STANDARD SPECIFICATION
FOR
HIGH FREQUENCY WELDED (HFW)
LINE PIPE
(ONSHORE)
Abbreviations:

API  American Petroleum Institute
ASTM American Society for Testing and Materials
BM  Base Metal
CE  Carbon Equivalent
CVN Charpy V-Notch
FBH Flat Bottomed Holes
HAZ Heat Affected Zone
ID  Inside Diameter
KvL Charpy value in pipe longitudinal direction
KvT Charpy value in pipe transversal direction
MPQT Manufacturing Procedure Qualification Tests
MPS Manufacturing Procedure Specification
NDT Non Destructive Testing
OD/D Outside Diameter, Specified
\( t \) Wall Thickness, Specified
UT Ultrasonic testing
CONTENTS

<table>
<thead>
<tr>
<th>1</th>
<th>SCOPE .................................................................................................................</th>
<th>4</th>
</tr>
</thead>
<tbody>
<tr>
<td>3</td>
<td>NORMATIVE REFERENCES .................................................................................</td>
<td>4</td>
</tr>
<tr>
<td>6</td>
<td>PIPE GRADE, STEEL GRADE AND DELIVERY CONDITION ..................................</td>
<td>4</td>
</tr>
<tr>
<td>8</td>
<td>MANUFACTURING .......................................................................................... 5</td>
<td></td>
</tr>
<tr>
<td>9</td>
<td>ACCEPTANCE CRITERIA .................................................................................. 6</td>
<td></td>
</tr>
<tr>
<td>10</td>
<td>INSPECTION ................................................................................................... 12</td>
<td></td>
</tr>
<tr>
<td>11</td>
<td>MARKING ......................................................................................................... 17</td>
<td></td>
</tr>
<tr>
<td>12</td>
<td>COATINGS AND THREAD PROTECTORS .......................................................... 18</td>
<td></td>
</tr>
<tr>
<td>13</td>
<td>RETENTION OF RECORDS ........................................................................... 18</td>
<td></td>
</tr>
<tr>
<td>14</td>
<td>PRODUCTION REPORT .................................................................................. 18</td>
<td></td>
</tr>
<tr>
<td>15</td>
<td>INSPECTION OF FIELD TESTS &amp; WARRANTY .................................................... 19</td>
<td></td>
</tr>
</tbody>
</table>

Annex B .......................................................................................................................... 20
Annex C .......................................................................................................................... 22
Annex E .......................................................................................................................... 23

Annex Q (New) ............................................................................................................... 28
FIGURE: 10.2.4.9.1 ....................................................................................................... 29
FIGURE: 10.2.5.3 ........................................................................................................... 30
FIGURE: E.1 .................................................................................................................. 31
1 SCOPE

This specification establishes the minimum requirements for the manufacture helical welded steel of high frequency line pipe in accordance with the requirements of API (American Petroleum Institute) Specification 5L, Forty-Fifth Edition, 2012 and makes restrictive amendments to API Specification 5L. Unless modified and/or deleted by this specification, the requirements of API Specification 5L shall remain applicable.

The sections, paragraphs and annexes contained herein have the same numbering as that of API Spec 5L in order to facilitate reference. Additional requirements, which are not specified in API Spec 5L, have also been numbered and marked as "(New)".

The coverage by this specification is limited to line pipe to be used in onshore pipelines transporting non-sour hydrocarbons in liquid or gaseous phase. The product specification level for line pipe to be supplied as per this specification shall be "PSL2".

The Manufacturer shall have a valid license to use API Monogram in accordance with the requirements of Specification 5L, Forty-Fifth Edition, 2012 for line pipe as Product Specification Level PSL 2.

1.1 Pipe Size

(New) This Specification shall be applied to line pipe of size 41/2” OD thru 20” OD (both sizes included).

3 NORMATIVE REFERENCES

The latest edition (edition enforce at the time of issue of enquiry) of following additional references are included in this specification:

ASTM

ASTM E1 12-12: Standard Test Methods for Determining Average Grain size

6 PIPE GRADE, STEEL GRADE AND DELIVERY CONDITION

6.1 Pipe grade and steel grade

6.1.2 Line pipe supplied to this specification shall conform to Product Specification Level 2 (PSL 2) as given in Table 1 of this specification and consists of an alpha or alphanumeric designation that identifies the strength level of the pipe. The steel name (designating a steel grade), linked to the chemical composition of the steel, additionally includes a suffix that consists of a single letter (M) that identifies the delivery condition as per Table 3 of this specification.

Table 1 of API Spec 5L stands replaced by Table 1 of this specification.

<table>
<thead>
<tr>
<th>PSL</th>
<th>Delivery Condition</th>
<th>Pipe grade/ steel grade</th>
</tr>
</thead>
<tbody>
<tr>
<td>PSL 2</td>
<td>Thermomechanical rolled</td>
<td>BM, X42M, X46M, X52M, X56M,</td>
</tr>
<tr>
<td></td>
<td></td>
<td>X60M, X65M &amp; X70M</td>
</tr>
<tr>
<td>a</td>
<td>Deleted</td>
<td></td>
</tr>
<tr>
<td>b</td>
<td>The suffix (M) for PSL 2 grades belongs to steel grade</td>
<td></td>
</tr>
</tbody>
</table>
6.2 Delivery condition

6.2.2 The delivery condition for starting material shall be in accordance with Table 1 of this specification.

8 MANUFACTURING

8.1 Process of Manufacture

Pipe furnished to this specification shall be manufactured in accordance with the applicable requirements and limitations given in Table 2 of API Spec 5L and Table 3 of this specification.

Table 3 of API Spec 5L stands replaced by Table 3 of this specification.

<table>
<thead>
<tr>
<th>Type of pipe</th>
<th>Starting Material</th>
<th>Pipe forming</th>
<th>Pipe heat treatment</th>
<th>Delivery condition</th>
</tr>
</thead>
<tbody>
<tr>
<td>HFW</td>
<td>Thermo mechanical - rolled coil</td>
<td>Cold forming</td>
<td>Heat treating a of weld area only</td>
<td>M</td>
</tr>
</tbody>
</table>

a See clause 8.8 of this specification for applicable heat treatment

High frequency electric welding shall be performed with a minimum welding current frequency of 200 kHz. The welding system shall have an integrated control in which following data as a minimum shall be monitored:
- Welding Temperature
- Welding speed
- Current and voltage

Abutting edges of the coiled shall be milled or machined immediately before welding. The width of the coil shall be continuously monitored.

8.3 Starting Material

8.3.2 Line pipe furnished to this specification shall be made from steel produced in basic oxygen or electric arc furnace. Steel shall be made by continuous casting only.

8.3.3 The steel used for manufacture of pipe shall be fully killed and fine grained with ASTM grain size number 7 or finer as per ASTM E 112.

8.8 Treatment of weld seam in EW and LW pipes

8.8.2 LW pipe and PSL 2 HFW pipe

The weld seam and the entire heat affected zone (HAZ) shall be heat treated so as to stimulate a normalizing heat treatment in order to control the grain structure so that no untempered martensite remains in the weld seam and the HAZ, and the mechanical properties of heat treated zone approximate that of the parent metal.

