

CONSTRUCTION: JOINING OF PIPES BY WELDING

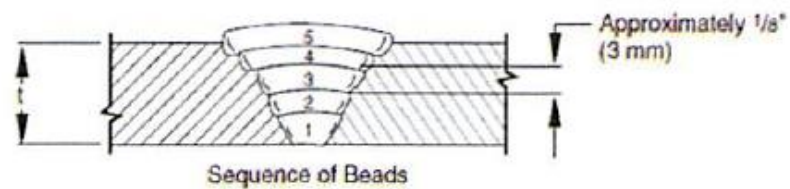
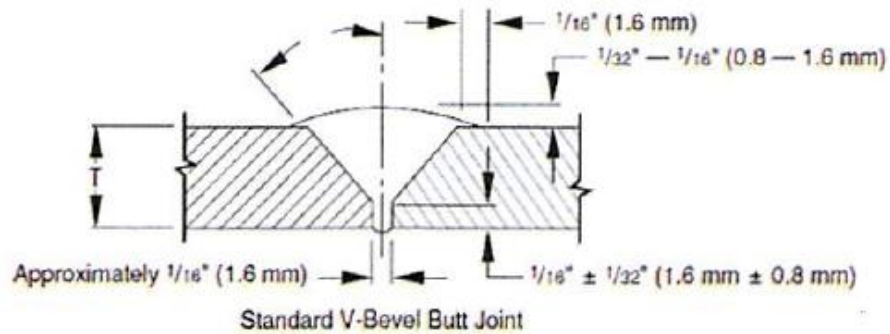
Issued: 12-28-12 Revised: _____ Number: 7A+ Page: _____

STANDARD WELDING PROCEDURE SPECIFICATION #: 7A+

- A. Process: Manual Electric Arc
- B. Material: API-5L Grade A thru X42
- C. Diameter and Wall Thickness: Less than 2 3/8 thru 6 5/8 and less than 0.188 WT thru 0.250
- D. Joint Design: Standard Vee Groove 30 degrees
- E. Filler Metal and Number of Beads: Electrode Classification Electrode E6010 & E8010 AWS Class A5.1 Minimum of 3 Passes
- F. Electrical or Flame Characteristics: D.C. Reverse Polarity, Electrode Positive
- G. Position: Inclined 45 degrees
- H. Direction of Welding: Vertical Down
- I. Number of Welders: 1
- J. Time Lapse Between Passes: Maximum of 5 minutes between stringer and hot pass; 3 minutes maximum when temperature is below 35° F
- K. Type of Line-up Clamp: External
- L. Removal of Line-up Clamp: After 50% completion of stringer bead
- M. Cleaning: Taper grind starts and craters and flatten crown by grinding stringer bead, power buff all remaining passes
- N. Speed of Travel: String bead 10 inches per minute max
- O. *Preheat, Stress Relief: Maximum of 300°F, Minimum of 150°F Preheating shall be done with device or equipment which will heat entire circumference(s) in single application 2" back from pipe ends
- P. Notes: Welded pipe strings shall be temporarily capped to prevent air draft cooling of stringer beads. Weld shall be completely protected from moisture until it has cooled to ambient temperature. Weld zone shall be protected so that the wind velocity near it does not exceed 8mph.
- * X-rated pipe must be stress relief if the carbon content exceeds 32% or C+1/4 Mn exceeds 65%. Heating of X-rated pipe is limited to 600°F.

Number: 7A+ Page: _____

CONSTRUCTION: JOINING OF PIPES BY WELDING



Note: Dimensions are for example only.

Bead No.	Electrode Diameter	Amperage Range	Voltage Range	Type Rod	Notes
1	3/32	65-80	20-25	E6010 5P+	
2	1/8**	80-100	25-35	E8010	
3	1/8	80-100	25-35	E8010	
4	1/8	80-105	27-37	E8010	
5					

Bead No.	Notes
2	Can be ran with 3/32 rod in the same class range at 75-85 amps and 22-27 volts
	Electrodes may be substituted within rod group 1&2 of AWS specification A5.1-A5.5

CONSTRUCTION: JOINING OF PIPES BY WELDING

(USE SEPARATE FORM FOR EACH WELDING PROCEDURE)

