

## Procedure for Obtaining an ASME “Code Stamp” or a National Board “R Stamp”

1. Determine which stamps will be needed over at least the next three years. ASME “Code” Stamps (PP, A, S, U, H, etc.) are required in most States to build NEW pressure vessels, boilers and to install some piping that comes directly off boilers. The National Board “R” stamp is required in some states to make repairs or alterations to EXISTING ASME “Code Stamped” pressure vessels, boilers and piping. The requirement to have an “R” stamp is becoming more commonplace each year. In addition, some owners and engineers require that contractors have “R” or other stamps to be eligible to do work for them. Companies that have “stamps” are recognized widely as those that are more capable and quality-oriented than companies that do not have “stamps.”
2. ASME Code Stamps cost approximately \$1600 each every three years, plus a shop or field survey (i.e. audit) every three years. An R Stamp costs approximately \$550 every three years, plus a shop or field site audit every three years. The direct audit cost is about \$5,000. If you get more than one stamp at the same time, only one audit is conducted. The Stamp fees and a retainer for the survey is payable in advance.
3. Obtain ASME “Code” stamp application forms from ASME Code Accreditation Department, Three Park Avenue, New York, New York 1001-5990 (212-591-8581) or at [www.asme.org](http://www.asme.org). Obtain “R” stamp application forms from the National Board of Boiler and Pressure Vessel Inspectors, 1055 Crupper Avenue, Columbus, Ohio (614-888-8320) or at [www.nationalboard.org](http://www.nationalboard.org). Complete and send in these forms along with the requested funds. Expect 8 to 12 weeks until the survey can occur.
4. If acquiring an “R” Stamp, obtain a copy of the National Board Inspection Code (NBIC) from National Board. If repairs are going to be made on ASME Code-Stamped tanks, boilers or piping, or if acquiring ASME “Code” Stamps, obtain the applicable Code books from ASME Publications Department (1-800-THE ASME) or at [www.asme.org](http://www.asme.org). See the attached list of required Code Sections for each Code stamp.
5. Contact an Authorized Inspection Agency and arrange a contract for their services. YOU MUST HAVE A CONTRACT IN FORCE BEFORE THE NATIONAL BOARD OR ASME WILL SCHEDULE THE SURVEY. A list of Inspection Agencies is posted on both the National Board and ASME web sites. One only pays for the services of the Inspection Agency as they are used, and their use is only required when manufacturing, erecting or repairing ASME Code-stamped items and during the survey
6. Prepare a Quality Control Program following the requirements of the National Board Inspection Code and/or ASME as applicable. Assistance in developing the QC Program and training in its implementation can be obtained from Sperko Engineering Services, Inc. (336-674-0600 or at [sperko@asme.org](mailto:sperko@asme.org))

Prepare and qualify welding procedures and welders. Prepare NDE procedures and qualify personnel in accordance with ASNT document SNT-TC-1A or make arrangements with an outside NDE laboratory.

Subcontracted services are acceptable for most specialized activities (e.g., design, drawings, NDE, heat treating) but not for welding. The Stamp holder is responsible for ALL work done, including any subcontractor work.

7. Have Authorized Inspection Agency review and concur with QC program. Prepare mock-up pipe/vessel or repair, as appropriate for the Stamp desired, following the QC program. Leave one major seam tacked but unwelded or as directed by the Authorized Inspector. Assistance with this is available from Sperko Engineering.
8. The Quality Control manual and its implementation will be audited by a Representative of the National Board of Boiler and Pressure Vessel Inspectors or Chief Inspector of the Local Jurisdiction and your Authorized Inspection Agency Supervisor and your Authorized Inspector.

First day - Review of QC program, Implementing QC procedures, welding and NDE procedures.

Second day - Shop inspection to verify implementation of program. Revisions to QC program.

When the audit is conducted by local jurisdiction, it may only take one day.

9. Audit team will advise towards the end of the second day in the exit interview whether your program passed or failed. . You may begin work with the concurrence of the Authorized Inspector after a successful survey, but you may not actually stamp anything until you receive the stamp from ASME or National Board, usually within a couple of weeks.

## Procedure for Obtaining an ASME “Code Stamp” or a National Board “R Stamp”

### TABLE OF POSSIBLE STAMPS

CODE SECTION	STAMP	ITEM
I	A	Assembly of Power Boilers
	S	Power Boilers
	M	Miniature Boilers
	E	Electric Boilers
	PP	Power Piping
	V	Boiler Safety Valves
III	N	Nuclear Components
	NA	Nuclear Shop Assembly and Installation
	NPT	Nuclear Parts
	NV	Nuclear Valves
IV	H	Heating Boilers
	HLW	Lined potable water heaters
VIII, Division 1	U	Pressure Vessels
	UM	Miniature Pressure Vessels
	UV	Pressure Vessel Safety Valves
VIII, Division 2	U2	Pressure Vessels
	U3	Pressure Vessels
VIII, Division 3	U3	Pressure Vessels
	RP	Fiberglass Reinforced Plastic Pressure Vessels
XI	RP	Fiberglass Reinforced Plastic Pressure Vessels
NATIONAL BOARD INSPECTION CODE	R	REPAIRS AND ALTERATIONS OF PREVIOUSLY ASME “CODE STAMPED” VESSELS, BOILERS AND PIPING