Heat treatment temperature of the weld seam and the entire HAZ shall be continuously measured and recorded.
8.9 Cold sizing and cold expansion

8.9.1 Pipes furnished to this specification shall be non-expanded

8.11 Jointers

8.11.1 Jointers on pipes are not permitted.

9 ACCEPTANCE CRITERIA

9.2 Chemical composition

9.2.2 For pipes supplied as per this specification, the chemical composition of each heat of steel on product analysis shall be as given in Table 5 of this specification.

Table 5 of API Spec 5L stands replaced by Table 5 of this specification.

<table>
<thead>
<tr>
<th>Element</th>
<th>Mass fraction based upon heat and product analyses (%)</th>
</tr>
</thead>
<tbody>
<tr>
<td>C&lt;sup&gt;b&lt;/sup&gt;</td>
<td>0.16 max. (For Grade B to X56)</td>
</tr>
<tr>
<td></td>
<td>0.12&lt;sup&gt;f&lt;/sup&gt; max. (For Grade X60 to X70)</td>
</tr>
<tr>
<td>Si</td>
<td>0.15&lt;sup&gt;m&lt;/sup&gt; (New) min</td>
</tr>
<tr>
<td></td>
<td>0.45 max.</td>
</tr>
<tr>
<td>Mn&lt;sup&gt;b&lt;/sup&gt;</td>
<td>1.20 max. (For Grade B to X46)</td>
</tr>
<tr>
<td></td>
<td>1.40 max. (For Grade X52 &amp; X56)</td>
</tr>
<tr>
<td></td>
<td>1.60 max. (For Grade X60 &amp; X65)</td>
</tr>
<tr>
<td></td>
<td>1.70 max. (For Grade X70)</td>
</tr>
<tr>
<td>P</td>
<td>0.020 max.</td>
</tr>
<tr>
<td>S</td>
<td>0.015 max.</td>
</tr>
<tr>
<td>V</td>
<td>0.05 max. (For Grade B to X56)</td>
</tr>
<tr>
<td></td>
<td>0.08&lt;sup&gt;d&lt;/sup&gt; max. (For Grade X60 to X70)</td>
</tr>
<tr>
<td>Nb</td>
<td>0.05 max. (For Grade B to X56)</td>
</tr>
<tr>
<td></td>
<td>0.05&lt;sup&gt;d&lt;/sup&gt; max. (For Grade X60 to X70)</td>
</tr>
<tr>
<td>Ti</td>
<td>0.04 max. (For Grade B to X46)</td>
</tr>
<tr>
<td></td>
<td>0.04&lt;sup&gt;d&lt;/sup&gt; max. (For Grade X52 to X60)</td>
</tr>
<tr>
<td></td>
<td>0.06&lt;sup&gt;d&lt;/sup&gt; max. (For Grade X65 &amp; X70)</td>
</tr>
<tr>
<td>Al&lt;sup&gt;n(New)&lt;/sup&gt;</td>
<td>0.02&lt;sup&gt;a&lt;/sup&gt; (New) min</td>
</tr>
<tr>
<td></td>
<td>0.07 max.</td>
</tr>
<tr>
<td>Cr</td>
<td>0.20 max.</td>
</tr>
<tr>
<td>Mo</td>
<td>0.10 max.</td>
</tr>
<tr>
<td>Cu</td>
<td>0.35 max.</td>
</tr>
<tr>
<td>Ni</td>
<td>0.20 max.</td>
</tr>
<tr>
<td>N&lt;sup&gt;n(New)&lt;/sup&gt;</td>
<td>0.012 max.</td>
</tr>
<tr>
<td>B</td>
<td>0.0005 max.</td>
</tr>
</tbody>
</table>
Table 5 - Chemical composition for pipe

<p>| | | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>a</td>
<td>Based upon product analysis as per clause 9.2.4 and 9.2.5 of API Spec 5L, the CEpcm limits apply if C ≤ 0.12% and CEnw limits apply if C &gt; 0.12%. For pipes of all grades, sizes and wall thicknesses, Carbon Equivalent shall comply with the following limits:</td>
<td></td>
</tr>
<tr>
<td>b</td>
<td>Deleted</td>
<td></td>
</tr>
<tr>
<td>c</td>
<td>Deleted</td>
<td></td>
</tr>
<tr>
<td>d</td>
<td>Nb + V + Ti ≤ 0.15 %</td>
<td></td>
</tr>
<tr>
<td>e</td>
<td>Deleted</td>
<td></td>
</tr>
<tr>
<td>f</td>
<td>Deleted</td>
<td></td>
</tr>
<tr>
<td>g</td>
<td>Deleted</td>
<td></td>
</tr>
<tr>
<td>h</td>
<td>Deleted</td>
<td></td>
</tr>
<tr>
<td>i</td>
<td>Deleted</td>
<td></td>
</tr>
<tr>
<td>j</td>
<td>Deleted</td>
<td></td>
</tr>
<tr>
<td>k</td>
<td>Deleted</td>
<td></td>
</tr>
<tr>
<td>l</td>
<td>Deleted</td>
<td></td>
</tr>
<tr>
<td>(New) m</td>
<td>Minimum for Si is not applicable for Al killed steel.</td>
<td></td>
</tr>
<tr>
<td>(New) n</td>
<td>Al/N shall be minimum 2 (not applicable to titanium-killed steel or titanium-treated steel).</td>
<td></td>
</tr>
<tr>
<td>(New) o</td>
<td>Applicable for Al killed steel only.</td>
<td></td>
</tr>
</tbody>
</table>

9.2.3 For heat analysis and product analysis, all the elements listed in Table 5 of this specification shall be analyzed and reported, even if those are not purposely added but are present as residuals only. If alloying elements other than those specified in Table 5 of this specification are added to the steel, the limits of the additional elements shall be agreed with the Purchaser.

9.3 Tensile properties

9.3.2 The finished pipe shall conform to the requirements of Table 7 of API Spec 5L and as modified herein.

The actual yield strength shall be as close as possible to the specified minimum yield strength (SMYS) but in no case it shall exceed the limits specified here under:

<table>
<thead>
<tr>
<th>API Spec 5L Grade</th>
<th>Permissible in excess of SMYS, MPa (psi)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Upto and including X46</td>
<td>131 (19,000)</td>
</tr>
<tr>
<td>X52 to X60</td>
<td>125 (18,000)</td>
</tr>
<tr>
<td>X6S to X70</td>
<td>120 (17,400)</td>
</tr>
</tbody>
</table>

The ratio of body yield strength and body tensile strength of each test pipe on which yield strength and tensile strength are determined, shall not exceed 0.90.

The tensile strength of the weld shall be equal to or higher than the specified minimum tensile strength of the base metal.

