



# GENERAL SERVICE BULLETIN

## T-Bolt Hub Nut Mount & Tapped Swing Nut

90.10869 R0 October 7, 2022

**Closures Affected:** Certain T-Bolt Closures with carbon steel Hub Nut Mounts and Tapped Swing Nuts manufactured from July 10, 2017 to October 20, 2018 with a serial number starting with “BM.”

**Description of Issue:** ASME Section VIII Div. 1 Boiler and Pressure Vessel Code (Code) compliance

A limited number of T-Bolt Closures were observed to include Hub Nut Mounts with weld seams. Weld seams signal potential non-compliance of the Hub Nut Mounts to the Code material identified in the U-2A Partial Data Report previously provided to those affected customers.

An updated and corrected U-2A Partial Data Report is being issued to reflect the incorporation of alternate materials that are also Code compliant. The changes to the Partial Data Report include a reference to Code Case 3047 in section #5, and the Hub Nut Mount material identifier is updated to reflect “SA-106 Grade B, SA-53 Grade E/B, or Code Case 3047” in the Remarks section #14. If the vessel has been registered with the National Board of Boiler and Pressure Vessel Inspectors (National Board), customers may be required to submit a corrected U-1 or U-1A data report to the National Board.

Some closures were also discovered with Tapped Swing Nuts made from either AISI 1018 or 1045 materials instead of the specified Code compliant SA-193 Grade B7 material.

Replacement Tapped Swing Nuts will be sent to the customer to be installed at the next available opportunity. Replacement of the Tapped Swing Nuts is necessary to maintain Code compliance. The head bolt is to be removed from the Tapped Swing Nut before sliding the Tapped Swing Nut out of the Hub Nut Mounts per the included instructions which are also located at <https://www.tubeturns.com/servicebulletins>. The new Tapped Swing Nut is to be assembled to the closure by following the steps outlined in those instructions. For questions on the replacement process please contact 502-774-6249. The old Tapped Swing Nuts should be marked or tagged and discarded to prevent reuse.

Testing and analysis of these materials confirmed that they meet the design conditions as identified on the applicable purchase order or sales order.

