

Global Standard	LESER Global Standard Marking of Safety Valves after Repair or 3rd party Assembly	LGS 2817
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1 Purpose

This LESER Global Standard (LGS) should establish a valid procedure for marking of repaired and 3rd party assembled LESER valves. Proper marking and identification of tested or repaired valves is critical to ensuring acceptance during subsequent inspections and ensures traceability and identification of any changes made to the valve. LESER requires that all repaired or tested valves are equipped with a repair tag / marking, if no other repair nameplates are required by the local code.

2 Scope

This LGS applies to all assembling sales partners, LARCs and independent workshops. The procedure described is similar to the requirements of NBIC 2015 Part 3, Section 5.

3 References

[LGS_0513_EN Approval of LARCs](#)

[LGS_3201_EN Nameplates](#)

4 Introduction

The following guideline details the procedure for marking of 3rd party assembled and repaired safety valves. LESER provides a unified layout for the nameplate and the repair tag and strongly recommends to use this layout. However, these are not supplied by LESER. The organization should source their own nameplates / tags with a similar “look and feel” based on the layout.

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resp. depart.:	QM	date of release:	04/19/20	revision No.:	0		
doc. type:	LGS	change rep.	NA	retention	10y.		

5 Design

5.1 Assembler nameplate

In the case of newly and loosely assembled valves, LESER demands that the original NGA (nameplate of global application) has to be removed and be replaced by an assembler nameplate. The new nameplate should be sourced by the assembling partner, but follow the LESER standard (it should have the original “look and feel”). Figure 1 provides the guideline for the nameplate (60 x 40 mm). Most information is copied from the original nameplate, except:

Mandatory information to be marked on the assembler nameplate:

- Assembler name preceded by the words “Assembled by” (17).
- The serial number must be extended by the respective abbreviation of the assembler to ensure a better tracking of the valves (4).
- A CE marking can remain on the nameplate, on the condition that the original valve was shipped with CE marking.