The minimum elongation of base metal shall be determined in accordance with the formula given in foot note (f) of Table 7 of API Spec 5L, however, minimum elongation in no case shall be less than 20%.
9.6 Flattening test

Acceptance criteria for flattening tests shall be as follows:

a) For HFW pipe of grade ≥ X60 and \( t \geq 12.7 \) mm, there shall be no opening of the weld before the distance between the plates is less than 66% of the original outside diameter. For all other combinations of pipe grade and specified wall thickness, there shall be no cracks or breaks in either weld or parent metal before the distance between the plates is less than 50% of the original outside diameter. Dye penetrant testing shall be used to positively confirm the presence of crack, break or opening.

b) For HFW pipe with a \( D / t > 10 \), there shall be no cracks or breaks other than in the weld before the distance between the plates is less than 33% of the original outside diameter.

c) For all pipes, there shall be no evidence of lamination or burnt metal during the entire test before opposite walls of the pipe meet.

Note: The weld extends to a distance of 13 mm on each side of the weld line. The original outside diameter is the specified outside diameter.

9.8 CVN impact test for PSL 2 pipe

9.8.1 General

9.8.1.2 From the set of three Charpy V-notch impact test pieces, only one is allowed to be below the specified average absorbed energy value and shall meet the minimum single absorbed energy value requirement as specified in Table 8 of this specification.

9.8.2 Pipe body tests

9.8.2.1 The average (set of three test pieces) absorbed energy value (KvT) for each pipe body test shall be as specified in Table 8 of this specification, based upon full sized test pieces at a test temperature of 0°C (32°F) or at a lower test temperature as specified in the Purchase Order.

Table 8 of API Spec 5L stands replaced by Table 8 of this specification.

**Table 8 - CVN absorbed energy requirements for pipe body, weld and HAZ of PSL 2 pipe**

<table>
<thead>
<tr>
<th>Pipe Grade</th>
<th>Full-size CVN absorbed energy (KvT)(^{ab}) [J]</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Average</td>
</tr>
<tr>
<td>B</td>
<td>40</td>
</tr>
<tr>
<td>X42</td>
<td>40</td>
</tr>
<tr>
<td>X46</td>
<td>40</td>
</tr>
<tr>
<td>X52</td>
<td>40</td>
</tr>
<tr>
<td>X56</td>
<td>40</td>
</tr>
<tr>
<td>X60</td>
<td>42</td>
</tr>
<tr>
<td>X65</td>
<td>45</td>
</tr>
<tr>
<td>X70</td>
<td>50</td>
</tr>
</tbody>
</table>

\( a \) The required \( KvL \) (longitudinal direction test pieces) values shall be 50% higher than the required \( KvT \) values.

\( b \) Testing shall be performed at a test temperature of 0°C (32°F) or at a lower temperature as specified in the Purchase Order.
9.8.2.2 The minimum average (set of three test pieces) shear fracture area shall be at least 85 % with one minimum value of 75%, based at a test temperature of 0°C (32°F) or at a lower test temperature as specified in the Purchase Order.

9.8.3 **Pipe weld and HAZ tests**

The average (set of three test pieces) absorbed energy value (KvT) for each pipe weld and HAZ test shall be as specified in Table G of this specification, based upon full-size test pieces at a test temperature of 0°C (32°F) or at a lower test temperature as specified in the Purchase Order.

9.10 **Surface conditions, imperfections and defects**

9.10.1 *General*

9.10.1.2 All pipes shall be free from cracks, sweats, leaks and slivers. Pipe containing such defects shall be treated in accordance with clause C.3 b) or C.3 c) of API Spec 5L.

9.10.3 **Arc burns**

9.10.3.2 Arc burns shall be treated in accordance with clause C.3 b) or c) of API Spec SL. As a reference method for confirming the existence of an arc burn, the area shall be buffed with wire brush or sanding disc and etched with 10% solution of ammonium persulfate or a 5% solution of nital.

However, arc burns can be considered for acceptance, in case the same is re-crystallized by seam heat treatment. In such case, the Manufacturer shall demonstrate the re-crystallization to Purchaser by taking a sample as per clause 10.2.3.8 (New) of this specification.

9.10.4 **Laminations**

Any lamination or inclusion either extending into the face or bevel of the pipe or present within 50 mm from pipe ends shall be classified as defect. Pipes that contain such defects shall be rejected or cut back until no lamination or inclusion is present at the pipe ends and shall be treated in accordance with clause C.3 b) or C.3 c) of API Spec 5L.

9.10.5 **Geometric deviations**

9.10.5.2 For dents, the length in any direction shall be $\leq 0.5$ D and the depth, measured as the gap between the extreme point of the dent and the prolongation of the normal contour of the pipe, shall not exceed the following:

- a) 3.2 mm for cold-formed dents with sharp-bottom gouges and not encroaching upon the specified minimum wall thickness.
- b) 6.4 mm for other dents.
- c) 1 mm at the pipe ends, i.e. within a length of 100 mm at each of the pipe ends.
- d) Any dent on weld and heat affected zone (HAZ).

Dents that exceed the above specified limits shall be considered as defect and shall be treated in accordance with C.3 b) or C.3 c) of API Spec 5L. Acceptable cold-formed dents with sharp-bottom gouges shall be treated in accordance with clause C.2 of API Spec 5L & as modified in this specification.
9.10.6 **Hard Spots**
Any hard spot larger than 50 mm (2.0 in) in any direction and hardness greater than 248HV 10 shall be classified as defect and treated in accordance with clause C.3 b) or C.3 c) of API Spec 5L.

9.10.7 **Other surface imperfection**
Other surface imperfections found by visual inspection or non-destructive inspection shall be investigated, classified and treated as follows:

a) Imperfections that have a depth \( \leq 0.05t \) and do not encroach on the minimum specified wall thickness shall be classified as acceptable imperfections and shall be treated in accordance with Clause C.1 of this specification.

b) Imperfections that have a depth \( > 0.05t \) and do not encroach on the minimum specified wall thickness shall be classified as defects, and shall be dressed-out by grinding in accordance with Clause C.2 of API Spec 5L and as modified in this specification or shall be treated in accordance with Clause C.3 b) or C.3 c) of API Spec 5L.

c) Imperfections that encroach on the minimum specified wall thickness shall be classified as defects and treated in accordance with Clause C.3 of API Spec 5L.

9.11 **Dimensions, mass and tolerances**

9.11.3 **Tolerances for diameter, wall thickness, length and straightness**

9.11.3.1 The diameter and out-of-roundness shall be within the tolerances given in Table 10 of this specification. Table 10 of API Spec 5L stands replaced by Table 10 of this specification.

### Table 10 - Tolerances for diameter and out-of-roundness

<table>
<thead>
<tr>
<th>Specified outside diameter ((D)) mm (in)</th>
<th>Diameter tolerances (^d)</th>
<th>Out-of-roundness Tolerance (e)(new)</th>
<th>Pipe except the end (^a)</th>
<th>Pipe end (^{a,e})</th>
</tr>
</thead>
<tbody>
<tr>
<td>( D \leq 168.3 ) (6(^3/8))</td>
<td>( \pm 0.0075D )</td>
<td>-0.4 mm to +1.6 mm</td>
<td>0.020 (D)</td>
<td>0.015 (D) upto a maximum of 2.0 mm</td>
</tr>
<tr>
<td>( 168.3 ) (6(^3/8)) &lt; ( D \leq 273.1 ) (10(^3/4))</td>
<td>( \pm 0.0075D )</td>
<td>( \pm 0.005D )</td>
<td>0.020 (D)</td>
<td>2.0 mm</td>
</tr>
<tr>
<td>( D &gt; 273.1 ) (10(^3/4))</td>
<td>( \pm 0.0075D ) upto a maximum of ( \pm 3.0 ) mm</td>
<td>( \pm 1.6 ) mm</td>
<td>0.020 (D)</td>
<td>3.0 mm</td>
</tr>
</tbody>
</table>

\(^a\) The pipe end includes a length of 100 mm at each of the pipe extremities.

