

**875—91.8(89) Plugging boiler tubes.** This rule does not apply to tubes in headers of economizers, evaporators, superheaters, or reheaters.

**91.8(1) General requirements.**

- a. Leaky tubes shall be replaced or plugged.
- b. Tube plugs shall be made of a material which 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 shall be kept on site, and a copy shall be supplied to the division of labor services by either mail or email.

**91.8(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.

**91.8(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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