THERMOCOUPLE PLACEMENT ON PIPE
GREATER THAN NPS 8 (DN 200)

Recording / Spare Thermocouple Pair

1 in. (25 mm) Weld Face

Over NPS 8 (DN 200)

Control / Spare Thermocouple Pair (either location may be used)

Recording / Spare Thermocouple Pair

1 in. (25 mm)

THERMOCOUPLE PLACEMENT ON PIPE
NPS 8 (DN 200) AND LESS

Recording / Spare Thermocouple Pair

1 in. (25 mm) Weld Face

NPS 8 (DN 200) and smaller

Control / Spare Thermocouple Pair (either location may be used)

1 in. (25 mm)
**THERMOCOUPLE PLACEMENT ON PIPE GREATER THAN NPS 8 (DN 200) WITH BRANCH CONNECTIONS OR ATTACHMENTS**

For branch connections or attachments without reinforcing pads (or with reinforcing pads which do not require PWHT):

- 1 in. (25 mm) Control / Spare Thermocouple Pair (either location may be used)
- Recording / Spare Thermocouple Pair
- Branch Connection or Attachment

For branch connections or attachments requiring PWHT:

- Over NPS 8 (DN 200)
- 1 in. (25 mm) Control / Spare Thermocouple Pair (either location may be used)
- Recording / Spare Thermocouple Pair

**THERMOCOUPLE PLACEMENT ON PIPE GREATER THAN NPS 8 (DN 200) WITH REINFORCING PADS ON BRANCH CONNECTIONS OR ATTACHMENTS**

- Branch Connection or Attachment with Reinforcing Pad Requiring PWHT
- Over NPS 8 (DN 200)
- 1 in. (25 mm) Control / Spare Thermocouple Pair (either location may be used)
- Recording / Spare Thermocouple Pair
THERMOCOUPLE PLACEMENT ON PIPE NPS 8 (DN 200) AND LESS WITH BRANCH CONNECTIONS OR ATTACHMENTS

Branch Connection or Attachment without Reinforcing Pad (or with reinforcing pads which do not require PWHT)

NPS 8 (DN 200) and smaller

Weld Width

1 in. (25 mm)

Control / Spare Thermocouple Pair (either location may be used)

Recording / Spare Thermocouple Pair

1 in. (25 mm)

THERMOCOUPLE PLACEMENT ON PIPE NPS 8 (DN 200) OR LESS WITH REINFORCING PADS ON BRANCH CONNECTIONS OR ATTACHMENTS

Branch Connection or Attachment with Reinforcing Pad Requiring PWHT

NPS 8 (DN 200) and smaller

Weld Width

1 in. (25 mm)

Control / Spare Thermocouple Pair (either location may be used)

Recording / Spare Thermocouple Pair

1 in. (25 mm)