

1 General

- 1 1 A welder qualified under this Standard may perform oxy-acetylene butt welds on 1/2-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)

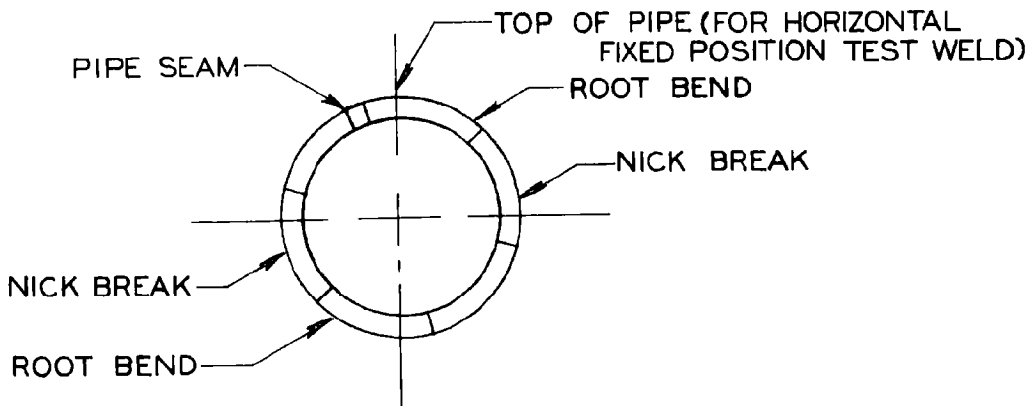
5 Limitations on Welder Qualification

- 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

1 6 79	ADDED SHEET 3 AND PARA 6	<i>[Signature]</i>			
0 12077	ISSUE FOR USE	<i>[Signature]</i>			
G	D	D	O	A	C
APPROVED <i>[Signature]</i> <i>[Signature]</i> <i>[Signature]</i> <i>[Signature]</i> <i>[Signature]</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DSGN					SUPERSEDED BY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 3 SHEETS
CH					W M C
OK					086463 1
DATE	SCALE				

6 Records

- 6 1 Records for all welders who have been qualified under this Standard shall be retained as outlined below
- 6 2 All Employee Qualification and Requalification records must be retained for a minimum duration of five years
- 6 3 All Employee Qualification and Requalification records must be retained through temporary lapses in a welder's qualification
- 6 4 The Record shall be made by filling out Form 75-96 (Gas Standard D-301 Page 3)



DESTRUCTIVE TEST SPECIMEN

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

PG & E CO		DRAWING NUMBER	REV
SHEET 2 OF 3 SHEETS		086463	1
		MICROFILM	

OXY ACETYLENE WELD TEST REPORT

DIVISION _____

FOR WELDERS ON PIPING SYSTEMS OPERATING AT HOOP STRESSES
GREATER THAN 20% OF THE SPECIFIED MINIMUM YIELD STRENGTH

(Check Appropriate Box)

CODE MARK _____

Passed Failed

FULL NAME _____

DATE OF ANNUAL QUALIFICATION WELD _____

SOCIAL SECURITY NO _____

DATE OF INSPECTION OF WELD _____

CLASSIFICATION _____

DATE OF PREVIOUS ANNUAL QUALIFICATION _____

TOWN _____

DATE OF 6 MONTH VERIFICATION OF WELDING IN
QUALIFICATION PROCESS _____

Butt Weld 2 Nominal Diameter By 0 154 W T By 4 5 Minimum Length Test Spools

Root Bend Pipe in Horizontal Fixed Position	PENETRATION (G) (S) (U)	FUSION (G) (S) (U)	POROSITY (P) (F)	SLAG INCLUSION (P) (F)	APPEARANCE (G) (S) (U)	REMARKS (1) (6)	TEST RESULTS (P) (F)
SPECIMEN							
1							
2							
Root Bend Pipe in Vertical Fixed Position	PENETRATION (G) (S) (U)	FUSION (G) (S) (U)	POROSITY (P) (F)	SLAG INCLUSION (P) (F)	APPEARANCE (G) (S) (U)	REMARKS (1) (6)	TEST RESULTS (P) (F)
SPECIMEN							
3							
4							

TYPE TEST NICK BREAK

SPECIMEN		GAS POCKETS			SLAG INCLUSION				
NO	LOCATION	NO	MAX SIZE	BETWEEN	NO	LENGTH	BETWEEN	FUSION	REMARKS
1									
2									
3									
4									

KEY Use these abbreviations in POROSITY SLAT INCLUSION & TEST RESULTS columns
 P - Pass F Fail
 Use these abbreviations in PENETRATION FUSION and APPEARANCE columns
 G = Good S - Satisfactory U Unsatisfactory
 Use the following in REMARKS section as applicable
 1 - Under cutting 3 - Excessive weld reinforcements 5 Lack of Penetration
 2 - Cold lap 4 Insufficient weld reinforcement 6 Burn through

Test Inspector _____

	PG & E CO	DRAWING NUMBER	REV
	SHEET 3 OF 3 SHEETS	086463	/
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