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TRANSPORTADORA DE GAS DEL PERU
CAMISEA NATURAL GAS AND NGL TRANSPORTATION SYSTEM



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AREA:L

WELDING JOINTS IDENTIFICATION

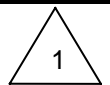
CONSTRUCTION SPECIFICATION

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2794-L-ME-00012

ESC. S/E

JOB: E100-50113



REVISION

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1.- PURPOSE

The purpose of this specification is to identify the welding joints, both pipeline and facilities.

2.- REFERENCES

- API 1104 19th ED. Para 7.10
- ASME Section V
- ASME B31.8
- ASME B31.4
- ASME IX

3.- PROCEDURE

The identification of the welding joints will increase from PK 0+000.

Welding Supervisor will be responsible for marking on the weld joint as follows:

- Number of welding joint
- Stamp of welder
- Welders located besides the RoW shall be marked in one side of the welding joint.
- Welders located besides the Ditch shall be marked on the opposite side of the welding joint.
- Marking will be placed at least 3” from the coating and according to the following schedule:

P = RoW	Z = Trench	P	Z	
		1	14	Root Pass
		5	6	Hot Pass
		8	10	Filler Cap
		8	10	CoverCap


All welding joints shall be identified with the prefix PK, which relates the kilometer (progressive) and the welding joint number, inside such kilometer (PK 7/45)

Pipes, pipe pups (nipples) and other pipeline sections will be identified (paint marked) : Pipe No., Heat No. and Wall thickness prior cut-off.

3.1 Cutting Identification

After the original identification prefix “CO” shall be added:

Example 1: PK 7/45 (original)	PK 7/45 CO (cut)
Example 2: PK 19	PK 19 CO

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3.2 Pup (Nipple) Identification

The first welding in the flow direction will be replaced by the same identification followed by “CO”. The second welding joint in the flow direction will be replaced by the same identification followed by the prefix “NCO”

Example 1: PK 7/45 (original) will be replaced by PK 7/45 CO and PK 7/45 NCO

Example 2: PK 19 will be replaced by PK 19 NCO

3.3 Pup (Nipple) identification (w/unequal wall thicknesses)

The identification for wall thickness changes larger than 1.6mm of the piping nominal wall thickness will be as follows:

Example 1: PK 7/45 NT PK 45 NTI

Example 2: PK 19 NT PK 19 NTI

3.4 Tie-Ins Identification

The letter “T” will be placed followed by the corresponding welding joint:

Example 1: PK 44/ T45/ 46

Example 2: PK 20/ T21/ 22

3.5 Final Tie-Ins Identification

Final Tie-Ins between hydraulic testing sections will be marked consecutively with prefix “FT”

Example: PK FT 7/45

3.6 Welding Joints for Valve Stations

Welding joints for valve stations will be marked with prefix “BV” followed by the station number and the welding joint number:


Example 1: BV 14/45

Example 2: BV 13/21

3.7 Scraper Traps Identification:

They shall include prefix “TS” followed by the scraper trap and the welded joint number:

Example: PK TS 2-12

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3.8 Special Crossings Identification

They shall include suffix “CR” and the name of the crossing. It shall be identified as in the example:

Example : PK 6/8 CR Name

