minor permanent attachment  (Suivant C 3354)	All thicknesses	<div style="border: 1px solid black; padding: 2px; display: inline-block;"> <b>x</b> </div>	<div style="border: 1px solid black; padding: 2px; display: inline-block;"> <b>x</b> </div>	RES S 7363
4 : TEMPORARY ATTACHMENTS 	On part A  On part B (required only for handling attachments)	<div style="border: 1px solid black; padding: 2px; display: inline-block;"> <b>x</b> </div>	<div style="border: 1px solid black; padding: 2px; display: inline-block;"> <b>x</b> </div>	WITHOUT  RES or MAG RES S 7363 S 7363

**TABLE S 7720.1 (cont. 2)**  
**GENERAL REQUIREMENTS**

TYPE	EXAMINATION AFTER WELDING			
	AUSTENITIC FERRITIC	→ →	X X	Non-destructive examination Criteria
<b>3 : PARTIAL PENETRATION FILLET WELD</b>  3.1 General case  (as per C 3353.3)			x x	RES RAD* S 7724.1 S 7724.3
3.2 (with buttering for dissimilar joint) 	On finished buttering (B) before welding (C)  If US cannot be performed : inside surface of hole after drilling to defined diameter on buttering base metal weld junction		x x x	RES US RES S 7724.1 S 7724.4 S 7724.1
	On finished weld (C)		x x	RES RAD * S 7724.1 S 7724.3
	* If RT cannot be performed, carry out US If neither RES or US can be performed, see « Examination during operation »			
3.3 Minor permanent attachment  (Suivant B 3354)			x x	RES S 7724.1
<b>4 : TEMPORARY ATTACHMENTS</b> 	On part B after removal and restoration of initial surface condition		x x x x	RES or MAG US (4) RES US (4) S 7724.1 S 7724.2 See TOME II S 7724.1 See TOME II

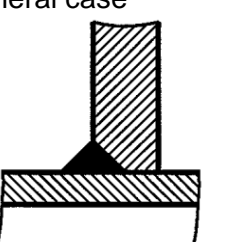
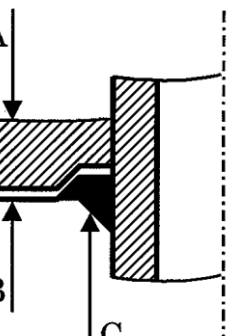
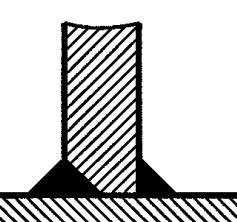
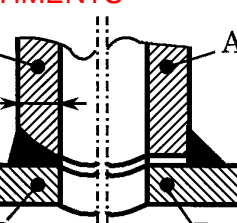
**TABLE S 7710.1**  
**GENERAL REQUIREMENTS**

TYPE	EXAMINATION ON SURFACES TO BE WELDED			
	AUSTENITIC → FERRITIC →	x x	Non-destructive examination RES or MAG RES	Criteria
<b>3 : PARTIAL PENETRATION FILLET WELD</b> 3.1 Général case  (as per B 3353.3)	All thicknesses	x	x	RES or MAG RES S 7363 S 7363
3.2 (with buttering for dissimilar metal joint) 	<b>BUTTERING B</b>  Examination of spot facing on part (A) before buttering (B)	x		RES or MAG S 7363
	<b>WELD C</b>  Examination before welding (C) on finished buttering (B)		x	RES S 7714.1
<b>3.3 Minor permanent attachment</b>  (Suiwant B 3354)	All thicknesses	x	x	RES or MAG RES S 7363 S 7363
<b>4 : TEMPORARY ATTACHMENTS</b> 	On part A ( $e_A \geq 10$ mm)	x	x	RES or MAG RES S 7363 S 7363
	On part B (required only for handling attachments)	x	x	RES or MAG RES S 7363 S 7363

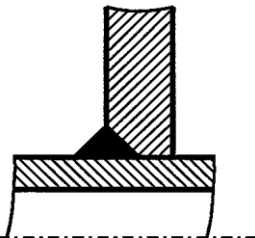
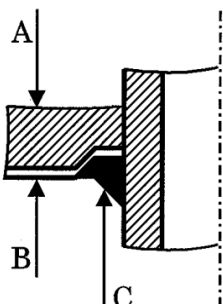
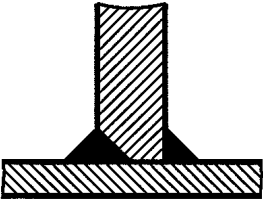
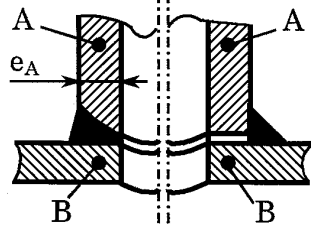


