



Revised Weld Inspection and Soap Testing Requirements for Pipelines Operating above 60 psig.

Summary	This Bulletin revises weld inspection documentation and soap testing requirements of welds performed on pipelines operating above 60 psig. This bulletin also communicates enhancements to employee operator qualification task 10-02, "Weld Inspection".
Affected Document	Gas Standard D-40, "Weld Inspection" Gas Standard A-34, "Piping Design and Test Requirements" UO Standard S4450 Operator Qualification Program
Target Audience	Gas construction employees and contractors who inspect welds on steel pipelines operating above 60 psi. Job Classifications include General Construction welders, Transmission District Mechanic welders, Distribution Gas Mechanics and Contract Welding Inspectors. Compliance with the requirements of Title 49 of the Code of Federal Regulations Part 192.235 & 192.241, ASME B31.8 Appendix I, and American Petroleum Institute (API) 1104 "Welding of Pipelines and Related Facilities".
What you need to know	Weld Inspection Documentation <ul style="list-style-type: none">• Weld inspection documentation for all welds performed on pipelines operating above 60 psig must be documented on form FD-40-A, "Daily Field Weld Summary Report" and signed by either:<ol style="list-style-type: none">1) Personnel that have been trained and qualified under the enhanced OQ Task 10-02 conducted by PG&E personnel or;2) Personnel who hold a valid American Welding Society QC1 Certified Welding Inspector (CWI) certification.• Use instructional job aid TD-D-40-JA01 for instructions to fill out form FD-40-A, "Daily Weld Summary Report".• All weld inspection documentation must be retained by the responsible operating department in the job file.



Revised Weld Inspection and Soap Testing Requirements for Pipelines Operating above 60 psig.

Weld Inspection Documentation (Continued)

- The areas to be documented on form FD-40-A for each weld include:
 - Project information
 - Welding & Non Destructive Testing (NDT) organizations
 - Pipeline Material information (for Traceability)
 - Weld identification
 - Welding Procedure Specification
 - Welder identification (position on weld)



Revised Weld Inspection and Soap Testing Requirements for Pipelines Operating above 60 psig.

- Acceptance/Rejection documentation will be required for the following items:

Joint Cleaning
 Bevel Condition & Fit up
 Pre & post-heat Temperature
 Electrode Type
 Time Between Passes (minute)
 Voltage & Amperage range
 Weld Travel Speed & Direction
 Visible Weld Defects & Repairs
 NDT results (If required for pipeline)
 Soap Test Results

Soap Test Requirement

- All pressure-retaining welds that are not included in a strength test pressure report must be soap tested at current operating pressure prior to coating and backfill.
- All existing design and test requirements for piping, assemblies, and equipment apply.

Operator Qualification Task 10-02 Enhancement

Operator Qualification (OQ) Task 10-02.00 "Weld Inspection" has been enhanced to incorporate visual weld inspection test questions and a comprehensive hands-on inspection evaluation.

- Beginning June 1, 2012, training and OQ evaluations will be conducted by PG&E Academy Operations, Gas Methods & Procedures field support and General Construction personnel.
- Upon successful qualification, employees are required to use form FD-40-A, "Daily Field Weld Summary Report" form (attached) to document weld inspection results.

Approved By

Redacted, Manager

Document Contact

Redacted (Supervisor, Gas Methods & Procedure)

Inclusion Plan

This information will be incorporated into a future updates of weld inspection procedures, design and test requirement procedures and OQ task 10-02. (Expected publication 12/31/2012)