

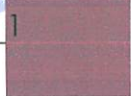
CONSTRUCTION: JOINING OF PIPES BY WELDING

Issued: 2-18-07 Revised: _____ Number: 5A Page: _____

STANDARD WELDING PROCEDURE SPECIFICATION # 5A

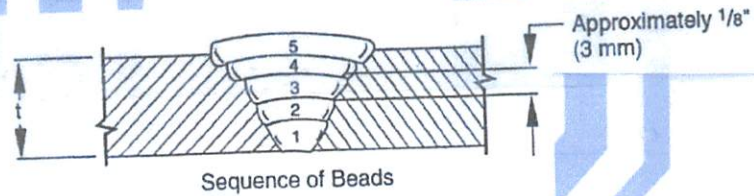
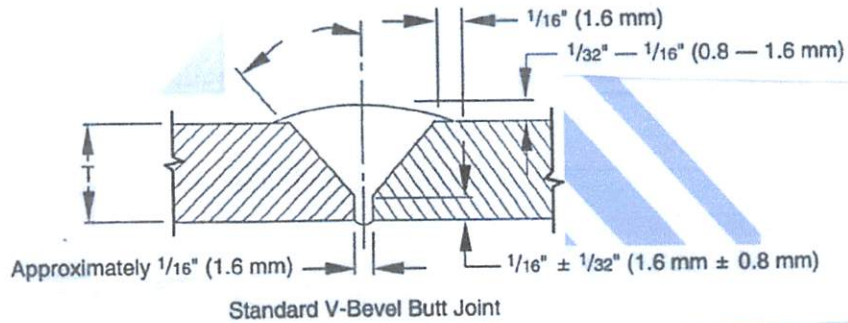
- A. Process: Manual Electric Arc
- B. Material: API-5L Grade A thru Grade X42
- C. Diameter and Wall Thickness: 8" thru 12" and .188 thru .500 WT
- D. Joint Design: Standard Vee Groove 30 degrees
- E. Filler Metal and Number of Beads: Electrode Classification
Electrode E6010 AWS Class A5.1 No less than 4 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 10-12 inches per minute maximum.
- 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 8 miles per hour.

*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.



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Note: Dimensions are for example only.

Bead No.	Electrode Diameter	Amperage Range	Voltage Range	Type Rod	Notes
1	1/8	95-110	25-35	E6010 5P+	
2	1/8	95-115	30-40	E6010 5P+	
3	5/32	105-120	30-40	E6010 5P+	
4	5/32	100-130	25-45	E6010 5P+	
5					

Bead No.	Notes
5	Additional passes may be made using E6010 3/16 within amperage Range 132-170 and volt range 25-35

WELD TEST REPORT

(USE SEPARATE FORM FOR EACH WELDING PROCEDURE)

DATE <i>8-13-2007</i>	WELDER'S NAME <i>Jimmie Moore</i>		SOCIAL SECURITY NUMBER 102-32-1536	
LOCATION <i>Guyton</i>	NAME OF CONTRACTOR OR COMPANY <i>West Texas Gas</i>	RIGHT HANDED <input checked="" type="checkbox"/> LEFT HANDED <input type="checkbox"/>	REQUALIFYING TEST <input checked="" type="checkbox"/> QUALIFYING TEST <input checked="" type="checkbox"/>	LINE TEST <input type="checkbox"/>
POSITION INCLINED <input checked="" type="checkbox"/> 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>100</i>	TIME OF DAY <i>Mid</i>
PIPE SPECIFICATION <i>API 5L X 42</i>	PIPE MANUFACTURER <i>Longstar</i>	WALL THICKNESS <i>.188</i>	DIAMETER (OD) <i>8.5</i>	WEIGHT PER FOOT <i>16.94</i>
MAKE OF WELDING MACHINE <i>Lin</i>	SIZE <i>300</i>	MAKE OF OX-ACETYLENE APPARATUS <i>N/A</i>	WELDING NOZZLE SIZE <i>N/A</i>	OX-ACETYLENE PRESSURE FLOWING <i>N/A</i>
BRAND OF ELECTRODE	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>5A</i>	

PIPE WELD	ELECTRODE TYPE AND SIZE	MACHINE SETTINGS		AMPERAGE RG.	VOLTAGE RG.
		COARSE	FINE		
STRINGER	<i>Lin 1/8 5P+</i>	<i>120-190</i>	<i>35</i>	<i>95-110</i>	<i>25-35</i>
HOT PASS	<i>Lin 1/8 5P+</i>	<i>120-190</i>	<i>45</i>	<i>95-115</i>	<i>30-40</i>
FILLER(S)	<i>Lin 5/32 5P+</i>	<i>120-190</i>	<i>50</i>	<i>105-120</i>	<i>30-40</i>
CAP PASS	<i>Lin 5/32 5P+</i>	<i>120-190</i>	<i>60</i>	<i>100-130</i>	<i>25-45</i>

Tested under API-1104 20th Edition

TENSILE TESTS	COUPON			CROSS SEC. AREA SQ. IN.	LOAD	% ELONG.	COMPUTED TENSIL PSI	REMARKS	AC-CEPTED	RE-JECTED
	LOCATION	LENGTH	WIDTH							
1	<i>T1</i>	<i>8"</i>	<i>1"</i>	<i>1.190</i>	<i>12,000</i>	<i>15%</i>	<i>63,157</i>	<i>No defect</i>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
2	<i>T2</i>	<i>8"</i>	<i>1"</i>	<i>1.190</i>	<i>12,000</i>	<i>15%</i>	<i>63,157</i>	<i>No defect</i>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
3										
4										

BEND TESTS	COUPON LOCATION	TYPE OF BEND	REMARKS	AC-CEPTED	RE-JECTED
	1	<i>TR</i>	<i>Root</i>	<i>No Defects</i>	<input checked="" type="checkbox"/>
2	<i>TF</i>	<i>Face</i>	<i>"</i>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
3	<i>BR</i>	<i>Root</i>	<i>"</i>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
4	<i>BF</i>	<i>Face</i>	<i>"</i>	<input checked="" type="checkbox"/>	<input type="checkbox"/>

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

This weld has been visually and destructively tested in accordance with API-1104

SIZE AND WALL THICKNESS OF MAIN	GAS PRESSURE ON MAIN PSIG	LOCATION OF FRACTURE WELD <input type="checkbox"/>	NIPPLE <input type="checkbox"/>	MAIN <input type="checkbox"/>
DID WELD CONTAIN: PINHOLES <input type="checkbox"/> COLDROLL <input type="checkbox"/> UNDERCUT <input type="checkbox"/>	DEPTH OF UNDERCUT	LENGTH OF UNDERCUT		
REMARKS ON TEE WELD				

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 type="checkbox"/> NOT QUALIFIED <input type="checkbox"/>	ELECTRIC ARC <input type="checkbox"/> OX-ACETYLENE <input type="checkbox"/>
TESTED BY	SIGNATURE <i>Ed Muehlebach</i>		TITLE	<i>Welding Inspector</i>	