**TABLE S 7710.1 (cont. 2)**

**GENERAL REQUIREMENTS**

TYPE	EXAMINATION AFTER WELDING				
	AUSTENITIC FERRITIC	→ →	x x	Non-destructive examination	Criteria
3 : PARTIAL PENETRATION FILLET WELD  3.1 General case    (as per B 3353.3)			x	MAG or RES (if MAG cannot be performed)  RAD*  RES  RAD*	S 7714.2 S 7714.1  S 7714.3  S 7714.1 S 7714.3
3.2 (with buttering for dissimilar joint)  	On finished buttering (B) before welding (C)  If UT cannot be performed : inside surface of hole after drilling to defined diameter on buttering base metal weld junction		x x x	RES  US  RES	S 7714.1  S 7714.4 S 7714.1
	On finished weld (C)		x x	RES RAD*	S 7714.1 S 7714.3
	* If RAD cannot be performed, carry out US If neither RAD or US can be performed, see « Examination during operation »				
3.3 Minor permanent attachment    (Suivant B 3354)			x	MAG or RES (if MAG cannot be performed)  RES	S 7714.2 S 7714.1  S 7714.1
4 : TEMPORARY ATTACHMENTS  	On part B after elimination and surface finishing	x x	x x x x	MAG  US (5)  RES  US (5)	S 7714.2  See TOME II S 7714.1  See TOME II

**TABLE S 7720.1**  
**GENERAL REQUIREMENTS**

TYPE	EXAMINATION ON SURFACES TO BE WELDED				Criteria
	AUSTENITIC FERRITIC	→ →	X X	Non-destructive examination	
3 : PARTIAL PENETRATION FILLET WELD 3.1 General case  (as per C 3353.3)	All thicknesses		x	RES	S 7363
3.2 (with buttering for dissimilar metal joint) 	BUTTERING B Examination of spot facing on part (A) before buttering (B)		x	RES or MAG	S 7363
	WELD C Examination before welding (C) on finished buttering (B)		x	RES	S 7724.1
3.3 Minor permanent attachment  (as per C 3354)	All thicknesses		x	RES	S 7363
<b>4 : TEMPORARY ATTACHMENTS</b> 	On part A			WITHOUT	
	On part B (required only for handling attachments)		x	RES or MAG RES	S 7363 S 7363

**TABLE S 7720.1 (cont. 2)**  
**GENERAL REQUIREMENTS**

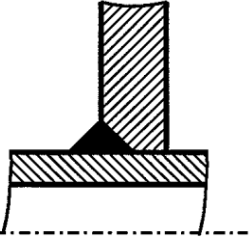
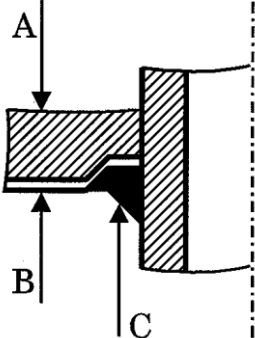
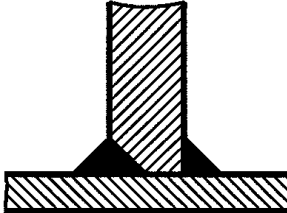
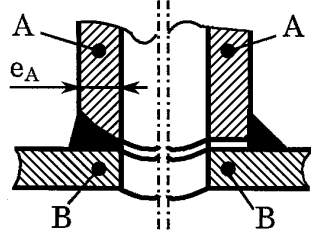
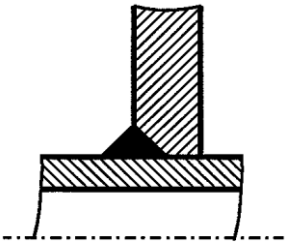
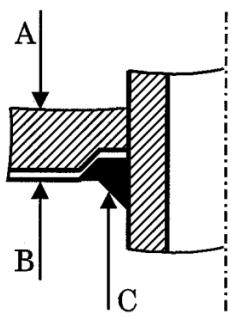
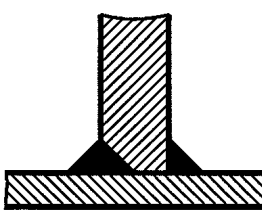
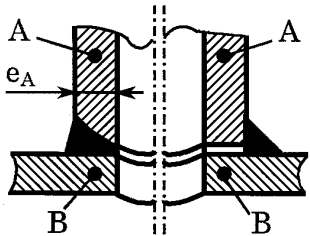
TYPE	EXAMINATION AFTER WELDING				
	AUSTENITIC FERRITIC	→ →	x x	Non- destructive examination	Criteria
<b>3 : PARTIAL PENETRATION FILLET WELD</b>  3.1 General case  (as per C 3353.3)			x	RES RAD*	S 7724.1 S 7724.3
3.2 (with buttering for dissimilar joint) 	On finished buttering (B) before welding (C)  If US cannot be performed : inside surface of hole after drilling to defined diameter on buttering base metal weld junction		x	RES US RES	S 7724.1 S 7724.4 S 7724.1
	On finished weld (C)		x	RES RAD *	S 7724.1 S 7724.3
* If RAD cannot be performed, carry out US If neither RES or US can be performed, see « Examination during operation »					
3.3 Minor permanent attachment  (as per B 3354)			x	RES	S 7724.1
<b>4 : TEMPORARY ATTACHMENTS</b> 	On part B after removal and restoration of initial surface condition		x	RES or MAG US (4) RES US (4)	S 7724.1 S 7724.2 See TOME II S 7724.1 See TOME II