\(^b\) Deleted

\(^c\) The diameter tolerance and out-of-roundness tolerance shall apply on inside diameter. The inside diameter, based on circumferential measurement, shall be calculated as \(ID = (D - 2t)\). Diameter measurements shall be taken at both ends of the pipe with a circumferential tape.

\(^d\) For determining compliance to the diameter tolerances, the pipe diameter is defined as the circumference of the pipe in any circumferential plane divided by \(\pi\).

\(^e\) Out-of-roundness tolerances apply to maximum and minimum diameters as measured with bar gage, caliper, or device measuring actual, maximum and minimum diameters.
9.11.3.2 In addition to API requirements, the wall thickness of each pipe shall be checked along the circumference at both ends and at the mid location of pipe body at 12 0’ clock, 3 0’ clock, 6 0’ clock and 9 0’ clock positions. The tolerances for wall thickness shall be as given in Table 11 of this specification.

Table 11 of API Spec SL stands replaced by Table 11 of this specification.

<table>
<thead>
<tr>
<th>Wall thickness (mm)</th>
<th>Tolerances ( t ) (mm)</th>
</tr>
</thead>
<tbody>
<tr>
<td>( t &lt; 15.0 ) mm</td>
<td>+0.20 ( t )</td>
</tr>
<tr>
<td></td>
<td>-0.0 ( t )</td>
</tr>
<tr>
<td>( t \geq 15.0 ) mm</td>
<td>+3.0 mm</td>
</tr>
<tr>
<td></td>
<td>-0.0 mm</td>
</tr>
</tbody>
</table>

A Deleted  
b Deleted  
c The +ve tolerance for wall thickness does not apply to the weld area  
d See 9.13.2 of API Spec 5L and as modified herein for additional restrictions

9.11.3.3 All pipes shall be supplied with length between 11.5 m and 12.5 m. However pipe with length between 10.0 m and 11.5 m can also be accepted for a maximum of 5\% of the ordered quantity. The minimum average length of the entire ordered quantity in any case shall be 12.0 m. Overall length tolerance shall be (-) Zero and (+) One pipe length to complete the ordered quantity. Table 12 of API Spec 5L stands deleted.

9.11.3.4 The tolerances for straightness shall be as follows:

a) The total deviation from a straight line over the entire pipe length shall not exceed 12 mm, as shown in Figure 1 of API Spec 5L
b) The local deviation from straight line in 1.0 m (3.0 ft) portion at each pipe end shall be \( \leq 3.0 \) mm (0.120 in), as shown in Figure 2 of API Spec 5L.

9.12 Finish of pipe ends

9.12.5 Plain ends

9.12.5.6 During removal of inside burrs at the pipe ends, care shall be taken not to remove excess (New) metal and not to form an inside cavity on bevel. Removal of excess metal beyond the minimum wall thickness as indicated in clause 9.11.3.2 of this specification shall be a cause for re-beveling. In case root face of bevel is less than that specified, the pipe ends shall be re-beveled and rectification by filing or grinding shall not be done.

9.12.5.7 Bevel Protectors

(New) Both pipe ends of each pipe shall be provided with metallic or high impact plastic bevel protectors as per Manufacturer’s standard. Bevel protectors shall be of a design such that they can be re-used by coating applicator for providing on externally anti-corrosion coated pipes subsequent to coating of line pipe.

9.16 Residual Bend test

(New) All pipes shall meet the minimum acceptance criteria for Reverse Bend Test as follows:
A specimen which fractures completely prior to the engagement of mandrel and specimen as specified in clause 10.2.4.9 (New) of this specification, or which reveals cracks or ruptures in the weld or heat affected zone longer than 4 mm shall be rejected. Cracks less than 6 mm long at the edges of the specimen shall not be cause for rejection. Dye penetrant testing shall be used to positively confirm cracks or openings.

10  **INSPECTION**

10.1  **Types of inspection and inspection documents**

10.1.3  **Inspection documents for PSL 2 pipes**

10.1.3.1  Inspection certificate 3.2 in accordance with EN 10204 shall be issued for each dispatched pipe by Purchaser’s authorized representative.

10.2  **Specific inspection**

10.2.1  **Inspection frequency**

10.2.1.2  For PSL 2 pipe, the inspection frequency shall be as given in Table 18 of this specification. Table 18 of API Spec 5L stands replaced by Table 18 of this specification.

**Table 18 - Inspection frequency of pipe**

<table>
<thead>
<tr>
<th>SL. no.</th>
<th>Type of inspection</th>
<th>Frequency of inspection</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>Heat analysis&lt;sup&gt;a&lt;/sup&gt;</td>
<td>One analysis per heat of steel</td>
</tr>
<tr>
<td>2</td>
<td>Product analysis&lt;sup&gt;b&lt;/sup&gt;</td>
<td>Two pipes per lot (maximum 100 pipes) per heat</td>
</tr>
<tr>
<td>3</td>
<td>Tensile testing of the pipe body</td>
<td>Two pipes per test unit of not more than 100 pipes</td>
</tr>
<tr>
<td>4</td>
<td>Tensile testing of the helical seam weld of pipe&lt;sup&gt;c&lt;/sup&gt;</td>
<td>Two pipes per test unit of not more than 100 pipes</td>
</tr>
<tr>
<td>5</td>
<td>CVN impact testing of the pipe body</td>
<td>Once per test unit of not more than 50 pipes</td>
</tr>
<tr>
<td>6</td>
<td>CVN impact testing of the helical seam weld and HAZ of pipe&lt;sup&gt;c&lt;/sup&gt;</td>
<td>Once per test unit of not more than 50 pipes</td>
</tr>
<tr>
<td>7</td>
<td>Flattening test of pipe</td>
<td>As shown in Figure 6 a) of API Spec 5L</td>
</tr>
<tr>
<td>8</td>
<td>Reverse Bend Test (New)</td>
<td>Same as Figure 6 a) of API Spec 5L</td>
</tr>
<tr>
<td>9</td>
<td>Hardness testing</td>
<td>Any hard spot exceeding 50 mm in any direction</td>
</tr>
<tr>
<td>10</td>
<td>Hydrostatic testing</td>
<td>Each pipe</td>
</tr>
<tr>
<td>11</td>
<td>Weighting of pipe</td>
<td>Each pipe shall be measured and recorded</td>
</tr>
<tr>
<td>12</td>
<td>Wall thickness measurement&lt;sup&gt;d&lt;/sup&gt;</td>
<td>Each pipe</td>
</tr>
<tr>
<td>13</td>
<td>Pipe diameter and out of roundness&lt;sup&gt;d&lt;/sup&gt;</td>
<td>Each pipe</td>
</tr>
<tr>
<td>14</td>
<td>Length</td>
<td>Each pipe shall be measured and recorded</td>
</tr>
</tbody>
</table>
Table 18 - Inspection frequency of pipe

