

## Department of Industrial Relations

Division of Occupational Safety and Health

## PRESSURE VESSEL UNIT

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Friday, March 21, 2008

Circular Letter PV-2004-1

Effective Date June 1, 2004

Subject: ASME Part UHX

To: All Parties Fabricating, Inspecting, Repairing, and Purchasing ASME Code Stamp Heat Exchangers

Changes have taken place in the ASME Code Section VIII 2001 Edition 2003 Addenda that affect the design of heat exchangers. This is the addition of Part UHX, Rules for Shell and Tube Heat Exchangers, the primary effect being that tubesheets will now only be designed per ASME rules and the use of TEMA design rules are no longer acceptable. Questions have been raised as to how to fabricate new heat exchangers; new parts of heat exchangers; and how to repair existing heat exchangers. This circular letter will provide instructions on how to handle these situations.

1. The use of Code Case 2429 is acceptable, providing all conditions contained in the code case and Part UHX are complied with. The code case shall be indicated on the Manufacturer's Data Report.
2. ASME Code stamped complete heat exchangers or ASME Code stamped parts of a heat exchanger, built under a purchase contract issued in 2004, shall be fabricated in accordance with the requirements of the new Part UHX unless the Code Case is complied with and listed on the Manufacturer's Data Report.
3. ASME Code stamped complete heat exchangers or ASME Code stamped parts of a heat exchanger, built under a purchase contract issued after January 1, 2005, shall be fabricated in accordance with the requirements of the new Part UHX.
4. For a welded repair, a single National Board 'R' Stamp holder may repair an existing heat exchanger under the rules of the original code of construction (i.e. replace the tubesheet using TEMA design criteria) or the new ASME Code Part UHX. This 'R' Stamp holder must perform all fabrication and testing requirements in accordance with the NBIC, including the completion of the appropriate R Form. The 'R' Stamp holder is not allowed to fabricate a welded part and ship it for installation by others.

Please contact our office if you have any questions.

Sincerely,

*Original signed by Donald C. Cook*

Donald C. Cook  
Principal Safety Engineer