



PROCESS
INDUSTRY
PRACTICES

REAFFIRMATION
April 2023

Refractory

PIP RFTA1000
Refractory Anchor and Accessory Installation
Qualification, Inspection, and Testing

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PURPOSE AND USE OF PROCESS INDUSTRY PRACTICES

This Practice has been prepared by harmonizing technical requirements from existing standards of major industrial operators, contractors, and standard development organizations. While this Practice is intended to incorporate the majority of requirements, individual applications may have requirements which take precedence over this Practice. Determinations concerning fitness for purpose or application of this Practice to specific project or engineering situations should not be made solely on information contained in this Practice. All Practices are intended to be consistent with applicable laws and regulations. Should this Practice conflict with applicable laws or regulations, such laws or regulations must be followed. Consult an appropriate professional before applying or acting on any material contained in or suggested by this Practice.

Use of trade names should not be viewed as an expression of preference. Other brands having the same specifications are equally correct and may be substituted for those named.

This Practice is subject to revision at any time. For more information refer to PIP ADG001, *Specification for Developing Practices*.

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Data Form

RFTA 1000-F - Inspection Hold Point and
Sign-Off Schedule

1. Scope

This Practice provides requirements for quality control and quality assurance for the installation of refractory anchors and accessories including the requirements for inspection and testing of anchors and accessory materials, in-progress installation inspection, surface preparation, welding qualification, weld repair, and final inspection.

2. References

Applicable parts of the following Practices and industry codes and standards shall be considered an integral part of this Practice. The edition in effect on the date of contract award shall be used, except as otherwise noted. Short titles will be used herein when appropriate.

2.1 Process Industry Practices (PIP)

- PIP RFIA1000 - *Refractory Anchor and Accessory Installation Details*
- PIP RFSA1000 - *Refractory Anchor and Accessory Specification*
- PIP RFSB2000 - *Refractory Brick Installation Specification*
- PIP RFSF2000 - *Ceramic Fiber Refractory Installation Specification*
- PIP RFSM2000 - *Monolithic Refractory Installation Specification*

2.2 Industry Codes and Standards

- American Society of Mechanical Engineers (ASME)
 - ASME Boiler and Pressure Vessel Code, Section IX - *Welding, Brazing, and Fusing Qualification*
- ASTM International (ASTM)
 - ASTM C71 - *Standard Terminology Relating to Refractories*
- American Welding Society (AWS)
 - AWS D1.1 - *Structural Welding Code – Steel*
 - AWS D1.6 - *Structural Welding Code – Stainless Steel*

3. Definitions

With the exception of the terms listed in this section, terms used in this Practice are defined in accordance with *ASTM C71*. If a definition as used in this Practice differs from the one listed in the referenced documents, the modified definition is included in the following listing.

hold point: Installation is stopped until inspection occurs, and the hold is removed by installer's and purchaser's inspector.

installer: Party responsible for installing the refractory anchors and accessories. This includes each individual installer, who is prequalified before being allowed to install refractory anchors and accessories.