TABLE S 7710.1

## GENERAL REQUIREMENTS

TYPE	EXAMINATION ON SURFACES TO BE WELDED			
	AUSTENITIC FERRITIC	→ →	X X	Non-destructive examination Criteria
3 : PARTIAL PENETRATION FILLET WELD 3.1 Général case  (as per B 3353.3)	All thicknesses		x x	PT or MT PT S 7363 S 7363
3.2 (with buttering for dissimilar metal joint) 	BUTTERING B Examination of spot facing on part (A) before buttering (B)		x	PT or MT S 7363
	WELD C Examination before welding (C) on finished buttering (B)		x	PT S 7714.1
3.3 Minor permanent attachment  (Suivant B 3354)	All thicknesses		x x	PT or MT PT S 7363 S 7363
4 : TEMPORARY ATTACHMENTS 	On part A ( $e_A \geq 10$ mm)		x x	PT or MT PT S 7363 S 7363
	On part B (required only for handling attachments)		x x	PT or MT PT S 7363 S 7363

**TABLE S 7710.1 (cont. 2)**  
**GENERAL REQUIREMENTS**

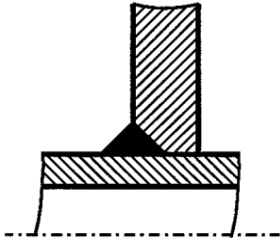
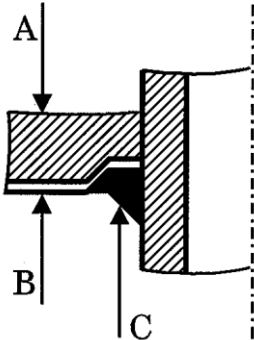
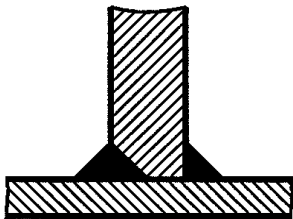
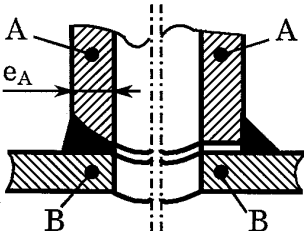
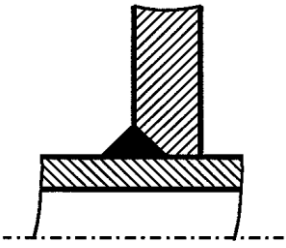
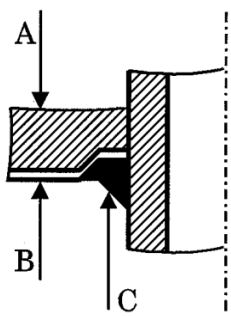
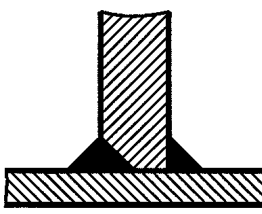
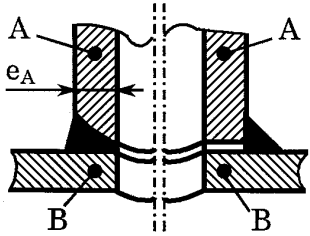
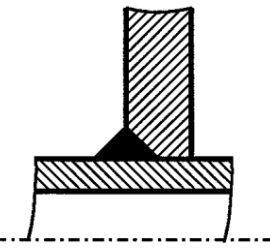
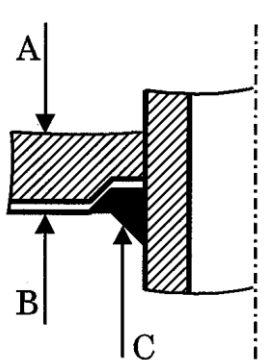
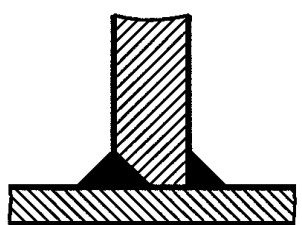
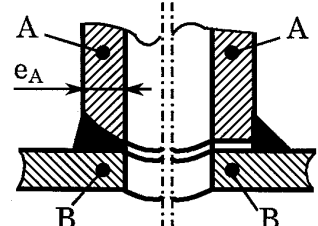
TYPE	EXAMINATION AFTER WELDING				
	AUSTENITIC FERRITIC	→ →	x x	Non-destructive examination	Criteria
3 : PARTIAL PENETRATION FILLET WELD  3.1 General case    (as per B 3353.3)			x	MT or PT (if MT cannot be performed)  RT*  x PT  RT*	S 7714.2 S 7714.1  S 7714.3  S 7714.1 S 7714.3
3.2 (with buttering for dissimilar joint)  	On finished buttering (B) before welding (C)		x x x	PT UT PT	S 7714.1 S 7714.4 S 7714.1
	If UT cannot be performed : inside surface of hole after drilling to defined diameter on buttering base metal weld junction				
	On finished weld (C)		x x	PT RT*	S 7714.1 S 7714.3
