

# **Welding of Pipelines and Related Facilities**

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## Foreword

This standard was prepared by a formulating committee that included representatives of the API, the American Gas Association (AGA), the Pipe Line Contractors Association (PLCA), the American Welding Society (AWS), and the American Society for Nondestructive Testing (ASNT), as well as representatives of pipe manufacturers and individuals associated with related industries.

The purpose of this standard is to present methods for the production of high quality welds through the use of qualified welders using approved welding procedures, materials, and equipment. Its purpose is also to present inspection methods to ensure the proper analysis of welding quality through the use of qualified technicians and approved methods and equipment. It applies to both new construction and in-service welding.

The use of this standard is entirely voluntary and is intended to apply to welding of piping used in the compression, pumping, and transmission of crude petroleum, petroleum products, fuel gases, carbon dioxide, and nitrogen and, where applicable, to distribution systems.

This standard represents the combined efforts of many engineers who are responsible for the design, construction, and operation of oil and gas pipelines, and the committee appreciatively acknowledges their wholehearted and valuable assistance.

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Suggested revisions are invited and should be submitted to the Standards Department, API, 200 Massachusetts Avenue, Suite 1100, Washington, DC 20001, [standards@api.org](mailto:standards@api.org).



# Contents

	Page
<b>1</b>	<b>Scope</b> ..... 1
<b>2</b>	<b>Normative References</b> ..... 1
<b>3</b>	<b>Terms, Definitions, Acronyms, and Abbreviations</b> ..... 2
<b>3.1</b>	<b>Terms and Definitions</b> ..... 2
<b>3.2</b>	<b>Acronyms and Abbreviations</b> ..... 8
<b>4</b>	<b>Specifications</b> ..... 11
<b>4.1</b>	<b>Equipment</b> ..... 11
<b>4.2</b>	<b>Materials</b> ..... 12
<b>5</b>	<b>Qualification of Welding Procedures with Filler Metal Additions</b> ..... 13
<b>5.1</b>	<b>Procedure Qualification</b> ..... 13
<b>5.2</b>	<b>Record</b> ..... 13
<b>5.3</b>	<b>Welding Procedure Specification</b> ..... 13
<b>5.4</b>	<b>Essential Variables</b> ..... 19
<b>5.5</b>	<b>Welding of Test Joints-Butt Welds</b> ..... 22
<b>5.6</b>	<b>Testing of Welded Joints-Butt Welds</b> ..... 22
<b>5.7</b>	<b>Welding of Test Joints-Branch and Fillet Welds</b> ..... 30
<b>5.8</b>	<b>Testing of Welded Joints-Branch and Fillet Welds</b> ..... 31
<b>6</b>	<b>Qualification of Welders</b> ..... 32
<b>6.1</b>	<b>General</b> ..... 32
<b>6.2</b>	<b>Single Qualification</b> ..... 33
<b>6.3</b>	<b>Multiple Qualification</b> ..... 36
<b>6.4</b>	<b>Visual Examination</b> ..... 40
<b>6.5</b>	<b>Destructive Testing</b> ..... 40
<b>6.6</b>	<b>Nondestructive Testing (NDT)-Butt Welds Only</b> ..... 41
<b>6.7</b>	<b>Retesting and Disposition of Test Results</b> ..... 42
<b>6.8</b>	<b>Records</b> ..... 42
<b>7</b>	<b>Design and Preparation of a Joint for Production Welding</b> ..... 42
<b>7.1</b>	<b>General</b> ..... 42
<b>7.2</b>	<b>Alignment</b> ..... 42
<b>7.3</b>	<b>Use of Lineup Clamp for Butt Welds</b> ..... 43
<b>7.4</b>	<b>Bevel</b> ..... 43
<b>7.5</b>	<b>Weather Conditions</b> ..... 43
<b>7.6</b>	<b>Clearance</b> ..... 43
<b>7.7</b>	<b>Cleaning Between Beads</b> ..... 43
<b>7.8</b>	<b>Position and Roll Welding</b> ..... 43
<b>7.9</b>	<b>Identification of Welds</b> ..... 44
<b>7.10</b>	<b>Preheat, Interpass Temperature, Postheat, and PWHT</b> ..... 44
<b>8</b>	<b>Inspection and Testing of Production Welds</b> ..... 44
<b>8.1</b>	<b>Rights of Inspection</b> ..... 44
<b>8.2</b>	<b>Methods of Inspection</b> ..... 44
<b>8.3</b>	<b>Qualification of Inspection Personnel</b> ..... 44
<b>8.4</b>	<b>Certification of NDT Personnel</b> ..... 45
<b>9</b>	<b>Acceptance Standards for NDT</b> ..... 45
<b>9.1</b>	<b>General</b> ..... 45
<b>9.2</b>	<b>Rights of Rejection</b> ..... 45