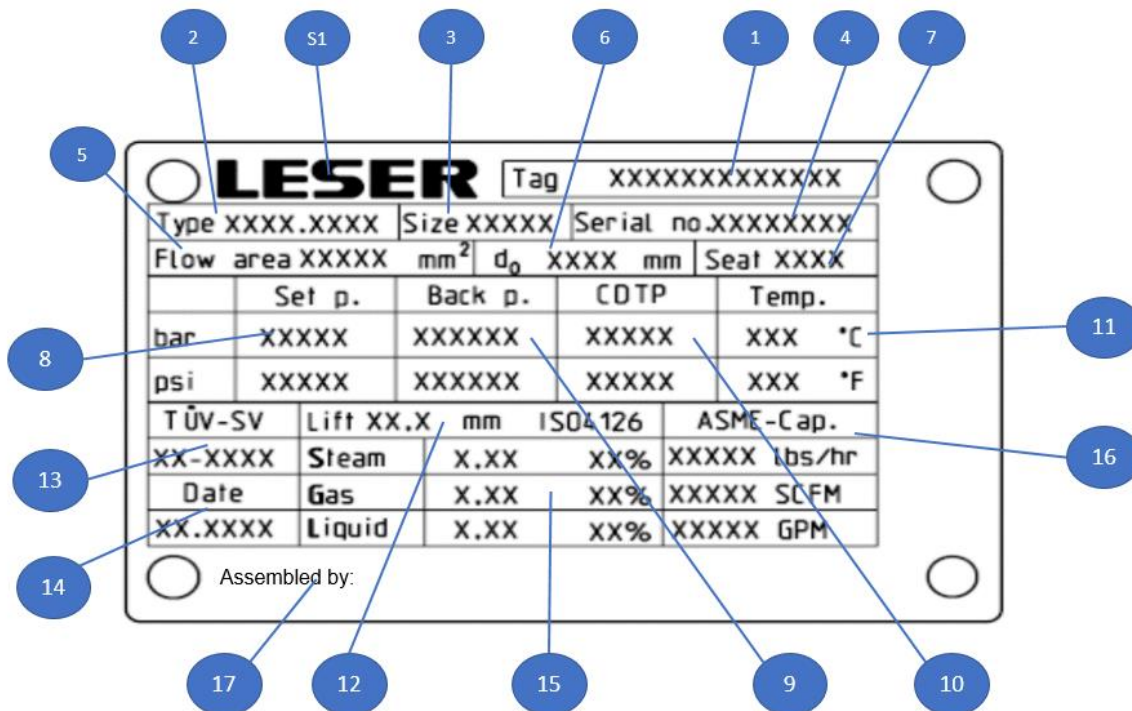


Figure 1: The LESER – Assembler nameplate

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No.	Field name		Example	Comment
S1	LESER		LESER	Name of Manufacturer
1	Tag			Additional marking of the valve (customer indication)
2	Type		4412.4514	Type designation of manufacturer (Article number specifies the safety valve)
3	Size		DN 25	Nominal size
4	Serial no.		10034748	Internal No. for identification of SV
5	Flow area		416 mm ²	Flow diameter in mm ²
6	do		23,0 mm	Flow diameter in mm
7	Seat		D J21	Identification of soft seal material Code letter O-ring disc + option code
8	Set p.	bar	10,00	Set pressure of valve in bar
		psig	145,04	Set pressure of valve in psig
9	Back p.	bar		Back pressure in bar
		psig		Back pressure in psig
10	CDTP	bar	10,00	Cold differential set pressure in bar (CDTP)
		psig	145,04	CDTP in psig
11	Temp.	°C	20,00	Temperature in °C
		°F	68	Temperatur ein °F
12	Lift -mm		x,xx	Smallest lift resp. reduced lift in mm with lift restriction
13	TÜV-SV		04-576	TÜEV-SV Number acc. to valid VdTÜV-Merkblatt + List number
14	Date		12.2006	Date of manufacture month/year
15	Medium	Steam	x,xx xx%	Allowable coefficient of discharge for steam + opening pressure difference in % resp. reduced coefficient of discharge in case of lift restriction / lift stopper
		Gas	x,xx xx%	Allowable coefficient of discharge (Kdr resp. αw) for gases + opening pressure difference in % resp. reduced coefficient of discharge in case of lift restriction / lift stopper
		Liquid	x,xx xx%	Allowable coefficient of discharge (Kdr resp. αw) for gases + opening pressure difference in % resp. reduced coefficient of discharge in case of lift restriction / lift stopper
16	ASME-Cap.	lbs/h	xxxx	Capacity for steam
		SCFM	xxxx	Capacity for gas
		GPM	xxxx	Capacity for liquids
Note: The marking is only allowed for the medium on which it has been tested.				
18			20009410/10 J78, J85	Indication only optional (OC: M16/M17) acc. to customer request. LESER-Job-No. + Pos.-No. Option code (e.g. bellows ...) In case of repair valves: repair order No. In case OC=N31 the OC=M16 is not possible
			xxxxxxx	M17-field is for subsidiary name resp. occupied by OC N73 (VR China) in SAP-Werk fix preset (e.g. LESER LLP Singapore)
17	Assembled by			
S2	CE		CE	CE-Marking
S3	0045		0045	Code number of responsible independent body.

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5.2 Repair Tag

For repairs and alteration a repair tag should be used in addition to the original nameplate. After a safety relief valve is maintained, a metallic repair tag should be securely attached to the valve (e.g. sealing wire or extra wire) without affecting its function. Before attaching the repair tag, any old repair tag must be removed from the valve.

