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| **Inspection Report** | | | | | **Post Inspection Memorandum** | | | | | | | |
| **Inspector/Submit Date:** | | |  | | **Inspector/Submit Date:**  **Compliance NC reference**  **Supervisor approval date:** | |  | | | | | |
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|  | | | | | | | | | | | | |
| **Name of Operator:** | |  | | | | | | | | **OPID #:** | |  |
| **Name of Unit(s):** | |  | | | | | | | | **Unit #(s):** | |  |
| **Records Location:** | |  | | | | | | | | | | |
| **Commodity:** Natural Gas | | | |  | | | | | | | | |
| **Inspection Type:** *(records, field or records and field)* | Welder qualification | | | | | **Inspection Date(s):** | |  | | | | |
| **PUC Representative(s):** | | |  | | | | | | **Field Days:** | |  | |

| **Summary of inspection** *include list of welder(s) and qual. dates; list company inspector(s) and engineer(s); list contractor(s)***:** |
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| **Comments and Findings** *include any**violations found, clarify all U, N/A and N/C checked***:** |
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| **Persons Interviewed** | **Titles** | | **Phone No.** |
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| **PUC Representative(s)**  **Party Conducting Qualification** | | **Inspection Date(s)** | |
| **Welders Qualified** | **Date Qualified** | | **Method of Qualification** |
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| **.13(c)** | **WELDING AND WELD DEFECT REPAIR/REMOVAL REQUIREMENTS** | **S** | **U** | **N/A** | **N/C** |
| --- | --- | --- | --- | --- | --- |
|  | .225 (a) Are welding procedures qualified under **Section 5 of API 1104** (19th ed.1999,  10/31/01 errata) or **Section IX of** **ASME Boiler and Pressure Code** (2004 ed. Inc addenda through July 1, 2005) by destructive test. *(List how company welds pick 1)* api 1104 or ASME Boiler |  |  |  |  |
|  | (b) Are welding procedures recorded in detail, including results of the qualifying tests? |  |  |  |  |
|  | Note: Alternate welding procedures criteria are addressed in API 1104 Appendix A, section A.3. |  |  |  |  |
|  | .227 (a) Are welders qualified according to **Section 6, API Std. 1104** or **Section IX, ASME Boiler and Pressure Vessel Code**? (Welders qualified under an earlier edition may weld but may not requalify under earlier edition) |  |  |  |  |
|  | (b) Welders may be qualified under **section I of Appendix C** to weld on lines that operate at **<**  **20% SMYS.** |  |  |  |  |
| .229 (a) Are all welders on compressor station piping and components qualified by means other than  nondestructive testing? |  |  |  |  |
| (b)&(c) Has the welder welded with this same process and has a weld been tested and found  acceptable according to **Section 6 or 9, API Std. 1104** at least twice each calendar year not to  exceed 7 ½ months? (Welders qualified under an earlier edition may weld but may not  requalify under earlier edition). For “low stress” welder requalification requirements, references 192.229(d). |  |  |  |  |
| .231 Is the welding operation protected from the weather conditions that could impair the quality of  the completed weld? |  |  |  |  |
| .233 Miter joints (**consider pipe alignment**) |  |  |  |  |
| .235 Are welding surfaces clean, free of foreign material, and aligned in accordance with the  qualified welding procedure? |  |  |  |  |
|  | **Repair and Removal of Weld Defects** |  | | | |
| .245 (a) Are cracks longer than 8% of the weld length removed? |  |  |  |  |
| For each weld that is repaired, is the defect removed down to clean metal and is the pipe  preheated if conditions demand it? |  |  |  |  |
| (b) Are the repairs inspected to insure acceptability? |  |  |  |  |
| If additional repairs are required, are they done in accordance with qualified written  welding procedures to assure minimum mechanical properties are met? |  |  |  |  |
|  | (c) Repair of a crack or any other defect in a previously repaired area must be in accordance  with a written weld repair procedure, qualified under **§192.225** |  |  |  |  |

| **.13(c)** | **WELD INSPECTIONS and NONDESTRUCTIVE TESTING REQUIREMENTS** | | **S** | **U** | **N/A** | **N/C** |
| --- | --- | --- | --- | --- | --- | --- |
| .241 Are inspectors performing visual inspection to check for adherence to the welding procedure  and the acceptability of welds as per Section 9, API Std. 1104, except for Subsection 9.7 for  depth of undercutting adjacent to the root bead?  Note: If the alternative acceptance criteria in API 1104 Appendix A are used, has the operator performed an Engineering Critical Assessment (ECA)? | |  |  |  |  |
| .243 (a) Is a detailed written **NDT** procedure established and qualified? | |  |  |  |  |
| (b) Are there records to qualify procedures? | |  |  |  |  |
| (c) Is the radiographer trained and qualified? (Level II or better) | |  |  |  |  |
| (d) Are the following percentages of each days field butt welds nondestructively tested: | |  | | | |
| (1) **10%** in **Class 1** locations. | |  |  |  |  |
| (2) **15%** in **Class 2** locations | |  |  |  |  |
| (3) **100%** in **Class 3** and **4** locations, river crossings, within railroad or public highway  ROWs, tunnels, bridges, overhead road crossings: however, if impracticable may test not  less than **90%**. | |  |  |  |  |
| (4) **100% at pipeline tie-ins.** | |  |  |  |  |
| (e) Is a sample of each welder’s work for each day nondestructively tested? (see code for  exceptions) | |  |  |  |  |
| (f) Do the radiograph records and daily reports show: | |  |  |  |  |
|  | ▪ Number of welds made. |  |  |  |  |
|  | ▪ Number of welds tested. |  |  |  |  |
|  | ▪ Number of welds rejected. |  |  |  |  |
|  | ▪ Disposition of rejected welds. |  |  |  |  |
|  | ▪ Is there a correlation of welds and radiographs to a bench mark? (Engineering station  or survey marker) |  |  |  |  |

| **Comments:** |
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