

Australian Standard[®]

Pipelines—Gas and liquid petroleum

Part 2: Welding

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 - Welding Technology Institute of Australia (WTIA)
-

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Australian Standard[®]

Pipelines—Gas and liquid petroleum

Part 2: Welding

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PREFACE

This Standard was prepared by the Joint Standards Australia/Standards New Zealand Committee ME-038, Petroleum Pipelines, to supersede AS 2885.2—2002.

The objective of this Standard is to provide requirements for the welding of pipeline designed and constructed in accordance with AS 2885.1.

The objective of this revision is to include editorial changes, and technical changes, which became necessary as a result of experience in the use of the Standard in the four years since the previous edition was issued. The most important changes that have been made are the following:

- (a) Material has been included defining the information that needs to be submitted in order that other welding processes that may be submitted for inclusion in the Standard may be considered.
- (b) Changes have been made to the application clause to clarify where the Standard is intended to be applied.
- (c) The methods and the requirements for qualifying welding procedures have been clarified.
- (d) A requirement for fracture toughness testing has been reintroduced for welds made to the requirements of Tier 1 where the welds are not made entirely with E4110 electrodes. (This requirement was inadvertently omitted from the 2002 edition.)
- (e) Important changes, corrections, and clarifications have been made to the essential variables.
- (f) The notched tensile test used in the previous Standard to determine whether overmatching is achieved has been deleted pending the performance of further research.
- (g) The acceptance criteria for the macro test have been clarified.
- (h) Changes have been made to the permissible limit and method of qualifying the limit of high-low.
- (i) Changes have been made to the methods used for non-destructive examination and to the method of interpreting and sentencing the depth of gas pores.
- (j) The previously accepted convention that root slag intrusions be sentenced as undercut has been reintroduced after being inadvertently lost.

The above list of changes is not intended to be complete. Users of the Standard should not rely upon the list in order to ascertain whether there have been changes made to the previous version of the Standard.

Statements expressed in mandatory terms in notes to tables and figures are deemed to be requirements of this Standard.

CONTENTS

	<i>Page</i>
SECTION 1 SCOPE AND GENERAL	
1.1 SCOPE	8
1.2 QUALIFICATION AND APPROVAL.....	9
1.3 RETROSPECTIVITY.....	10
1.4 REFERENCED DOCUMENTS	11
1.5 DEFINITIONS	11
1.6 ROUNDING OF NUMBERS	11
1.7 CARBON EQUIVALENT (CE).....	15
SECTION 2 MATERIALS	
2.1 GENERAL	16
2.2 CONSUMABLES.....	16
SECTION 3 POST-WELD HEAT TREATMENT AND POST-WELD COOLING	
3.1 POST-WELD HEAT TREATMENT.....	18
3.2 POST-WELD COOLING	18
SECTION 4 WELDING POSITIONS	
4.1 DESIGNATION	19
4.2 LIMITS OF QUALIFIED POSITIONS	19
SECTION 5 QUALIFICATION OF A WELDING PROCEDURE	
5.1 PURPOSE OF QUALIFYING A WELDING PROCEDURE.....	23
5.2 TYPES OF WELDS	23
5.3 DOCUMENTATION AND APPROVAL.....	24
5.4 METHODS OF QUALIFICATION.....	24
5.5 WELDING PROCEDURE SPECIFICATION.....	26
5.6 CHANGES IN A WELDING PROCEDURE	27
5.7 TEST PIECE SIZE	27
5.8 TEST PIECE MATERIAL	27
5.9 PREPARATION AND ASSEMBLY OF TEST PIECES.....	28
5.10 TEST CONDITIONS.....	28
5.11 SUPERVISION OF THE TEST WELD	28
5.12 IDENTIFICATION OF THE TEST WELD.....	28
SECTION 6 ASSESSMENT OF THE TEST WELD TO QUALIFY A WELDING PROCEDURE	
6.1 METHOD OF ASSESSMENT	35
6.2 VISUAL EXAMINATION.....	35
6.3 NON-DESTRUCTIVE EXAMINATION.....	35
6.4 DESTRUCTIVE TESTS.....	35
6.5 REPEATED TESTS	39
6.6 RECORD OF RESULTS	39
6.7 PERIOD OF VALIDITY	39
6.8 DISQUALIFICATION OF A QUALIFIED WELDING PROCEDURE.....	39
SECTION 7 QUALIFICATION OF A WELDER OPERATOR	
7.1 PURPOSE OF QUALIFYING A WELDER.....	41
7.2 CATEGORIES AND SCOPE OF WELDER OR OPERATOR QUALIFICATION..	41
7.3 METHODS OF QUALIFICATION.....	41

