API-AGA JOINT COMMITTEE ON OIL & GAS PIPELINE FIELD WELDING PRACTICES

API 1104 Section 12 Task Group
Tuesday January 21, 2020
1:00 pm – 5:00 pm

Bob Huntley – Co-Chairman
RJ Hammer – Co-Chairman
Task Group Attendees:
39 people in attendance

- 17 Voting Members
- 22 Visitors

Open Action Items: Ballot Items 22nd Edition

- The task group met to discuss 9 comments (or suggested revisions)
  - Editorial 4
  - General 4
  - Technical 1
• The task group met to discuss 9 comments (or suggested revisions)

  Editorial  4  
  General    4  
  Technical  1  

• 9 Items Discussed

  Agree       6  
  Agree in Principle  1  
  Disagree    2  

• 2 Items need revision resulting from Section 5 session.
The text states "thickness lesser than 0.500" but the correct term should be less not lesser.

Correct a) to remove superscript

Correct b) to remove superscript

uncapitalize wall thickness

Change upper case W and T to lower case w and t in the words wall thickness

Paragraph 2 last sentence ends with "and the essential variables of Section 5 shall apply to the manual or semiautomatic portion of the weld." I would like to recommend that we exclude certain Table 1 essential variables that overlap/conflict with Table 19 essential variables. For example it should be clear that 12.5.2.2 Base Material should govern for the entire WPS and that the user need not follow 5.4.2.2 when manual or semiautomatic welding is used in conjunction with mechanized welding.

Include prescriptive language where Table 19 essential variables apply over Table 1 essential variables.

Agree in Principle.

Change wording in 12.2 second paragraph to add "except that 5.4.2.2 and 5.4.2.3 shall be replaced by 12.5.2.2 and 12.5.2.3"
<table>
<thead>
<tr>
<th>Suggestion</th>
<th>Action</th>
<th>Agreement</th>
</tr>
</thead>
<tbody>
<tr>
<td>Change to read &quot;and/or&quot;</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Does the method of calculation heat input need to be referenced as it is in Section 5.3.2.6.</td>
<td>Reference Section 5.3.2.6 on calculating heat input.</td>
<td>Disagree.</td>
</tr>
<tr>
<td>There are differences noticed between sections.</td>
<td>Consider aligning with Section 5 for 0.188&quot; wall thickness</td>
<td>Disagree.</td>
</tr>
<tr>
<td>Not all of the footnotes are properly assigned.</td>
<td>Ensure footnotes are correct.</td>
<td>Agree.</td>
</tr>
<tr>
<td>The qualification of welding equipment is not talked about within this section</td>
<td>Change the title to Qualification of Operators</td>
<td>Agree.</td>
</tr>
</tbody>
</table>
2 Items need revision resulting from Section 5 session

12.4 Welding Procedure Specification
12.4.2.5 Joint Design and Weld Shape and Size

The specification shall include a sketch or sketches of the joint that show the type of joint (e.g. V, U, K, etc.), the angle of bevel, and the size of the root face and root opening (with tolerances). The cap height and width beyond the groove shall be shown (with tolerances)
Figure 35-Sample Coupon Test Report Form
Figure 36-Sample Welding Procedure Specification Form

Revise the 6th column to show minimum preheat and maximum interpass temperature individually to be in alignment with discussions with Section 5.
QUESTIONS?