

875—91.7(89) Plugging boiler tubes. This rule does not apply to tubes in headers of economizers, evaporators, superheaters, or reheaters.

91.7(1) General requirements.

- a. Leaky tubes are replaced or plugged.
- b. Tube plugs are made of a material that is compatible with the material of the boiler tube being plugged and shall be welded into place or manufactured to be expanded into the tube sheet or drum.
- c. The maximum number of tubes that may be plugged shall be the lesser number specified by the OEM or an engineer experienced in boiler design.
- d. Documentation of the maximum number of tubes that may be plugged are kept on site, and a copy is supplied to the department by either mail or email.

91.7(2) Fire tube boilers.

- a. A tube that is adjacent to a plugged tube shall not be plugged.
- b. All plugged boiler tubes shall be replaced prior to the next required certificate inspection.

91.7(3) Water tube boilers, unfired boilers, or process steam generators. Water wall tubes that form a separation wall between products of combustion and the outside atmosphere or a separation of the gas passes in a multiple gas pass boiler shall not be plugged.

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