7.4	QUALIFICATION BY TESTING	41
7.5	ESSENTIAL VARIABLES FOR WELDERS AND OPERATOR	42
7.6	TEST PIECE	43
7.7	ASSEMBLY OF TEST PIECES	44
7.8	AUTOMATIC WELDING EQUIPMENT	44
7.9	CATEGORIES OF TEST WELDS	44
7.10	MAKING A TEST WELD	44
7.11	SUPERVISION OF A TEST WELD	44
7.12	IDENTIFICATION OF A TEST WELD	45

SECTION 8 ASSESSMENT OF TEST WELDS FOR WELDER OR OPERATOR QUALIFICATION

8.1	METHOD OF ASSESSMENT	46
8.2	VISUAL EXAMINATION	46
8.3	NON-DESTRUCTIVE EXAMINATION	46
8.4	REPEATED TEST	46
8.5	RECORD OF RESULTS	46
8.6	CLASSIFICATION OF CATEGORIES OF WELDS	47
8.7	PORTABILITY OF A WELDER'S OR OPERATOR'S QUALIFICATION	47

SECTION 9 WELDER OR OPERATOR QUALIFICATION AND DISQUALIFICATION

9.1	RECIPROCITY OF A WELDER'S OR OPERATOR'S QUALIFICATION	48
9.2	PERIOD OF VALIDITY	48
9.3	QUALIFICATION RECORD	48
9.4	DISQUALIFICATION OF A WELDER'S OR OPERATOR'S QUALIFICATION	48

SECTION 10 DESIGN OF A WELDED JOINT

10.1	GENERAL	49
10.2	BUTT WELDS BETWEEN COMPONENTS OF EQUAL NOMINAL WALL THICKNESS	49
10.3	BUTT WELDS BETWEEN COMPONENTS OF UNEQUAL NOMINAL WALL THICKNESS	49
10.4	REINFORCEMENT OF A BUTT WELD	49
10.5	FILLET WELD	49
10.6	WELDING OF THREADED JOINTS	50
10.7	REINFORCEMENT OF A WELDED BRANCH CONNECTION	50
10.8	REINFORCEMENT OF MULTIPLE OPENINGS	50
10.9	FORGED BRANCH FITTING	50
10.10	FABRICATED ELBOW OR BEND	50
10.11	EFFECT OF COMPONENTS UPON PIG PASSAGE	50
10.12	OFFSET OF LONGITUDINAL WELDS	51
10.13	DISTANCE BETWEEN WELDS	51

SECTION 11 PRODUCTION WELDS

11.1	WELDING PROCESS	54
11.2	WELDING EQUIPMENT	54
11.3	WELDER AND WELDING PROCEDURE	54
11.4	SUPERVISION OF WELDING	54
11.5	SAFETY IN WELDING	54
11.6	STORAGE AND HANDLING OF ELECTRODES, FILLER RODS AND FLUXES	54
11.7	WELDING IN ADVERSE CLIMATE CONDITIONS	54
11.8	PREPARATION FOR WELDING	55
11.9	METHOD OF MAKING THE WELD PREPARATION	55
11.10	ACCURACY OF ALIGNMENT	55

