



Public Input No. 190-NFPA 99-2024 [Section No. 5.1.10.11.11.4]

5.1.10.11.11.4

The brazing procedure qualification record and the brazer performance qualification record shall document filler metal used, base metals, cleaning, joint clearance, overlap, internal purge gas and flow rate during brazing of coupon, ~~and absence of internal oxidation in the completed coupon.~~

Statement of Problem and Substantiation for Public Input

While there is a need to use nitrogen NF to prevent oxidation when brazing the pipe during installation, there is no need or benefit to requiring documentation showing an absence of oxidation in a brazing performance qualification record (BPQR). The BPQR is recording the skill and the ability of the brazer to satisfactorily braze a joint. This requirement prevents an individual who is a qualified brazer from having their BPQR's accepted if it does not show a lack of oxidation in a braze coupon.

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