API 1104 Weld Procedure And Qualification Subcommittee
Meeting January 21, 2016

Attendance - 39  Committee voting members 14
Number of Subcommittee members 23
Quorum was established

OLD BUSINESS
Discussed standing ballot and asked all voting members to vote

NEW BUSINESS
Discussed the presentation that Bill Bruce gave to the main committee regarding changing Sections 5 & 6 to clarify the some of the reoccurring issues from interpretations. It was decided that independent Task Groups would be set up to review the document and make proposed changes and work to have those changes ready for 2017 with meetings scheduled during 2016
- Briefly reviewed the September 2015 ITG meeting responses.
- Discussed the ITG recommendation from Jan 19th and changed the response slightly

3
- Discussions related to preheat. It was noted that for preheat that the AWS 3.0 defines preheat as all passes. Spent time reviewing and tabled it to go into the new task group
- A presentation was given regarding heat input calculations. The group will look at this for future inclusion in the sections.
- Question on single qualification for a welder on branch welds and the position they made the test in. This needs to be addressed in the future
- PHMSA regarding what “High Strength Pipe” meant in Section 6.5.5. Discussions around this and the task group will clean up the proposed wording and will present it to the subcommittee

6.5.5 - First paragraph –
For the bend test, if any specimen shows imperfections that exceed those allowed by 5.6.4.3 or 5.6.5.3, the welder shall be disqualified. Welds in high strength pipe may not bend to the full U-shape. **Welds might not bend to the full U shape in the jig before breaking. If a break occurs during the bending** these welds shall be considered acceptable if the specimens that crack are broken apart and their exposed surfaces meet the requirements of 5.6.3.3.

- A presentation of a suggested pipe material grouping chart be included in the API 1104. This grouping is extensive and it was decided to pursue this task. The grouping as presented will be revised prior
formal presentation Task groups were established to look at sections 5 and 6. One group will look at Section 5.4 Essential Variables only and another group will look at the remaining items in Section 5. A third group will look at Section 6. We will work to have the first round of items to look at by the end of May 2016 with a timeline to have a presentable outline for the 2017 meetings. Task groups are

Section 5.4 Essential Variables Task Group
Luke Ludwig – Chair
Brad Etheridge
Madana Kunjapur
Bob Wise
Mike Bernasek
Bob Lawless
Paul
Geoff Rogers – Corresponding member

Remaining sections in Section 5 Task Group
Antonio Howard - Chair
Brian Moidel
Kevin Wigren
Robert Punch

Section 6 Task Group
Bill Amend - Chair
R.J. Hammer
Geoff Rogers
Don Finkes