11.11 LINE-UP CLAMP	55
11.12 TACK WELDS.....	55
11.13 WORKING CLEARANCE.....	55
11.14 PLACEMENT OF WELD PASSES	55
11.15 ARC STRIKE AND ARC BURN	56
11.16 CLEANING.....	56
11.17 PEENING	56
11.18 INSERT PATCHING	56
11.19 PREHEAT AND INTERPASS TEMPERATURE.....	56
11.20 POST-WELD HEAT TREATMENT	56
11.21 IDENTIFICATION OF A PRODUCTION WELD.....	56
 SECTION 12 WELDING AND CUTTING ON A PIPELINE AFTER COMMISSIONING OR AFTER HYDROSTATIC TESTING	
12.1 GENERAL	57
12.2 SAFETY.....	57
12.3 HOT REPAIR OF LEAKING GAS-FILLED PIPELINES	57
12.4 WHERE GAS IS NOT ESCAPING.....	58
12.5 PIPELINES CONTAINING PETROLEUM FLUIDS OTHER THAN LEAN NATURAL GAS	58
12.6 QUALIFICATION OF WELDER(S)	58
12.7 QUALIFICATION OF SUPERVISORS AND INSPECTORS.....	58
12.8 FIT-UP BEFORE WELDING AND CUTTING	58
12.9 EXAMINATION AND TESTING	58
12.10 CRITERIA OF ACCEPTANCE	59
 SECTION 13 WELDING ONTO AN IN-SERVICE PIPELINE	
13.1 GENERAL—PIPELINE CONTAINING FLAMMABLE OR PRESSURIZED FLUID	60
13.2 PRECAUTIONS TO BE UNDERTAKEN BEFORE IN-SERVICE WELDING.....	60
13.3 LINING	60
13.4 SAFETY.....	60
13.5 INSPECTION BEFORE WELDING	60
13.6 ULTRASONIC EXAMINATION BEFORE WELDING.....	61
13.7 WELDING CONSUMABLES.....	61
13.8 HEAT INPUT.....	61
13.9 QUALIFICATION OF WELDING PROCEDURES	61
13.10 WELDING SEQUENCE	62
13.11 QUALIFICATION OF WELDER(S)	64
13.12 QUALIFICATION OF SUPERVISORS AND INSPECTORS.....	64
13.13 FIT-UP BEFORE WELDING	64
13.14 EXAMINATION OF TESTING.....	64
13.15 CRITERIA OF ACCEPTANCE	64
13.16 WELDING OF TEST ASSEMBLY.....	64
 SECTION 14 ASSESSMENT OF PRODUCTION WELDS AND REPAIR WELDS	
14.1 GENERAL	65
14.2 QUALIFICATION OF PERSONNEL	65
14.3 RESPONSIBILITIES	65
14.4 METHODS OF EXAMINATION	65
 SECTION 15 VISUAL EXAMINATION	
15.1 PURPOSE	66
15.2 METHOD OF EXAMINATION	66
15.3 EXTENT OF VISUAL EXAMINATION.....	66

15.4	CRITERIA OF ACCEPTANCE	66
15.5	UNDERCUT DEPTH MEASUREMENT	66
SECTION 16 NON-DESTRUCTIVE EXAMINATION		
16.1	PURPOSE	68
16.2	ORGANIZATIONS UNDERTAKING NON-DESTRUCTIVE EXAMINATION	68
16.3	QUALIFICATIONS OF PERSONNEL	68
16.4	METHODS	68
16.5	AMOUNT OF NON-DESTRUCTIVE EXAMINATION	68
16.6	EXEMPTION FROM RADIOGRAPHIC OR ULTRASONIC EXAMINATION	69
16.7	TIMING OF NON-DESTRUCTIVE EXAMINATION	70
SECTION 17 RADIOGRAPHIC EXAMINATION		
17.1	GENERAL	71
17.2	SAFETY AND PROTECTION FROM IONIZING RADIATION	71
17.3	DENSITY	71
17.4	IMAGE QUALITY	71
17.5	UNDERCUT DEPTH MEASUREMENT	72
17.6	GAS PORE DEPTH MEASUREMENT	73
17.7	INTERPRETATION AND ASSESSMENT OF RADIOGRAPHS	74
17.8	CRITERIA OF ACCEPTANCE	75
17.9	REPORT OF RADIOGRAPHIC EXAMINATION	75
17.10	RETENTION OF RADIOGRAPHS	75
SECTION 18 QUALIFYING A RADIOGRAPHIC PROCEDURE		
18.1	RADIOGRAPHIC PROCEDURE	76
18.2	METHOD OF QUALIFYING THE RADIOGRAPHIC PROCEDURE	76
18.3	TEST CONDITIONS	77
18.4	RADIOGRAPHIC PROCEDURE SPECIFICATION DOCUMENTATION	77
18.5	PERIOD OF VALIDITY	77
SECTION 19 ULTRASONIC EXAMINATION		
19.1	MANUAL ULTRASONIC EXAMINATION	78
19.2	MECHANIZED ULTRASONIC EXAMINATION	79
SECTION 20 MAGNETIC PARTICLE TESTING		
20.1	PURPOSE	82
20.2	METHOD	82
20.3	QUALIFICATION OF PERSONNEL	82
20.4	CRITERIA OF ACCEPTANCE	82
SECTION 21 DYE-PENETRANT TESTING		
21.1	PURPOSE	83
21.2	METHOD	83
21.3	QUALIFICATION OF PERSONNEL	83
21.4	CRITERIA OF ACCEPTANCE	83
SECTION 22 CRITERIA OF ACCEPTANCE FOR GIRTH WELD DISCONTINUITIES		
22.1	GENERAL	84
22.2	TIER 1 CRITERIA—WORKMANSHIP STANDARD	87
22.3	TIER 2 CRITERIA—GENERALIZED FITNESS-FOR-PURPOSE STANDARD	96
22.4	TIER 3 CRITERIA—ENGINEERING CRITICAL ASSESSMENT	101