## Contents

	Page
9.3 Radiographic Testing.....	46
9.4 Magnetic Particle Testing.....	52
9.5 Liquid Penetrant Testing.....	53
9.6 Ultrasonic Testing.....	54
9.7 Visual Acceptance Standards for Undercutting.....	56
9.8 Visual Acceptance Standards for Internal Concavity.....	56
10 Repair and Removal of Weld Defects.....	56
10.1 General.....	56
10.2 Repair Requirements.....	57
10.3 Repair Procedure.....	58
10.4 Repair Welder Qualification.....	67
10.5 Inspection of Repair Welding.....	71
10.6 NDT and Weld Repair Acceptance Criteria.....	71
11 Procedures for Nondestructive Testing (NDT).....	71
11.1 General.....	71
11.2 Magnetic Particle Testing Method.....	83
11.3 Liquid Penetrant Testing Method.....	83
11.4 Ultrasonic Testing Methods.....	83
12 Mechanized Welding with Filler Metal Additions.....	94
12.1 Acceptable Processes.....	94
12.2 Procedure Qualification.....	94
12.3 Record.....	95
12.4 Welding Procedure Specification.....	95
12.5 Essential Variables.....	99
12.6 Testing of Welded Joints-Butt Welds.....	102
12.7 Qualification of Welding Operators.....	107
12.8 Records of Qualified Operators.....	111
12.9 Inspection and Testing of Production Welds.....	111
12.10 Acceptance Standards for NDT.....	111
12.11 Repair and Removal of Defects.....	111
12.12 Radiographic Testing.....	111
12.13 Ultrasonic Testing.....	111
Annex A (normative) Alternative Acceptance Standards for Girth Welds.....	112
Annex B (normative) In-service Welding.....	137
Annex C (normative) Requests for Interpretation and Requests for Revision to the Document.....	161
Bibliography.....	163
<b>Figures</b>	
1 Sample Qualification Weld Report Form.....	15
2 Sample Welding Procedure Specification Form.....	16
3 Location of Test Butt Weld Specimens for Procedure Qualification Test.....	23
4 Tension Test Specimen.....	25
5 Nick Break Test Specimen.....	27
6 Dimensioning of Imperfections in Exposed Weld Surfaces.....	28
7 Root and Face Bend Test Specimen: Wall Thicknesses Less than or Equal to 0.500 in. (12.7 mm).....	28

