



R-Stamp Compliance & Pressure Vessel Pre-Audit Checklist

Phase 1: Documentation & Certification

- Quality Control Manual:** Verify that your manual is up-to-date and signed by the current Quality Control Manager.
- Weld Procedure Specifications (WPS):** Confirm that all welding procedures are properly qualified and documented.
- Welder Performance Qualification (WPQ):** Check that every technician is certified for the specific processes and positions required for the repair.
- Material Test Reports (MTRs):** Track all materials back to their origin to ensure they meet ASME specifications.

Phase 2: Material Control & Traceability

- Heat Number Traceability:** Ensure heat numbers are clearly visible on all plates, pipes, and fittings.
- Segregation of Materials:** Clearly separate non-compliant or scrap materials from code-approved stock to avoid cross-contamination.
- Precision Preparation:** Use high-quality cutting methods to prepare materials without creating large heat-affected zones.
- Filler Metal Control:** Store welding electrodes in ovens at the correct temperature to prevent moisture contamination.



Phase 3: Physical Inspection & Welding

- Calibration Logs:** Confirm that all welding machines and pressure gauges have current calibration tags.
- In-Process Inspection:** Document the required hold points where a Quality Control Manager or Authorized Inspector (AI) must sign off.
- Non-Destructive Examination (NDE):** Ensure all required X-ray or ultrasonic testing reports are organized and ready for review.
- Safe Access:** Provide the inspector with stable and safe access to every weld being reviewed.

Phase 4: Final AI Review & Form Completion

- "R" Form Accuracy:** Double-check that the description of work on the form matches the physical repair exactly.
- Hydrostatic Testing:** Ensure testing equipment is calibrated and all test parameters are documented.
- National Board Coordination:** Ensure all repairs are registered correctly to maintain R-Stamp compliance across your fleet.
- Operational Integration:** Ensure the final product integrates seamlessly with existing infrastructure and meets all design pressure requirements.