<table>
<thead>
<tr>
<th>SI. no.</th>
<th>Type of inspection</th>
<th>Frequency of inspection</th>
</tr>
</thead>
<tbody>
<tr>
<td>15</td>
<td>Straightness d</td>
<td>Each pipe</td>
</tr>
<tr>
<td>16</td>
<td>Tolerances for the weld seam d</td>
<td>Each pipe</td>
</tr>
<tr>
<td></td>
<td>a) Radial offset of coil edges</td>
<td></td>
</tr>
<tr>
<td></td>
<td>b) Height of flash</td>
<td></td>
</tr>
<tr>
<td></td>
<td>c) Depth of groove after trimming of inside flash</td>
<td></td>
</tr>
<tr>
<td>17</td>
<td>Visual inspection</td>
<td>Each pipe</td>
</tr>
<tr>
<td>18</td>
<td>Metallographic testing (including Vicker's hardness test)</td>
<td>At least one finished pipe from each lot of 50 pipes per heat or at least once per operating shift (12 hrs max.) whichever is occurring more frequently and whenever changes of grade, diameter or wall thickness are made and whenever significant excursions from operating heat treatment conditions are encountered and at the beginning of the production of each combination of specified outside diameter and specified wall thickness.</td>
</tr>
<tr>
<td>19</td>
<td>Other dimensional testing</td>
<td>Random testing, with the details left to the discretion of the manufacturer</td>
</tr>
<tr>
<td>20</td>
<td>Non-destructive inspection</td>
<td>In accordance with Annex E of API Spec 5L and as modified herein</td>
</tr>
</tbody>
</table>

<p>| | | |</p>
<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>a</td>
<td></td>
<td>Where the steel mill is not a part of an integrated pipe mill, heat analysis shall be reported by the Manufacturer prior to start of pipe production.</td>
</tr>
<tr>
<td>b</td>
<td></td>
<td>Pipes selected shall be such that one at the beginning of the heat and one at the end of the heat are also represented.</td>
</tr>
<tr>
<td>c</td>
<td></td>
<td>Pipe produced by each welding machine shall be tested shall be tested at least once per week.</td>
</tr>
<tr>
<td>d</td>
<td></td>
<td>Measurement shall be recorded at least 3 times per operating shift (12 hrs maximum).</td>
</tr>
<tr>
<td>e</td>
<td></td>
<td>&quot;Test unit&quot; is as defined in clause 4.62 of API Spec 5L.</td>
</tr>
</tbody>
</table>

10.2.2 **Samples and test pieces for product analysis**

Samples shall be taken, and test pieces prepared, in accordance with ISO 14284 or ASTM E1806. Samples used for product analysis shall be taken from finished pipes only. Samples for product analysis from coil may be used provided the traceability of samples is guaranteed.

10.2.3 **Samples and test pieces for mechanical tests**

10.2.3.1 **General**

In addition to API Spec 5L requirements, samples and test pieces for various types of tests shall be taken from Figure 5 c) of API Spec 5L and Figure 10.2.5.3.1 & 10.2.5.3.2 of this specification, whichever is applicable, and as given in Table 20 of this specification.

Table 20 of API Spec 5L stands replaced by Table 20 of this specification.
Table 20 - Number, orientation and location of test pieces per sample for mechanical tests

<table>
<thead>
<tr>
<th>Sample Location</th>
<th>Type of test</th>
<th>Number, orientation and location of test pieces per sample</th>
<th>Specified outside diameter, ( D ) mm (in)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Pipe body</td>
<td>Tensile</td>
<td>1L90</td>
<td>&lt; 219 mm (8.625 in)</td>
</tr>
<tr>
<td></td>
<td>CVN</td>
<td>3T90</td>
<td>≥ 219.1 mm (8.625 in)</td>
</tr>
<tr>
<td>Seam Weld</td>
<td>Tensile</td>
<td>--</td>
<td>1T180</td>
</tr>
<tr>
<td></td>
<td>CVN</td>
<td>3W and 3HAZ</td>
<td>3T90</td>
</tr>
<tr>
<td></td>
<td>Hardness</td>
<td>1W</td>
<td>(As shown in figure 10.2.5.3 of this specification)</td>
</tr>
<tr>
<td>Pipe body and weld</td>
<td>Flattening</td>
<td>As shown in figure 6 a) of API spec 5L</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Reverse Bend</td>
<td>As shown in figure 10.2.4.9.1 of this specification</td>
<td></td>
</tr>
</tbody>
</table>

* a  See Figure 5 b) of API Spec SL for an explanation of the symbols used to designate orientation and location.
  
* b  Test specimen shall be tested for ultimate tensile strength only

10.2.3.2 Test pieces for the tensile test

Rectangular test pieces, representing the full wall thickness of the pipe, shall be taken in accordance with ASTMA370 and as shown in Figure 5b) of API Spec SL.

Longitudinal tensile tests for pipe body with specified outside diameter, \( D < 219.1 \) mm (8.625 inch) shall be carried out on a strip specimen representing full wall thickness of the pipe prepared according to ASTM A370.

Transverse tensile test for pipe body with specified outside diameter, \( D \geq 219.1 \) mm (8.625 inch) shall be carried out on flattened rectangular test pieces.

For tensile test piece, both inside and outside flash of weld in excess of pipe wall thickness shall be removed from the test piece either by grinding or machining.

10.2.3.3 Test pieces for the CVN impact test

In addition to the API Spec 5L requirements, following shall also be applicable:

The test pieces shall be prepared in accordance with ASTM A370. Non-flattened test pieces shall be used. The axis of the notch shall be perpendicular to the pipe surface.

Charpy V-notch impact testing shall be performed on full-sized test pieces. However, if preparation of full size test piece is not possible, then standard sub-sized test pieces shall be prepared as per ASTM A370.

Lower pipe sizes wherein preparation of transverse sub-sized specimen is not possible, CVN impact testing shall be carried out on longitudinal test specimen [see Note 'a' of Table 8 of this specification].
10.2.3.7 **Test pieces for flattening test**

The test pieces shall be prepared in accordance with ISO 8492. The length of each test piece shall be > 60 mm.

Minor surface imperfections may be removed by grinding.

10.2.3.8 **Test pieces for Macrographic and metallographic tests**

Test piece for metallographic testing shall be taken transverse to the helical weld. The test piece extraction shall be as per Fig. 10.2.3.1 of this specification. The test piece shall be suitably ground, polished and etched to reveal the macro-structure.

10.2.3.9 **Test pieces for Residual Stress test**

Residual stress test shall be carried out as per clause 10.2.4.9 (New) of this specification.

10.2.4 **Test methods**

10.2.4.3 **CVN impact test**

The Charpy test shall be carried out in accordance with ASTM A370.

10.2.4.7 **Flattening test**

In addition to the API Spec SL requirements, following shall also be applicable:

The flattening test shall be carried out in accordance with ISO 8492.