## Contents

Page

8	Jig for Guided-bend Tests.....	29
9	Side Bend Test Specimen: Wall Thicknesses Greater than 0.500 in. (12.7 mm).....	30
10	Location of Nick Break Test Specimens: Branch and Fillet Weld Procedure and Welder Qualification Test Welds .....	30
11	Location of Nick Break Test Specimens: Branch and Fillet Weld Procedure and Welder Qualification Test Welds, Including Size-to-size Branch Connection Welder Qualification Test .....	31
12	Location of Test Butt Weld Specimens for Welder Qualification Test (Full Circumference).....	38
13	Location of Test Butt Weld Specimens for Welder Qualification Test (Half Circumference) .....	39
14	Inadequate Penetration Without High-low .....	46
15	Inadequate Penetration Due to High-low .....	46
16	Inadequate Cross Penetration .....	47
17	Incomplete Fusion at Root of Bead or Top of Joint.....	47
18	Incomplete Fusion Due to Cold Lap.....	48
19	Internal Concavity.....	48
20	Maximum Distribution of Gas Pockets: Wall Thickness (t) less than or equal to 0.500 in. (12.7 mm) .....	50
21	Maximum Distribution of Gas Pockets: Wall Thickness (t) Greater Than 0.500 in. (12.7 mm).....	51
22	Hardness Locations for Full-thickness Repair Procedure Qualification .....	64
23	Hardness Locations for External Partial-thickness Repair Procedure Qualification at Weld Centerline....	64
24	Hardness Locations for Cover Pass Repair Procedure at Weld Centerline .....	65
25	Hardness Location for Back Weld Repair or Internal Partial-Thickness Repair Procedure at Weld Centerline.....	65
26	Hardness Locations for Cover Pass Repair Procedure at Fusion Line.....	66
27	Hardness Locations for External Partial-Thickness Repair at Fusion Line.....	66
28	Calculation for Determining Beam Width .....	75
29	Example of Reference Standard for Manual Ultrasonic Testing.....	89
30	Example: Establishing Distance, Refracted Angle, and Velocity.....	89
31	Example: Attenuation and Transfer Procedure.....	90
32	Example: V Prep Reference Standard—Example Reflector Positioning.....	93
33	Example: J and K Prep Reference Standard—Reflector Positioning .....	93
34	Example—J Prep Reference Standard—Top View.....	93
35	Sample Coupon Test Report.....	96
36	Sample Welding Procedure Specification Form.....	97
37	Location of Test Butt Weld Specimens for Procedure Qualification Test.....	104
38	Tension Test Specimen .....	105
39	Root and Face Bend Test Specimen: Wall Thicknesses Less Than or Equal to 0.500 in. (12.7 mm) .....	106
40	Jig for Guided-bend Tests.....	106
41	Side Bend Test Specimen: Wall Thicknesses Greater than 0.500 in. (12.7 mm).....	107
A.1	Top View (Width in Circumferential Direction) of the Tensile Test Specimen.....	119
A.2	Charpy Specimen and V-notch Location for HAZ Impact Testing.....	120
A.3	Orientation of CTOD Test Specimen .....	121
A.4	Machining Objective for CTOD Test Specimen with Respect to Pipe Wall .....	121
A.5	Location of Notch for Weld Metal Specimen.....	122
A.6	Location of Notch for Heat-affected Zone Specimen .....	123
A.7	Option 1 Imperfection Limits for $CTOD \geq 0.010$ in. (0.25 mm).....	125
A.8	Option 1 Imperfection Limits for $0.004$ in. (0.10 mm) $\leq CTOD < 0.010$ in. (0.25 mm).....	125
A.9	Allowable Imperfection Size Curves Before and After Height Adjustment.....	128
A.10	Schematic Overview of the Option 2 Procedure .....	129
A.11	Criteria for Evaluation of Imperfection Interaction .....	136
B.1	Examples of Typical Temper Bead Deposition Sequences .....	138

## Contents

	Page
B.2 An Example of Procedure and Welder Qualification Test Assembly .....	143
B.3 Suggested Location of Test Specimens .....	144
B.4 Suggested Location of Test Specimens for Weld Deposition Repair .....	145
B.5 Example Macro Test Specimen—In-service Fillet Welds .....	147
B.6 Face Bend Test Specimen .....	149
B.7 Reinforcing Pad .....	153
B.8 Reinforcing Saddle .....	154
B.9 Encirclement Sleeve .....	154
B.10 Encirclement Tee .....	155
B.11 Encirclement Sleeve and Saddle .....	155
B.12 Encirclement Saddle .....	156

### Tables

1 Essential Variables for Qualification of Welding Procedure Specifications .....	20
2 Filler Metal Groups .....	22
3 Type and Number of Test Specimens for Procedure Qualification Test .....	24
4 Filler Metal Groups for Welder Qualification .....	33
5 Qualified Thickness Range for Single Qualification Test .....	35
6 Qualification Scope for Single Qualification Test Using a Branch Connection .....	36
7 Type and Number of Butt Weld Test Specimens per Welder for Welder Qualification Test and Destructive Testing of Production Welds .....	41
8 Maximum Dimensions of Undercutting .....	56
9 Essential Variables for Qualification of Repair Welding Procedure Specifications .....	60
10 Repair Type Qualification Matrix .....	60
11 Type and Number of Butt Weld Test Specimens per Repair Type for Repair Procedure .....	62
12 Repair Weld Maximum Hardness Values, Non-Sour Service, HV10 .....	67
13 Repair Welder Qualification Scope .....	68
14 Type and Number of Butt Weld Test Specimens per Repair Type for Repair Welder Qualification .....	69
15 Essential Variables for Repair Welders .....	70
16 Repair Welder Qualification Matrix .....	71
17 ASTM E747 Wire Type IQI Selection .....	77
18 ISO Wire Type IQI Selection .....	77
19 ASTM E1025 Hole Type IQI Selection .....	77
20 Essential Variables for the Qualification of Mechanized Welding Procedure Specifications .....	100
21 Filler Metal Groups .....	102
22 Type and Number of Test Specimens for Procedure Qualification Test .....	103
23 Type and Number of Test Specimens for Welding Operator Qualification Test .....	109
A.1 Essential Variables for Qualification of Welding Procedure Specifications in Accordance with this Annex .....	116
A.2 Allowed Range of Variation from the Targeted Mean Values for a Lot Defined by Controlled Chemical Composition .....	118
A.3 Initial Allowable Imperfection Size for $P_r = 0.825$ .....	127
A.4 Example Acceptance Table .....	128
A.5 Acceptance Limits for Buried Volumetric Imperfections .....	134
A.6 Acceptable Limits for Unrepaired Arc Burns .....	134
B.1 Essential Variables for Qualification of Welding Procedure Specifications in Accordance with this Annex .....	140
B.2 Essential Variables Applicable to Procedure and Welder Qualification .....	141
B.3 Type and Number of Specimens—In-service Welding Procedure Qualification Test .....	146

