

1 General

- 1 1 A welder qualified under this Standard may perform oxy-acetylene butt welds on 2-inch and smaller pipe with a wall thickness of less than 0.188 in either vertical or horizontal position and at all design pressure stress levels
- 1 2 Qualification applies only to pipe meeting API 5L or 5LX or ASTM A53 or A106 specifications
- 1 3 Weld procedure materials and equipment shall be as specified in Standard D-20

2 Qualification Test

- 2 1 Qualification shall be performed with 2" nominal diameter by 0.154" wall thickness by 4 5 minimum length test spools (code 02-2057)
- 2 2 One test weld shall be performed in the horizontal fixed position and one in the vertical fixed position

3 Test Weld Inspection Requirements

- 3 1 The test welds shall be visually inspected See Standard D-40 for inspection requirements Any weld not meeting these requirements shall be failed without performing destructive tests
- 3 2 See Page 2 for type and number of destructive test specimens Specimens shall be tested in accordance with and meet the requirements of Standard D-31

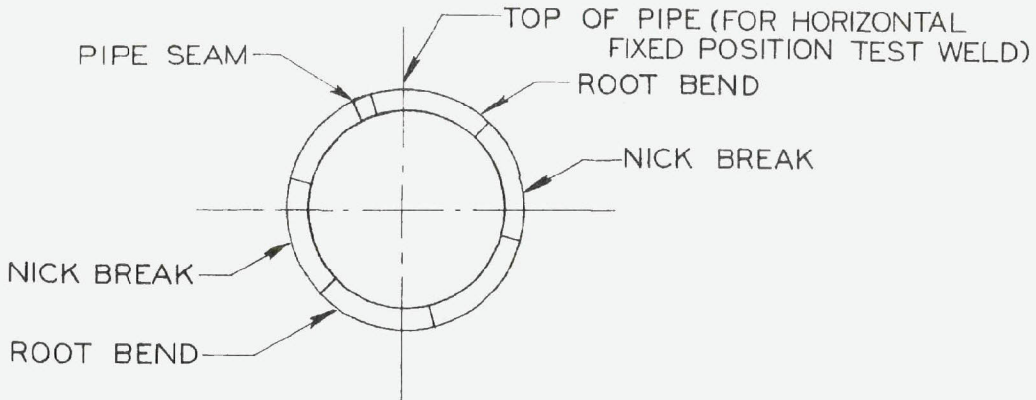
4 Requalification

- 4 1 Welders shall be requalified at intervals not to exceed six months The requalification test is the same as the qualification (Section 2)

5 Limitations on Welder Qualification

- 5 1 This test shall be given only to welders who will be making oxy-acetylene butt welds on pipe designed to operate at over 20% of SMYS (limited to 2 and smaller) For general purpose oxy-acetylene welding qualification is required under D-30

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APPROVED <i>[Handwritten Signatures]</i>										
BY	PIPING - DETAILS OXY-ACETYLENE WELDER QUALIFICATION FOR OVER 20% OF SMYS GAS STANDARD PACIFIC GAS AND ELECTRIC COMPANY								SUPERSEDES	
DSGN									SUPERSEDED BY	
DR									SHEET No 1 OF 2 SHEETS	
CH									w	
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NOTES:

1. PIPE SEAM WELD SHALL BE LOCATED IN AN AREA OTHER THAN IN A SPECIMEN.
2. WELD SPECIMENS MUST BE TESTED IN ACCORDANCE WITH AND MEET REQUIREMENTS OF STANDARD D-31. WELDS SHALL PASS BOTH VISUAL AND DESTRUCTIVE TESTS.

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<p>APPROVED <i>gwh pdt RATES ROH pdt cjt</i></p>						
<p>BY DSGN. DR. CH. O.K.</p>			<p>PIPING - DETAILS OXY-ACETYLENE WELDER QUALIFICATION FOR OVER 20% OF S.M.Y.S. GAS STANDARD PACIFIC GAS AND ELECTRIC COMPANY</p>			
<p>DATE 10-10-75</p>			<p>SCALE</p>		<p>SUPERSEDES SUPERSEDED BY SHEET No. 2 OF 2 SHEETS DRAWING NUMBER 086463</p>	
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