10.2.4.9 **Residual bend test**

The mandrel shall be plunged into the test piece prepared in accordance with clause 10.2.3.9 (New) of this specification, with the weld in contact with the mandrel, to such a depth that the angle of engagement between mandrel and specimen reaches 60° as shown in figure 10.2.4.9.1 of this specification. If the combination of diameter & wall thickness of pipe and radius of mandrel is such that the angle of engagement cannot reach 60°, then the mandrel shall be plunged into the specimen until opposite walls of the specimen meet.

**Selection of Mandrel**

The reverse bend test shall be carried out with a mandrel, whose radius (R), or width (A) shall be calculated for any combination of diameter, wall thickness and grade with the following formula:

Where,

\[
A = 2R = \frac{1.4(D - t) t}{e(D - 2t) - 1.4 t} - t
\]

\[D\] - Specified outside diameter of pipe, mm
\[t\] - Specified wall thickness of pipe, mm
\[1.4\] - Peaking factor
\[e\] - Strain

Minimum value of ‘e’ shall be as per Table 23 of API Spec SL reproduced as below:

---

**Bharat Petroleum Corporation Limited**
10.2.5 Macrographic and metallographic tests

10.2.5.3 The test piece shall be visually examined using a minimum 40X magnification to provide evidence that heat treatment of weld zone is adequate and there is no untempered martensite or detrimental oxides from the welding process present along the weld seam. The metallographic examination shall be documented on micrographs (at 10X to 20X magnification). In case imperfections or defects are observed, it will become a cause for re-evaluation of welding parameters as deemed necessary by Purchaser's Representative.

Vickers hardness tests shall be carried out on each test piece taken for metallographic examination in accordance with ISO 6S07-1, at locations indicated in Fig. 10.2.5.3.2 of this specification. Indentation in the HAZ shall start as close to the fusion line as possible. The resulting Vickers hardness value at any point shall not exceed 248 HV10. The maximum difference in hardness between the base metal and any reading taken on the weld or heat affected zone shall be less than 80HV10. Modalities of retest shall be in accordance with clause 10.2.12.7 of API Spec 5L.

10.2.6 Hydrostatic test

10.2.6.1 Test pressure shall be held for a minimum period of 15 seconds for all sizes and grades of pipes.

10.2.6.2 In addition to the requirements of API Spec 5L, following shall also be applicable:

The pressure gauge used for hydrostatic testing shall have a minimum range of 1.5 times and maximum range of 4 times the test pressure. The test-pressure measuring device shall be calibrated by means of a dead-weight tester only. The test configuration shall permit bleeding of trapped air prior to pressurization of the pipe.

10.2.6.5 The test pressure for all sizes and grades of pipe shall be such that hoop stress (fibre stress) generated is at least 95% of SMYS, computed based on the Equation (6) indicated in clause 10.2.6.5S of API Spec SL. Table 26 of API Spec 5L stands deleted.

10.2.7 Visual inspection

10.2.7.1 Each pipe shall be visually examined for entire external surface and internal surface to the extent feasible and shall be free of defects in finished condition. Visual examination shall be carried out in a sufficiently illuminated area; minimum 1000 lx. If required
additional lights shall be used to obtain good contrast and relief effect between imperfections and backgrounds.

10.2.8 **Dimensional testing**

10.2.8.1 Diameter measurements shall be made with a circumferential tape only.

10.2.8.7 The measuring equipment requiring calibration or verification under the provisions of API Spec 5L shall be calibrated with manual instruments at least once per operating shifts (12 hours maximum). Such calibration records shall be furnished to Purchaser’s representative on request.

10.2.10 **Non-destructive inspection**

Non-destructive inspection shall be performed in accordance with Annex E of API Spec 5L and as modified herein.

10.2.11 **Reprocessing**

This clause of API Spec 5L stands cancelled

10.2.12 **Retesting**

10.2.12.1 **Recheck analyses**

Modalities of recheck analysis shall be as per API Spec 5L as applicable to the lot being tested (see Table 18 of this specification). However, during individual testing, each pipe shall be fully analyzed to meet the requirements of Table 5 of this specification.

10.2.12.9 **Residual bend retests**

(New) Reverse bend retest provisions shall be same as specified for flattening retests in clause 10.2.12.3 of API Spec 5L.

11 **MARKING**

11.1 **General**

11.1.1 Pipe manufactured in accordance with this specification shall be marked by the manufacturer as per the requirements of API Spec 5L and as modified herein. Marking shall be in English language and International System (SI) of Units.

11.1.5 Marking shall also include Purchase Order number, item number, pipe number and heat number.

11.2 **Pipe markings**

11.2.1 k) Actual length in meters and actual pipe weight in kg shall be marked.

(New)

11.2.2 c) Paint used for stencil marking shall withstand a temperature up to 250°C expected to be experienced during further external anti-corrosion coating operations of line pipe by coating applicator.

11.2.3 The pipe number shall be placed by cold rolling or low stress dot marking or vibro-etching on the outside surface of the pipe at an approximate distance of 50 mm from...
both ends. In case of non-availability of either cold rolling or low stress dot marking facility in pipe mill, an alternative marking scheme of a permanent nature may be proposed by the Manufacturer.

11.2.7 A colour code band shall be marked on inside surface of finished pipe for identification of pipes of same diameter but different wall thickness, as indicated in the Purchase Order.

The colour code band shall be 50 mm wide and shall be marked at a distance of 150 mm from the pipe ends.

12 COATINGS AND THREAD PROTECTORS

12.1.1 Unless otherwise specified in the Purchase Order, the pipes shall be delivered bare, free of any trace of oil, stain, grease and paint. Varnish coating shall be applied on the marking area. Bevels shall be free of any coating.

13 RETENTION OF RECORDS

In addition to the records indicated in API Spec 5L, the Manufacturer shall retain the records of all additional tests and calibration records mentioned in this specification including the hard copy records of ultrasonic testing carried out on pipe/coil as well as pipe ends.

14 PRODUCTION REPORT

The Manufacturer shall provide one electronic copy and six hard copies of production report in English language indicating at least the following for each pipe. International system of units (SI) shall be adopted.

- Pipe number
- Heat number from which pipe is produced
- Pipe length and weight.
- Pipe grade

The Manufacturer shall provide one electronic copy and six hard copies of acceptance certificates which shall include the results of all tests required as per this specification and performed on delivered material giving details of, but not limited to, the following:

- All test certificates as per clause 10.13 of API Spec 5L and as modified herein.
- Records of qualification of welders and procedures for repair welding.
- Certified reports of dimensional inspection, surface imperfections & defects.
- Data on test failures, rejected heats/lots, etc.
- All other reports and results required as per this specification.

The certificates shall be valid only when signed by the Purchaser's Representative. Only those pipes, which have been certified by the Purchaser's Representative, shall be dispatched from the pipe mill.

