



RUSSIAN MARITIME REGISTER OF SHIPPING

CIRCULAR LETTER

No. 311-05-1935c

dated 22.05.2023

Re:

amendments to the Rules for the Classification and Construction of Sea-Going Ships, 2023, ND No. 2-020101-174-E

Item(s) of supervision:

materials and welding

Entry-into-force date:

01.07.2023

~~Cancels / amends / adds Circular Letter No.~~

~~dated~~

Number of pages: 1 + 2

Appendices:

Appendix 1: information on amendments introduced by the Circular Letter

Appendix 2: text of amendments to Parts XIII "Materials" and XIV "Welding"

Acting Director General

Andrey V. Fasolko

Text of CL:

We hereby inform that the Rules for the Classification and Construction of Sea-Going Ships shall be amended as specified in the Appendices to the Circular Letter.

It is necessary to do the following:

1. Bring the content of the Circular Letter to the notice of the RS surveyors, as well as interested organizations and persons in the area of the RS Branch Offices' activity.
 2. Apply the provisions of the Circular Letter when performing technical supervision of materials and compliance with welding procedures on ships contracted for construction or conversion on or after 01.07.2023, in the absence of a ship's data, during review of technical documentation requested for review on or after 01.07.2023.
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List of the amended and/or introduced paras/chapters/sections:

Rules for the Classification and Construction of Sea-Going Ships:

Part XIII: paras 6.5.1.4 — 6.5.1.7

Part XIV: para 2.1.4.2

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**Information on amendments introduced by the Circular Letter
(for inclusion in the Revision History to the RS Publication)**

Nos.	Amended paras/chapters/ sections	Information on amendments	Number and date of the Circular Letter	Entry-into-force date
1	Part XIII, paras 6.5.1.4 — 6.5.1.7	Para 6.5.1.4 has been deleted; existing paras 6.5.1.5 — 6.5.1.7 have been renumbered 6.5.1.4 — 6.5.1.6 accordingly	311-05-1935c of 22.05.2023	01.07.2023
2	Part XIV, para 2.1.4.2	Requirements for ambient temperature at which edges of parts to be welded shall be preheated have been specified	311-05-1935c of 22.05.2023	01.07.2023

RULES FOR THE CLASSIFICATION AND CONSTRUCTION OF SEA-GOING SHIPS, 2023,

ND No. 2-020101-174-E

PART XIII. MATERIALS

6 PLASTICS AND MATERIALS OF ORGANIC ORIGIN

1 **Para 6.5.1.4** is deleted. Existing paras **6.5.1.5 — 6.5.1.7** are renumbered **6.5.1.4 — 6.5.1.6** accordingly.

PART XIV. WELDING

2 TECHNOLOGICAL REQUIREMENTS FOR WELDING

2 **Para 2.1.4.2** is replaced by the following text:

"2.1.4.2 On condition proper quality of welded joints is ensured, welding and all related operations on the structures subject to technical supervision by the Register made of hull structural steel of normal and higher strength 20 mm in thickness are generally permitted at ambient temperature up to $-25\text{ }^{\circ}\text{C}$. For specific conditions, the minimum permissible ambient temperature for unheated welding shall be agreed with the Register at approving welding procedures. Preheating of the edges of parts to be welded shall be carried out at ambient temperature below $-5\text{ }^{\circ}\text{C}$ for normal strength steels and below $0\text{ }^{\circ}\text{C}$ for higher strength steels. For high strength steels, preheating of the edges of parts to be welded shall be carried out at ambient temperature specified in Table 6.4.4.8.3, Part III "Technical Supervision during Manufacture of Materials" of the Rules for Technical Supervision during Construction of Ships and Manufacture of Materials and Products for Ships.

For steel forgings and castings of the ship hull, welding may, as a rule, be carried out at the ambient temperature up to $-15\text{ }^{\circ}\text{C}$.

The edges of parts to be welded shall be preheated at least to $20\text{ }^{\circ}\text{C}$ over a width of 100 mm to both sides of the weld.

To be preheated is the side of the joint to be welded first.

If during welding the ambient temperature drops below the minimum permissible value, the welding shall be stopped after filling in the groove on one side of the joint and making the back sealing run or the first run on the other side. Prior to welding renewal after the stop, reheating or redrying of the edges shall be performed, where necessary."