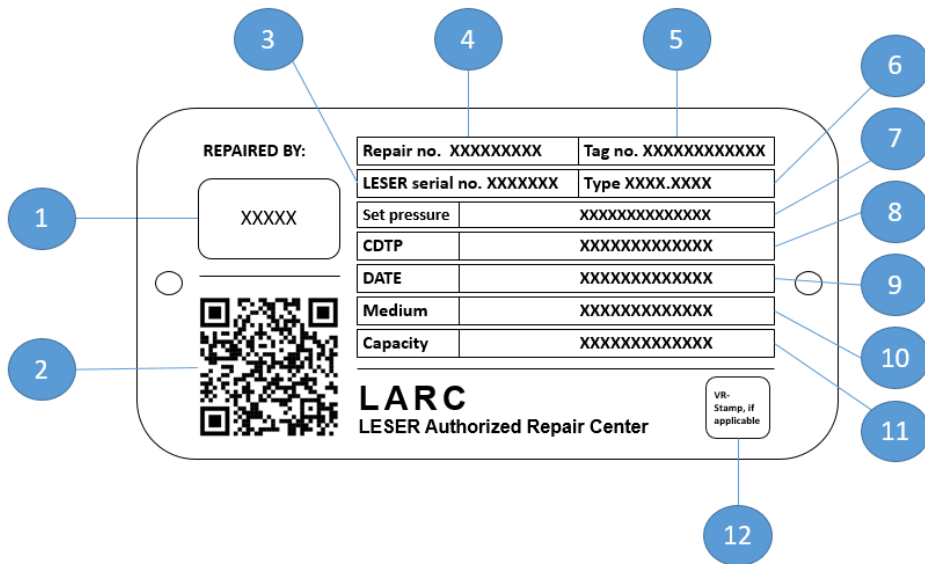


Figure II: LESER Repair tag : Dimension: 70 x 35 mm

1. The name of the repair organization preceded by the words “repaired by;”
2. (Optional) QR-Code leading to LARC website.
3. LESER serial no.
4. Unique identifier (repair no.)
5. Tag no. (if any)
6. Type/Model number
7. Set pressure
8. Cold Differential Test Pressure (CDTP)
9. Date of repair
10. Medium
11. Capacity
12. VR-Stamp, if applicable

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6 Alterations and Markings

Any change to a valve must be marked on the 3rd party nameplate or repair tag. Thereby it is important to distinguish between valves from stock and repaired valves. LESER describes the cases in which the information on the nameplate has to be changed in this chapter.

6.1 Valves from stock

For valves assembled from stock (e.g. loosely assembled valves or valves without stamped set pressure [L50]), a new assembler nameplate has to be attached to the valve before shipping. This is to clearly highlight (in addition to the seal) who set and tested the valve. Most information is copied from the original nameplate. However, the assembler has to make certain changes to ensure the traceability of the work done.

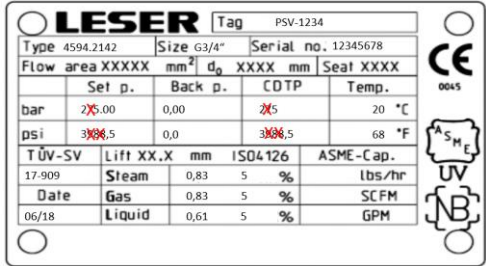
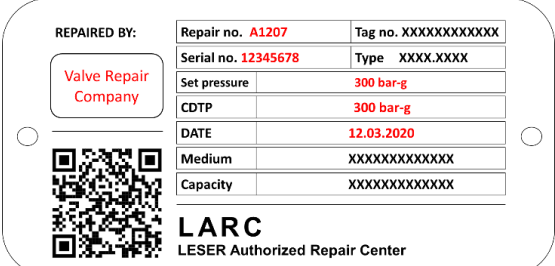
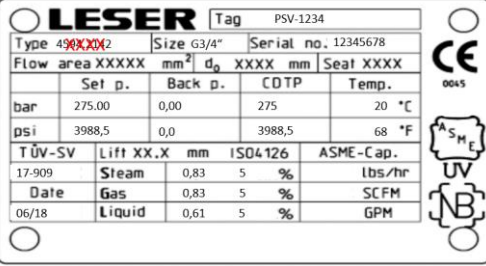
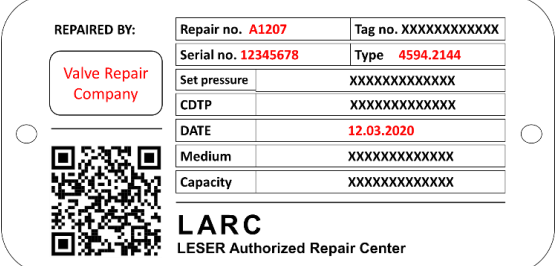
Nameplate field	Information from assembler	Example
(17) Assembled by	Include the line "Assembled by" and the assembler name.	Assembled by BValve
(4) Serial number	When the original valve configuration was changed in any way, the assembler abbreviation (to be provided by LESER) should be added at the end of the serial number.	10400000-BVa
(8) set pressure	Operational data from sizing	
(9) back pressure		
(10) CDTP		
(11) temperature		
CE marking	The CE marking can remain on the nameplate, on the condition that the original valve was shipped with CE marking	
UV stamp	The UV stamp can only be used by ASME certified assemblers.	
(16) Capacity	Capacity for UV certified valves	

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6.2 Repairs and Retrofitting

Whenever a valve is repaired, a repair tag must be attached to the valve. The repair tag must contain at least the date and serial number. Any changes to the valve that result in a change to the information on the nameplate must X-ed out on the nameplate. In addition, the new information must be marked on the repair tag. In this context, LESER indicates which information must be X-ed in the following table.

