



APPLIED TECHNOLOGY SERVICES

Non Destructive Examination

3400 Crow Canyon Road, San Ramon, CA 94583



Data Sheet for RT Characterization of DSAW vs. SSAW Pipeline long seam welds

Examiner/Level (Print): _____

(Sign) _____

Company: PGE / ATS

Interpreter/Level (Print) _____

(Sign) _____

Company: PGE / ATS

Reviewer/Level (Print) _____

(Sign) _____

Company: PGE / ATS

Date: _____

Line No.: _____

Location: _____

GPS data: _____

Pipe Size: _____

Documented pipe thickness: _____

Minimum thickness found: _____

OD Corrosion: Yes* No*

NDT Equipment, Procedures and Results

RT Procedure #: _____

Length of weld examined: _____

RT method: X Ray* Gamma* Se⁷⁵
Ir¹⁹²

Acceptable to API 5L: Yes* No*

UT Procedure #: _____

UT Equip. Serial numbers: _____

Surface NDT Procedure #: _____

Surface NDT method: _____

Surface NDT results: _____

Acceptable or Rejectable: Accept* Reject*

Note * delete or line through where applicable

Weld Characterization

DSAW

- Similar width OD & ID crowns.
- Light density at weld center across superimposed crowns.
- Visible edges of OD & ID weld crowns.
- In the "Flat Topped" area, the ID weld crown will have a uniform density across the 4-inch area and a weld bead characteristic of a machine submerged arc weld (uniform with bead width similar to OD crown).

SSAW

- OD crown but no uniform ID crown.
- Evidence of possible use of temporary chill ring.
- More uniform density across weld crown indicating less reinforcement on ID.
- Root geometry.
- Moderate weld indications observed.

OTHER

- Only OD crown, with possible ID repairs.
- Evidence of repairs.
- Grinding marks.