## Contents

	Page
<b>B.4 Weld Maximum Hardness Values, Non-Sour Service, HV10 .....</b>	<b>148</b>
<b>B.5 Type and Number of Test Specimens for Longitudinal Groove Seam—Welder Qualification .....</b>	<b>152</b>
<b>B.6 Essential Variables for Qualification of Repair Welding Procedure Specifications in Accordance with this Annex .....</b>	<b>158</b>
<b>B.7 Type and Number of Specimens—In-service Welding Repair Procedure Qualification Test.....</b>	<b>159</b>

# Welding of Pipelines and Related Facilities

## 1 Scope

This standard covers the gas and arc welding of butt, branch, and fillet welds in carbon and low-alloy steel pipe and piping components used in the compression, pumping, and transmission of crude petroleum, petroleum products, fuel gases, carbon dioxide, nitrogen, and, where applicable, covers welding on distribution systems. It applies to both new construction and in-service welding. The welding may be done by a shielded metal arc welding, submerged arc welding, gas tungsten arc welding, gas metal arc welding, flux-cored arc welding, plasma arc welding, or oxyacetylene welding process, or by a combination of these processes using a manual, semiautomatic, or mechanized welding technique or a combination of these techniques. The welds may be produced by position or roll welding or by a combination of position and roll welding.

This standard also covers the procedures for radiographic, magnetic particle, liquid penetrant, and ultrasonic testing, as well as the acceptance standards to be applied to production welds tested to destruction or inspected by radiographic, magnetic particle, liquid penetrant, ultrasonic, and visual testing methods.

The values stated in either U.S. customary units (USC) or metric units (SI) are to be regarded separately as standard. Each system is to be used independently of the other, without combining values in any way.

The figures depicted in this standard are not drawn to scale.

It is intended that all work performed in accordance with this standard meets or exceeds the requirements of this standard.

While this standard is comprehensive, it may not address all issues that may arise. The absence of guidance or requirements is not to be considered prohibitive to a particular activity or approach that is based upon sound engineering judgment. For example, other industry standards, reliable engineering tests and analyses, or established industry practices may provide useful reference to establish sound engineering judgment.

## 2 Normative References

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

API Specification 5L, *Specification for Line Pipe*

ASNT<sup>1</sup> SNT-TC-1A, *Recommended Practice for Personnel Qualification and Certification in Nondestructive Testing*

ASTM<sup>2</sup> E23, *Standard Test Methods for Notched Bar Impact Testing of Metallic Materials*

ASTM E165, *Standard Test Method for Liquid Penetrant Examination*

ASTM E384, *Standard Test Method for Knoop and Vickers Hardness of Materials*

ASTM E709, *Standard Guide for Magnetic Particle Testing*

ASTM E747, *Standard Practice for Design, Manufacture and Material Grouping Classification of Wire Image Quality Indicators (IQI) Used for Radiology*

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<sup>1</sup> American Society for Nondestructive Testing, 1711 Arlingate Lane, Columbus, Ohio 43228-0518, [www.asnt.org](http://www.asnt.org).

<sup>2</sup> ASTM International, 100 Barr Harbor Drive, West Conshohocken, Pennsylvania 19428, [www.astm.org](http://www.astm.org).