

Attachment #3/11-1

NB11-1802

Existing Section, Part 3, S1.2.12.1

S1.2.12.1 CAULKING RIVETED SEAMS AND RIVET HEADS (SEE FIGURE S1.2.12.1)

a) Caulking refers to the sealing of plate seams and rivet heads by driving the edge of one surface onto the other by use of an impact tool.

b) Riveted seams and rivet heads may be caulked in accordance with ASME Code Section I, 1971.¹⁴

¹⁴ This Code is available from the National Board.

Revision of NBIC Part 3, S1.2.12.1

S1.2.12.1 CAULKING, REPAIR AND INSTALLATION OF RIVETS AND RIVETED SEAMS (SEE FIGURE S1.2.12.1)

- a) Replacement rivets shall have heads of sufficient size to conform to Part 2, S1.4.2.1 (I). Changing the rivet head style at either end shall be considered a repair, changing the rivet body diameter, or changing the rivet hole diameter shall be an alteration.
- b) Rivet heads shall completely cover the perimeter of the hole in the plate or entirely fill the countersink.
- c) During driving of rivets, where the factory head moves away from the sheet because of insufficient bucking, such rivets shall be removed and discarded.
- d) Rivets shall be heated sufficiently to be driven completely with the equipment being used.
- e) Reheating of rivets above 600 degrees F after the original installation is prohibited. When seal welding rivet heads, inter or post-pass head temperature shall be kept below 600 degrees F.
- f) Each rivet head shall contact the plate over the entire circumference upon completion of the installation. Rivets on which either head does not have contact with the plate over the entire area of the driven head, not including any excess washer (excess material at the base of the rivet head), shall be replaced. Repair is prohibited.
- g) Caulking refers to the sealing of plate seams and rivet heads by driving the edge of one surface onto the other by use of an impact tool.
- h) Caulked rivet seams and rivet heads shall be in accordance with ASME Code Section I, Part PR, 1971.¹⁴

¹⁴ This Code is available from the National Board.