



West Texas Gas Welding Procedures List

Procedure # 4A - **Inclined 45 Deg.**, Less than 2 3/8 Pipe size, and less than .188 Wall Thickness , Grade A thru X42, Electrode E6010

Procedure # 4AH - Fixed Horizontal, Less than 2 3/8 Pipe size, and less than .188 Wall Thickness , Grade A thru X42, Electrode E6010

Procedure # 5A - **Inclined 45 Deg.**, 8” thru 12” and .188 Wall Thickness thru .500 Wall Thickness, Grade A thru X42, Electrode E6010

Procedure # 5AH - Fixed Horizontal, 8” thru 12” and .188 Wall Thickness thru .500 Wall Thickness, Grade A thru X42, Electrode E6010

Procedure # 5G - **Inclined 45 Deg.**, 8” thru 12” Pipe size, and .188 Wall Thickness thru .500 Wall Thickness, Grade A thru X42, Electrode E6010 and E8010

Procedure # 52G - Inclined 45 Deg., 8” thru 12” Pipe size, and .188 Wall Thickness thru .500 Wall Thickness, Grade X52, Electrode E6010 and E8010

Procedure # 5GH - Fixed Horizontal, 8” thru 12” Pipe size, and .188 Wall Thickness thru .500 Wall Thickness, Grade A thru X42, Electrode E6010 and E8010

Procedure # 6 - **Inclined 45 Deg.**, Greater than 12” Pipe Size, and .188 Wall Thickness thru .500 Wall Thickness, Grade A thru X42, Electrode E6010 and E8010

Procedure # 6H - Fixed Horizontal, Greater than 12” Pipe Size, and .188 Wall Thickness thru .500 Wall Thickness, Grade A thru X42, Electrode E6010 and E8010

Procedure # 6A - **Inclined 45 Deg.**, Greater than 12” Pipe Size, and .188 Wall Thickness thru .500 Wall Thickness, Grade A thru X42, Electrode E6010

Procedure # 6AH - Fixed Horizontal, Greater than 12” Pipe Size, and .188 Wall Thickness thru .500 Wall Thickness, Grade A thru X42, Electrode E6010

Procedure # 6AH52 – Fixed horizontal, Greater than 12” Pipe Size, and .188 Wall Thickness thru .500 Wall Thickness, and Grade X52, Electrodes E6010 / E8010

Procedure # 7A - **Inclined 45 Deg.**, 2 3/8 thru 6 5/8 Pipe size, and less than .188 Wall Thickness, Grade A thru X42, Electrode E6010

Procedure # 7AH - Fixed Horizontal, 2 3/8 thru 6 5/8 Pipe size, and less than .188 Wall Thickness, Grade A thru X42, Electrode E6010

Procedure# 7B – **Inclined 45 Deg.**, 2 3/8 thru 6 5/8 Pipe Size, and .188 Wall Thickness thru .500 Wall thickness. Grade A thru X 42, Electrode E6010 and E8010

Procedure# 7BH – Fixed Horizontal, 2 3/8 thru 6 5/8 Pipe Size, and .188 Wall Thickness thru .500 Wall thickness. Grade A thru X 42, Electrode E6010 and E8010

Procedure# 7C – **Inclined 45 Deg.**, 2 3/8 thru 6 5/8 Pipe Size, and .188 Wall Thickness thru .500 Wall thickness. Grade A thru X 42, Electrode E6010

Procedure# 7CH – Fixed Horizontal, 2 3/8 thru 6 5/8 Pipe Size, and .188 Wall Thickness thru .500 Wall thickness. Grade A thru X 42, Electrode E6010

Procedure# F22 - Fixed Horizontal, **Fillet weld procedure** to weld Pumpkin on Horizontal pipeline.

Procedure# 7B2F – Fixed Horizontal Header **Fillet Weld Procedure**, 2 3/8 thru 12 in. and .188 thru .250 X 1 in. thru 4 in. Branch .188 thru .250 wall. Electrode E6010 & E8010

Procedure# 7A+ - Fixed Horizontal 2 3/8 thru 6 5/8 Pipe Size, and .188 thru .250 Wall thickness. Grade A thru X42, Electrode E6010 and E8010

Procedure# 7B2 – **Inclined 45 Deg.**, 2 3/8 thru 6 5/8 Pipe Size, and .188 Wall Thickness thru .500 Wall thickness. Grade A thru X 42, Electrode E6010 and E8010

Procedure# 7B52 – **Inclined 45 Deg.**, 2 3/8 thru 6 5/8 Pipe Size, and .188 thru .500 Wall thickness. Grade X52, Electrode E6010 and E8010

Procedure# 7A2 – **Inclined 45 Deg.** 2 3/8 thru 6 5/8 Pipe Size, and less than .188 Wall thickness. Grade A thru X42, Electrode E6010 and E8010

Procedure# F 12/12 – **Horizontal Header 8 in. thru 12 in - Branch Down 8 in. thru 12 in. Pipe Size and .188 thru .500 Wall thickness. Grade A thru X 42, Electrode E6010 and E8010**

Procedure # 6G – **Fixed Horizontal** , 12” and larger, and .188 thru .500 Wall thickness, Grade X52---Electrode E6010 & E8010

Procedure # 7B52F – Horizontal Header 8” thru 12”, Branch 8” thru 12”, .250 Wall thru .500 Wall, Grade X52, Electrode E6010 & E8010

ALL ORIGINAL WELD INSPECTION REPORTS FOR EACH PROCEDURE ARE LOCATED IN THE DALHART OFFICE.