

CONSTRUCTION: JOINING OF PIPES BY WELDING

Issued: 8-14-07 Revised: _____ Number: 7A Page: _____

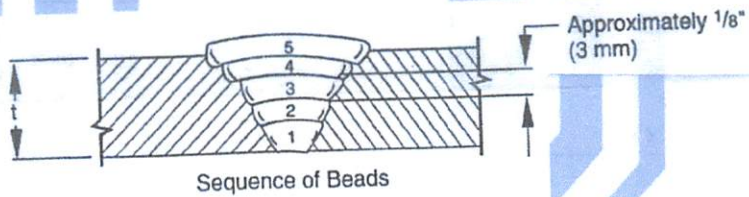
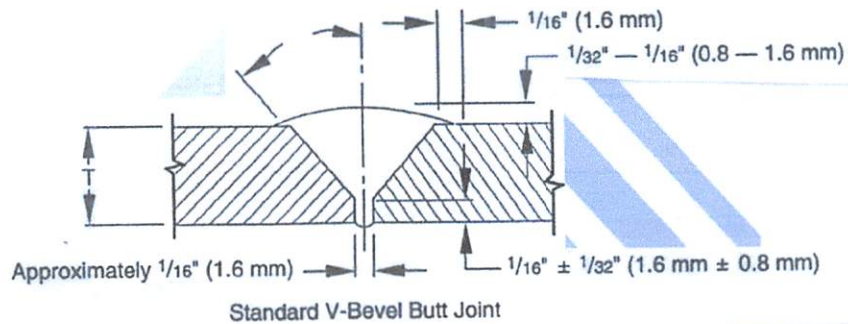
STANDARD WELDING PROCEDURE SPECIFICATION # 7A

- A. Process: Manual Electric Arc
- B. Material: API 5L Grade A thru X42
- C. Diameter and Wall Thickness: 2 3/8 thru 6 5/8 and less than .188 WT
- D. Joint Design: Standard Vee Groove, 30 Degrees
- E. Filler Metal and Number of Beads: Electrode Classification
Electrode E6010 AWS Class A5.1 Minimum of 3 Passes
- F. Electrical or Flame Characteristics: 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 N/A
- 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	3/32	65-80	20-25	E6010 5P+	
2	1/8 **	80-100	25-35	E6010 5P+	
3	1/8	80-100	25-35	E6010 5P+	
4	1/8	80-105	27-37	E6010 5P+	
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

WELD TEST REPORT

(USE SEPARATE FORM FOR EACH WELDING PROCEDURE)

DATE <i>Aug 14, 2007</i>	WELDER'S NAME <i>Derrell Louisford</i>		SOCIAL SECURITY NUMBER <i>XXX-XX-2519</i>	
LOCATION <i>Guymon</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 type="checkbox"/> FIXED <input checked="" type="checkbox"/> HORIZONTAL <input checked="" type="checkbox"/>	ELECTRIC ARC <input checked="" type="checkbox"/> INDOORS <input checked="" type="checkbox"/> OX-ACETYLENE <input type="checkbox"/> OUTDOORS <input type="checkbox"/>	WEATHER <i>CL</i>	TEMPERATURE <i>101</i>	TIME OF DAY <i>2:00 PM</i>
PIPE SPECIFICATION <i>API 5L GR X42</i>	PIPE MANUFACTURER <i>Rep.</i>	WALL THICKNESS <i>1.156</i>	DIAMETER (OD) <i>6.58</i>	WEIGHT PER FOOT <i>10.78</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 <i>N/A</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>7A</i>	

PIPE WELD	ELECTRODE TYPE AND SIZE	MACHINE SETTINGS		AMPERAGE RG.	VOLTAGE RG.
		COARSE	FINE		
STRINGER	<i>Lin 3/32 5PT</i>	<i>120-190</i>	<i>30</i>	<i>65-80</i>	<i>20-25</i>
HOT PASS	<i>Lin 1/8 5PT</i>	<i>120-190</i>	<i>40</i>	<i>80-100</i>	<i>25-35</i>
FILLER (S)	<i>Lin 1/8 5PT</i>	<i>120-190</i>	<i>40</i>	<i>80-100</i>	<i>25-35</i>
CAP PASS	<i>Lin 1/8 5PT</i>	<i>120-190</i>	<i>45</i>	<i>80-105</i>	<i>27-37</i>

Tested Under API 1104 20th Edition

TENSILE TESTS	COUPON			CROSS SEC. AREA SQ. IN.	LOAD	% ELONG.	COMPUTED TENSILE PSI	REMARKS	AC-CEPTED	RE-JECTED
	LOCATION	LENGTH	WIDTH							
1	<i>T1</i>	<i>8"</i>	<i>1"</i>	<i>.160</i>	<i>10,000</i>	<i>25%</i>	<i>63,500</i>	<i>No defect</i>	<input checked="" type="checkbox"/>	<input type="checkbox"/>
2	<i>T2</i>	<i>8"</i>	<i>1"</i>	<i>.160</i>	<i>10,000</i>	<i>25%</i>	<i>63,500</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>R1</i>	<i>Root</i>	<i>No Cracks Full Pen.</i>	<input checked="" type="checkbox"/>
2	<i>R2</i>	<i>Root</i>	<i>" "</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>" "</i>	<input checked="" type="checkbox"/>	<input type="checkbox"/>

NICK-BREAK TESTS	COUPON LOCATION	REMARKS	AC-CEPTED	RE-JECTED
	1	<i>N1</i>	<i>Clean Velvet texture</i>	<input checked="" type="checkbox"/>
2	<i>N2</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 Marshall</i>		TITLE <i>Welding Inspector</i>		