In the event of small quantities of pipes supplied against this specification, the production report may consist of only test certificates required as per clause 10.13 of API Spec 5L and as modified herein and other test reports/results required as per this specification.
15 INSPECTION OF FIELD TESTS & WARRANTY

(NeW) Purchaser shall be reimbursed by Manufacturer for any pipe furnished on this order that fails under field hydrostatic test if such failure is caused by a material/manufacturing defect in the pipe. The reimbursement cost shall include pipe, labour and equipment rental for finding excavating, cutting out and installation of replaced pipe in position. The field hydrostatic test pressure will not exceed that value which will cause a calculated hoop stress equivalent to 95 percent of specified minimum yield strength.

In case Manufacturer so desires, he will be advised at least two weeks in advance so that his Representative may witness the hydrostatic test in field, however, the testing and leak (if any) finding and repair operation shall not be postponed because of absence of the Manufacturer's Representative.
Annex B

Manufacturing Procedure Qualification for PSL 2 Pipe

B.1 INTRODUCTION

B.1.1 This annex specifies additional provisions that apply for the PSL 2 pipes ordered as per this specification.

B.1.2 Two lengths each of completely finished pipes from two different heats (i.e. a total of four pipe lengths) shall be selected at random for testing as per clause B.5.1 of this specification to verify that the manufacturing procedure results in the quality of pipes which are in complete compliance with this specification. The pipes thus tested shall be considered to be the test pipes required per heat or per lot as per relevant clauses of this specification.

These manufacturing procedure qualification tests (MPQT) shall be repeated upon any change in the manufacturing procedure as deemed necessary by Purchaser Representative. The manufacturing procedure qualification tests shall be carried out on pipes for each wall thickness, each diameter and each grade of steel. In addition, change of width of coil shall also call for manufacturing procedure qualification tests.

B.1.3 Verification of the manufacturing procedure shall be by qualification in accordance with clause B.3, B.4 and B.S of API Spec SL and as modified herein.

Note: In the event of small quantities of pipes ordered against this specification, like those for bends and other similar applications, as specifically called out in the Purchase Order, the manufacturing procedure qualification test as per clause B.51 of this specification shall not be carried out. Pipes in such case shall be accepted based on regular production tests.

B.3 CHARACTERISTICS OF THE MANUFACTURING PROCEDURE SPECIFICATION

Before pipe production commences, Manufacturing Procedure Specification (MPS) for manufacturing of pipes and Statistical process control charts shall be prepared by pipe manufacturer (including all information as per clause B.3 a), b) and e) of API Spec 5L) and submitted for approval of the Purchaser.

B.5 MANUFACTURING PROCEDURE QUALIFICATION TESTS (MPQT)

B.S.1 For the qualification of the manufacturing procedure, all tests & inspections specified in Table 18 and clause B.5.2 of this specification shall be conducted on all the pipes selected for testing as per clause B.1.2 of this specification.

B.5.2 The Manufacturer shall submit to Purchaser a report giving the results of all tests mentioned below. The report shall be agreed and signed by Purchaser Representative, prior to start of regular production.

The various tests to be conducted on each pipe shall be as follows. The test method and acceptance values shall be as per this specification unless specified differently in this Annex.

a. VIsual Examination

All pipes shall be examined visually for dimensional tolerances and apparent surface defects.
b. **Ultrasonic Examination**

The weld seam of all pipes shall be examined ultrasonically by automatic ultrasonic equipment.

c. **Mechanical Properties**

The mechanical properties of all pipes shall be tested and shall meet the requirements of this specification. Purchaser's Representative will select the places in pipe from where the test specimen shall be extracted.

The following tests shall be conducted:

i. **Flattening test**

Two (2) flattening test pieces shall be extracted; one test piece shall be tested with weld at 0° and other at 90°.

ii. **Tensile test**

Tensile tests shall be conducted on:

*For pipe with specified outside diameter, \( D < 219.1 \text{ mm} \) (8.625 inch):*

- Two (2) longitudinal test pieces from base metal

*For pipe with specified outside diameter, \( D \geq 219.1 \text{ mm} \) (8.625 inch):*

- Two (2) transverse test pieces from base metal
- Two (2) transverse test pieces from the longitudinal weld seam

iii. **Metallographic tests**

Six (6) weld cross-section test pieces, three (3) from each end of pipe joint shall be taken for metallographic examination. Two of these shall be tested for hardness at room temperature after etching.

iv. **CVN impact testing**

CVN impact test shall be performed on test pieces extracted as follows:

- Four sets of three (3) transverse specimen each from base metal
- One set of three (3) transverse specimen with weld in middle
- One set of three (3) transverse specimen with HAZ in middle.

The minimum average (set of three test pieces) absorbed energy value (KvT) at the test temperature specified in clause 9.8 and Table 8 of this specification shall be complied with for test pieces extracted from base metal, weld and HAZ.

v. **Fracture toughness testing**

Four (4) sets of CVN base metal test pieces shall be tested at -40°C, -10°C, 0°C and +20°C for shear area and absorbed energy to produce full transition curve. The minimum average (set of three test pieces) shear fracture area at the test temperature specified in clause 9.8 of this specification shall be complied with. For other temperatures, the value shall be for information only.
Annex C

Treatment of surface imperfections and defects

C.1 TREATMENT OF SURFACE IMPERFECTIONS

Surface imperfection not classified as defect shall be cosmetically dressed-out by grinding.

C.2 TREATMENT OF DRESSABLE SURFACE DEFECTS

C.2.3 Complete removal of defects shall be verified by local visual inspection and by suitable non-destructive inspection. To be acceptable, the wall thickness in the ground area shall be in accordance with clause 9.11.3.2 of this specification.
Annex E

Non-destructive inspection for other than sour service or offshore service

The Purchaser reserves the right to depute its Representative(s) to perform inspection and witness tests in all phases of manufacturing and testing starting from steel making to finished line pipe ready for shipment. Manufacturer shall comply with the provisions regarding inspection notice, plant access, compliance and rejection mentioned in the Annex Q (New) of this specification. The Manufacturer shall give the Purchaser reasonable notice of the starting date of normal production and the work schedule. Any action or omission on part of Purchaser's Representative shall not relieve the Manufacturer of his responsibility and obligation to supply material in strict accordance with this specification.

E.1 QUALIFICATION OF PERSONNEL

E.1.1 All personnel performing NDT activities shall be qualified in the technique applied, in accordance with latest edition of ISO 9712, ISO 11484 or ASNT No. ASNT-TC-1A or equivalent.

All NDT shall be performed in accordance with written procedures. These procedures shall have prior approval of the Purchaser.

Inspector Qualification

Acceptable qualification for NDT inspectors shall be as specified below:

(i) For UT

For UT, at least one Level III qualified inspector shall be available to the mill for overall supervision. Level III inspectors shall be ASNT Level III or ACCP Professional Level III and certified in applicable method.

A level II inspector is required for shift supervision, manual weld inspection and calibration of all systems (both manual and automated).

(ii) For all other NDT methods

Evaluation of indications: Level II & Level III inspector

E.3 METHODS OF INSPECTION

E.3.1 General

E.3.1.1 The weld seams of the pipe shall be inspected by ultrasonic methods (Refer Table E.1 of API Spec 5L) for full length (100%) for the entire thickness, using automatic ultrasonic equipment in accordance with clause E.5 of API Spec 5L and as modified in this specification.