* If RT cannot be performed, carry out UT If neither RT or UT can be performed, see « Examination during operation »					
3.3 Minor permanent attachment    (Suivant B 3354)			x	MT ou PT (if MT cannot be performed)  x PT	S 7714.2 S 7714.1  S 7714.1
4 : TEMPORARY ATTACHMENTS  	On part B after elimination and surface finishing	x x	x x x x	MT UT (5) PT UT (5)	S 7714.2  See TOME II S 7714.1  See TOME II

TABLE S 7720.1

## GENERAL REQUIREMENTS

TYPE	EXAMINATION ON SURFACES TO BE WELDED			
	AUSTENITIC FERRITIC	→ →	X X	Non-destructive examination Criteria
3 : PARTIAL PENETRATION FILLET WELD 3.1 Général case  (as per C 3353.3)	All thicknesses		x x	PT S 7363
3.2 (with buttering for dissimilar metal joint) 	BUTTERING B Examination of spot facing on part (A) before buttering (B)		x	PT or MT S 7363
	WELD C Examination before welding (C) on finished buttering (B)		x	PT S 7724.1
3.3 Minor permanent attachment  (as per C 3354)	All thicknesses		x x	PT S 7363
4 : TEMPORARY ATTACHMENTS 	On part A On part B (required only for handling attachments)		x x	WITHOUT PT or MT PT S 7363 S 7363

**TABLE S 7720.1 (cont. 2)**  
**GENERAL REQUIREMENTS**

TYPE	EXAMINATION AFTER WELDING			
	AUSTENITIC FERRITIC	→ →	X X	Non-destructive examination Criteria
<b>3 : PARTIAL PENETRATION FILLET WELD</b> 3.1 General case  (as per C 3353.3)			x x PT RT*	S 7724.1 S 7724.3
3.2 (with buttering for dissimilar joint) 	On finished buttering (B) before welding (C)  If UT cannot be performed : inside surface of hole after drilling to defined diameter on buttering base metal weld junction		x PT x UT x PT	S 7724.1 S 7724.4 S 7724.1
	On finished weld (C)		x PT x RT*	S 7724.1 S 7724.3
* If RT cannot be performed, carry out UT If neither RT or UT can be performed, see « Examination during operation »				
3.3 Minor permanent attachment  (Suivant B 3354)			x x PT	S 7724.1
<b>4 : TEMPORARY ATTACHMENTS</b> 	On part B after elimination and surface finishing	x x x x	PT or MT UT (4) PT UT (4)	S 7724.1 S 7724.2 See TOME II S 7724.1 See TOME II