

STANDARD PROCEDURE FOR INSPECTION OF WELDS ON GAS PIPING SYSTEMS

1. Scope

1.1 The purpose of this standard is to establish a minimum weld check by radiographic or visual examination procedures on all gas piping systems, in accordance with General Order 112.

1.2 The quality of welding shall be checked on a sampling basis, with the following minimum number of inspections required.

1.2.1 Piping systems designed to operate at stresses less than 20% of specified minimum yield point - random visual inspections to check weld quality. Permanent records are not required; however, inspection shall be sufficient to establish conformance with ~~SP-1600~~ and ~~1601~~.
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1.2.2 Piping systems designed to operate at stresses over 20% of specified minimum yield point - the extent of weld inspection shall be sufficient to establish that the performance of each welder is sampled. The following minimum inspections shall be made:

- 1.2.2.1 100% of welds at tie-ins.
- 1.2.2.2 100% of welds at river, highway, and railroad crossings.
- 1.2.2.3 100% of welds at taps to pipelines.
- 1.2.2.4 100% of welds which contain repaired areas.
- 1.2.2.5 30% of welds in Class 3 and Class 4 locations.
- 1.2.2.6 20% of welds in Class 1 and Class 2 locations.

1.3 On pipeline systems operating at stresses over 20% of the specified minimum yield point, the number of welds examined by radiographic procedures shall be at least in accordance with ~~SP-1602~~. The balance of the welds to comply with General Order 112 shall be inspected by the visual method.
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2. Inspection

2.1 Visual inspection shall be in conformance with ~~SP-1602~~, Paragraph 4.2, and must be made by a qualified employee who shall not be permitted to inspect his own work.
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2.2 Radiographic inspection shall be given by the General Construction Radiographic Service or by an approved commercial radiographic service, and shall either be in accordance with ~~SP-1602~~ or API 1104, latest edition.
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3. Records

Inspection results on pipelines designed to operate at stresses over 20% of specified minimum yield point shall be recorded on an inspection report, page 2 of this standard. Reports must identify the specific location of welds requiring 100% inspection as noted in Paragraph 1.2.2. Inspection reports shall be maintained for the life of the pipeline facility. The reports shall be forwarded to the Division Gas Superintendent or Manager, Pipeline Operations for permanent filing with completed foreman's copy of the W.O. or G.M.

APPROVED

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DATE

10-28-63

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Vice President - Gas Operations