SECTION 23 REPAIR OF AN UNACCEPTABLE WELD	
23.1	GENERAL 102
23.2	REPAIR METHODS 102
23.3	QUALIFICATION OF THE REPAIR WELDING PROCEDURE 102
23.4	INSPECTION 102
23.5	CRITERIA OF ACCEPTANCE 102
SECTION 24 REMOVAL OF AN ARC BURN	
24.1	GENERAL 103
24.2	REPAIR BY GRINDING 103
24.3	METHOD OF INSPECTION 103
24.4	CRITERIA OF ACCEPTANCE 103
24.5	CLEANING AFTER TESTING 103
SECTION 25 CUTTING OUT AN UNACCEPTABLE WELD OR AN ARC BURN 104	
SECTION 26 RECORDS 105	
APPENDICES	
A	ITEMS REQUIRING APPROVAL 106
B	LIST OF REFERENCED DOCUMENTS 108
C	SELECTION AND SPECIFICATION OF CELLULOSIC WELDING ELECTRODES 111
D	GUIDANCE ON 'GMAW' WELDING CONSUMABLES FOR MECHANIZED PIPELINE GIRTH WELDS 115
E	AVOIDANCE OF HYDROGEN ASSISTED COLD CRACKING (HACC) 116
F	EXAMPLE OF WELD PROCEDURE SPECIFICATION FORM 120
G	EXAMPLE OF WELDING PROCEDURE QUALIFICATION RECORD FORM 122

STANDARDS AUSTRALIA

**Australian Standard
Pipelines—Gas and liquid petroleum****Part 2: Welding**

SECTION 1 SCOPE AND GENERAL

1.1 SCOPE

This Standard specifies the minimum requirements for materials, welding consumables, welding processes, weld preparations, qualifications of welding procedures and personnel, and fabrication and inspection requirements for the construction and maintenance welding of carbon and carbon-manganese steel pipelines down to 3.2 mm wall thickness designed and constructed in accordance with AS 2885.1. The welding of corrosion-resistant alloy steel pipelines, or pipelines with wall thickness less than 3.2 mm, is not precluded but is not expressly covered by this Standard. The welding of such pipelines has to be given special consideration.

The welding may be done by a manual metal arc, submerged arc, gas tungsten arc, gas metal arc, flux cored arc, oxyacetylene, or by a combination of these using a manual, semi-automatic, or automatic 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.

Other processes may be submitted for inclusion in the Standard upon provision of the following information:

- (a) A description of the welding process.
- (b) A proposal on the essential variables.
- (c) A typical welding procedure qualification record and a welding procedure specification.
- (d) Weld inspection methods.
- (e) Types of weld discontinuities and their proposed acceptance limits.
- (f) Repair procedures.

This Standard is applicable to the welding of joints in or on pipelines, and the field welding of pipeline assemblies. This Standard may be applied to the factory fabrication of pipeline assemblies manufactured from pipes and fittings. See Figure 1.1 for examples.

NOTE The welding of fittings may present special difficulties when using typical pipeline welding procedures (see Appendix E).