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Action	Nameplate	Repair Tag
Change of set pressure	 <p>LESER Tag PSV-1234 Type 4594.2142 Size G3/4" Serial no. 12345678 Flow area XXXXX mm² d₀ XXXX mm Seat XXXX Set p. Back p. CDTP Temp. bar 275.00 0,00 275 20 °C psi 3988,5 0,0 3988,5 68 °F TÜV-SV Lift XX.X mm ISO4126 ASME-Cap. 17-909 Steam 0,83 5 % lbs/hr Date Gas 0,83 5 % SCFM 06/18 Liquid 0,61 5 % GPM</p>	 <p>REPAIRED BY: Valve Repair Company Repair no. A1207 Tag no. XXXXXXXXXXXXX Serial no. 12345678 Type XXXX.XXXX Set pressure 300 bar-g CDTP 300 bar-g DATE 12.03.2020 Medium XXXXXXXXXXXXXXXX Capacity XXXXXXXXXXXXXXXX LARC LESER Authorized Repair Center</p>
Change of cap / sealing for compact performance / pilot control for POSV	 <p>LESER Tag PSV-1234 Type 4594.2142 Size G3/4" Serial no. 12345678 Flow area XXXXX mm² d₀ XXXX mm Seat XXXX Set p. Back p. CDTP Temp. bar 275.00 0,00 275 20 °C psi 3988,5 0,0 3988,5 68 °F TÜV-SV Lift XX.X mm ISO4126 ASME-Cap. 17-909 Steam 0,83 5 % lbs/hr Date Gas 0,83 5 % SCFM 06/18 Liquid 0,61 5 % GPM</p>	 <p>REPAIRED BY: Valve Repair Company Repair no. A1207 Tag no. XXXXXXXXXXXXX Serial no. 12345678 Type 4594.2144 Set pressure XXXXXXXXXXXXXXXX CDTP XXXXXXXXXXXXXXXX DATE 12.03.2020 Medium XXXXXXXXXXXXXXXX Capacity XXXXXXXXXXXXXXXX LARC LESER Authorized Repair Center</p>
Bellows conversion	If the CDTP does not change, none of the information on the original nameplate will change. If CDTP change -> see "Change of set pressure"	If the CDTP does not change, then only the date and serial number will be marked. If CDTP change -> see "Change of set pressure"
Lapping of disc or seat / nozzle	After disassembling the safety valve for e.g. lapping a repair tag has to be attached. Including the 1) Name of responsible organization; 2) Date of repair; 3) set pressure;	
Test Only	Where a valve has been tested a "Test Only" tag can be applied that contains the following information: 1) Name of responsible organization; 2) Date of test; 3) Set Pressure; and 4) Identification, such as "Test Only." This also applies if the valve was adjusted to restore the nameplate set pressure but not otherwise repaired. The existing repair nameplate, if applicable, shall not be removed during such testing.	

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Appendix I: List of Assembler Abbreviations

The following lists details the abbreviations that assembling sales partners and certified assembler (*) should use.

Name	Abbreviation
Advance Valve Inc (*)	AV
Aeon PEC – Shreveport (*)	AP
André Ramseyer AG	AR
ARMATEC DENMARK A/S	AD
ARMATEC NORWAY AS	AN
ARMATEC SWEDEN AB	AS
Blass Zvi Co. Ltd	BL
BRUNNBAUER-ARMATUREN	BR
ERIKS B.V.	ER
GEDIK Termo VANA	GE
Hong Kong LESER Safety	HK
LESER FR	FR
Leser UK Limited	UK
Myers-Aubrey Co	MA
Oy ARMATEC FINLAND Ab	AF
Spirax Sarco	SP
Unified Valve Group LTD (*)	VU
Westech Industrial Ltd. (*)	WI

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