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API Publication 939-B, Repair and Remediation Strategies for Equipment Operating in Wet H₂S Service

This report summarizes the experimental methods and findings of a research program entitled *Repair and Remediation Strategies for Equipment Operating in Wet H₂S Service*, conducted by the Materials Properties Council, Inc. (MPC). The program was jointly funded by MPC and the API Committee on Refinery Equipment.

The overall goal of this project was to provide guidelines for effective repair procedures for use in remediation of equipment damaged in wet H₂S service and to minimize the reoccurrence of cracking after inspection and/or repair. These included specific aspects related to:

- The use of temper bead as opposed to conventional weld repairs.
- The postweld heat treatment (PWHT) versus as-welded.
- Local thin areas in the base metal and grooves in the heat-affected zone (HAZ) which result from removal of cracks found by inspection.
- Influence of blend grinding on internal fillet-welded attachments.
- Evaluation of surface treatments.
- Serviceability of pre-existing wet H₂S damage.

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