WELD TEST REPORT		(USE SEPARATE FORM FOR EACH WELDING PROCEDURE)						
DATE <i>12-28-11</i>		WELDER'S NAME <i>T.J. Galloway</i>			SOCIAL SECURITY NUMBER <i>7686</i>			
LOCATION <i>Dallhart</i>		NAME OF CONTRACTOR OR COMPANY <i>M+M</i>			RIGHT HANDED <input checked="" type="checkbox"/> LEFT HANDED <input type="checkbox"/>			
POSITION INCLINED <input checked="" type="checkbox"/> 45° FIXED <input type="checkbox"/> HORIZONTAL <input type="checkbox"/>		ELECTRIC ARC <input checked="" type="checkbox"/> INDOORS <input type="checkbox"/> OX-ACETYLENE <input type="checkbox"/> OUTDOORS <input type="checkbox"/>		WEATHER <i>CL</i>		TEMPERATURE <i>70</i>	TIME OF DAY <i>Afternoon</i>	WIND BREAK USED <i>n/a</i>
PIPE SPECIFICATION <i>API 5L GR X42</i>		PIPE MANUFACTURER <i>Rep</i>		WALL THICKNESS <i>.188</i>		DIAMETER (OD) <i>8.875</i>	WEIGHT PER FOOT <i>12.92</i>	
MAKE OF WELDING MACHINE <i>Lind</i>		SIZE <i>300</i>	MAKE OF OX-ACETYLENE APPARATUS <i>n/a</i>	WELDING NOZZLE SIZE <i>n/a</i>		OX-ACETYLENE PRESSURE (PSIG) TEST FOR <i>n/a</i>		
BRAND OF ELECTRODE <i>Lind</i>		BRAND OF OX-ACETYLENE ROD AND SIZE <i>n/a</i>		NUMBER OF PASSES - OX-ACETYLENE WELD <i>n/a</i>		WELDING PROCEDURE NO <i>7AT</i>		

	ELECTRODE TYPE AND SIZE		MACHINE SETTINGS		AMPERAGE RG.	VOLTAGE RG.	
			COARSE	FINE			
PIPE WELD	STRINGER	<i>5A 5P+ 3/32</i>	<i>120-190</i>	<i>30</i>	<i>65-75</i>	<i>20-25</i>	<i>API 1104 20th Edition</i>
	HOT PASS	<i>5A 70+ 1/8</i>	<i>120-190</i>	<i>35</i>	<i>80-100</i>	<i>25-30</i>	
	FILLER (S)	<i>5A 70+ 1/8</i>	<i>120-190</i>	<i>40</i>	<i>80-90</i>	<i>25-30</i>	
	CAP PASS	<i>5A 70+ 1/8</i>	<i>120-190</i>	<i>40</i>	<i>85-95</i>	<i>28-35</i>	

	COUPON			CROSS SEC. AREA SQ. IN.	LOAD	% ELONG.	COMPUTED TENSIL PSI	REMARKS	AC-CEPTED	RE-JECTED	
	LOCATION	LENGTH	WIDTH								
TENSILE TESTS	1	<i>T1</i>	<i>8</i>	<i>1"</i>	<i>.188</i>	<i>12,300</i>	<i>20%</i>	<i>45,425</i>	<i>No defect</i>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
	2	<i>T2</i>	<i>8</i>	<i>1"</i>	<i>.188</i>	<i>12,100</i>	<i>20%</i>	<i>48,361</i>	<i>No defect</i>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
	3										
	4										

	COUPON LOCATION	TYPE OF BEND	REMARKS	AC-CEPTED	RE-JECTED	
	BEND TESTS	1	<i>R1</i>	<i>Root</i>	<i>No defect</i>	<input checked="" type="checkbox"/>
2		<i>R2</i>	<i>Root</i>	<i>No defect</i>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
3		<i>F1</i>	<i>Face</i>	<i>No defect</i>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
4		<i>F2</i>	<i>Face</i>	<i>No defect</i>	<input checked="" type="checkbox"/>	<input type="checkbox"/>

	COUPON LOCATION	REMARKS	AC-CEPTED	RE-JECTED	
	NICK-BREAK TESTS	1	<i>T1</i>	<i>Clean Metal</i>	<input checked="" type="checkbox"/>
2		<i>T2</i>	<i>Clean Metal</i>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
3					
4					

TEE WELD TEST	SIZE AND WALL THICKNESS OF MAIN <i>.188 4"</i>	GAS PRESSURE ON MAIN <i>0</i> PSIG	LOCATION OF FRACTURE WELD <input type="checkbox"/> NIPPLE <input type="checkbox"/> MAIN <input checked="" type="checkbox"/>		
	DID WELD CONTAIN: PINHOLES <input type="checkbox"/> COLD ROLL <input type="checkbox"/> UNDERCUT <input type="checkbox"/>		DEPTH OF UNDERCUT	LENGTH OF UNDERCUT	
	REMARKS ON TEE WELD <i>Checked next, no defects</i>				

PIPE WELD	QUALIFIED <input checked="" type="checkbox"/> NOT QUALIFIED <input type="checkbox"/>	ELECTRIC ARC <input checked="" type="checkbox"/> OX-ACETYLENE <input type="checkbox"/>	TEE WELD	QUALIFIED <input checked="" type="checkbox"/> NOT QUALIFIED <input type="checkbox"/>	ELECTRIC ARC <input checked="" type="checkbox"/> OX-ACETYLENE <input type="checkbox"/>
TESTED BY	SIGNATURE <i>Donald [Signature]</i>		TITLE	<i>Plant Mgr. [Signature]</i>	