E.3.1.3 Location of NDT equipment in the manufacturer's facility shall be such that final inspection of weld seam of pipe shall be performed after hydrostatic testing.

E.3.2 Pipe End Inspection - Welded Pipe

E.3.2.1 Pipe ends including weld at the pipe ends not covered by automatic ultrasonic equipment shall be inspected by manual ultrasonic equipment with same sensitivity and capability as automatic equipment, or, such non-inspected pipe end shall be cut-off. Records in accordance with E.5.4 of API Spec 5L shall be maintained.
E.3.2.3 Ultrasonic inspection in accordance with the method described in ISO 10893-8 shall be used to verify that the 50 mm (2.0 in) wide zone at each pipe end is free of any laminar imperfections in the circumferential direction.

E.3.2.4 Bevel face at each pipe end shall be magnetic particle inspected for the detection of laminar imperfections in accordance with ISO 10893-5.

E.5 ULTRASONIC AND ELECTROMAGNETIC INSPECTION

E.5.1 Equipment

E.5.1.2 In addition to the API Spec 5L requirements, all automatic ultrasonic equipment shall have an alarm device, which continuously monitors the effectiveness of the coupling. The equipment for the automatic inspection shall allow the localization of both longitudinal and transverse defects corresponding to the signals exceeding the acceptance limits of the reference standard. The equipment shall be fitted with a paint spray or automatic marking device and alarm device for areas giving unacceptable ultrasonic indications and probe de-coupling. All ultrasonic testing equipment shall be provided with recording device. In addition, an automatic weld tracking system shall be provided for correct positioning of the probes with respect to weld centre.

E.S.2 Ultrasonic and electromagnetic inspection reference standards

E.S.2.1 The reference standard (calibration pipe) shall have the same specified diameter and wall thickness as specified for the production pipe being inspected.

E.S.2.2 Reference standards shall be of sufficient length to permit calibration of ultrasonic inspection equipment at the speed to be used in normal production. The reference standard (calibration pipe) shall also be of the same material, type and have the same surface finish and heat treatment as the pipe being inspected.

E.S.2.3 Reference standards

E.S.2.3.1 Reference standards for pipe weld seam UT:

Reference standard shall contain as reference indicators i.e. machined notches or as given in Table E.7 of this specification. Table E.7 of API Spec 5L stands replaced by Table E.7 of this specification.

Table E.7 - Reference indicators

<table>
<thead>
<tr>
<th>Item</th>
<th>Reference Indicators</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Number of notches and orientation&lt;sup&gt;a&lt;/sup&gt;</td>
</tr>
<tr>
<td></td>
<td>OD</td>
</tr>
<tr>
<td>Weld Seam</td>
<td>1L</td>
</tr>
</tbody>
</table>

<sup>a</sup> The symbol indicates the orientation of the notch i.e. L = Longitudinal and T = Transverse. Reference indicators shall be located as per Figure E.1 of this specification.

<sup>b</sup> Dimensions of Notch type N5 shall be 0.05t x 50 mm x 1 mm (Depth x maximum Length x maximum width), where, 't' is the specified wall thickness. The depth tolerance is ± 15% of the specified notch depth or ± 0.05 mm, which ever is greater.
E.5.2.3.2 Reference standards for coil/pipe body UT:

(New)

Reference standard for the ultrasonic inspection of coil or pipe body (except the coil edges/pipe ends) shall contain continuous machined notch of following dimension:

a) width, \( w \) : 8 mm, with a tolerance +0.8/- 0.0 mm

b) depth, \( d \) : 0.25 \( t < d < 0.5 \ t \), where ‘\( t \)’ is the specified wall thickness

Reference standard for the ultrasonic inspection of coil edges/pipe ends shall have 6.4 mm (1/4 inch) diameter FBH of a depth 0.5 \( t \), where ‘\( t \)’ is the specified wall thickness

E.5.3 Instrument standardization

E.5.3.2 The instrument shall be calibrated with appropriate reference standard (refer E.5.2 of API Spec 5L and as modified herein) at following intervals:

- Once the beginning of each operating shift (12 hours maximum).
- Once in between of each operating shift i.e. 3 hrs to 4 hrs after the first
- Every time there is change in probes or working condition of the UT machine.
- Every time the running of the system gives rise to doubts on its efficiency.

If during the above calibration verification, it is found that the equipment has not functioned satisfactorily in the opinion of the Purchaser's Representative, all the pipes or coils already inspected after the previous verification shall be inspected again at Manufacturer's cost.

E.5.5 Acceptance limits

E.5.5.2 For ultrasonic inspection of pipe/coil, any imperfection that produces an imperfection greater than the acceptable limits shall be treated as following:

a) Locations showing indications above the allowable limits during automatic ultrasonic inspection shall be re-examined by manual ultrasonic method. If no defects are located during re-examination by manual UT, the original findings may be ignored. Additional scanning may be requested by Purchaser’s Representative to check questionable areas.

E.S.6 Disposition of defects found by ultrasonic and electromagnetic inspection

Disposition of any imperfection in pipe/coil that produces an indication greater than the acceptable limits as specified in Table E.9 (New) of this specification shall be classified as defect and shall be given disposition as specified in (e) or (f) of E 10 of API Spec 5L.

E.7 RESIDUAL MAGNETISM

E7.2 The longitudinal magnetic field shall be measured on all sizes of pipes. Measurement on pipe in stack shall not be considered valid. Such measurements shall be taken on the root face or square cut face of finished plain-end pipes.

E7.2 Measurements shall be made using Hall - effect gauss meter only.

E 7.4 Measurements shall be made on each end of a pipe for 5% of the pipes produced but at least once per 4 hr per operating shift (12 hrs maximum).

E 7.6 Four readings shall be taken approximately 90° apart around the circumference of each end of the pipe. The average of the four readings shall not exceed 2.0 mT (20 gauss) and no single reading shall exceed 25 mT (25 gauss). All residual magnetism measurements shall be recorded.
### E.8 LAMINAR IMPERFECTIONS IN THE PIPE BODY OF EW, SAW AND COW PIPES

The coil or the pipe body, except the coil edges or side of the pipe weld seam, shall be ultrasonically tested for laminations using an oscillating or straight running pattern of probes in accordance with ISO 10893-9 amended as follows:

- The distance between adjacent scanning tracks shall be sufficiently small to ensure detection of minimum allowed imperfection size. The minimum coverage during automatic ultrasonic inspection shall be $\geq 20\%$ of the coil surface uniformly spread over the area.

- Acceptance limit for laminar imperfection in the coil, except the longitudinal edges shall be as per Table E.9 (New) of this specification. Disposition of defects shall be as per clause E.5.6 of this specification.

Table 3 of ISO 10893-9 stands replaced by Table E.9 (New) of this specification.

### E.9 LAMINAR IMPERFECTIONS ALONG THE STRIP/ PLATE EDGES OR PIPE WELD SEAM OF EW, SAW AND COW PIPES

The coil edges (in case of inspection before pipe forming) or each side of pipe weld seam (in case of inspection after seam welding) shall be 100% ultrasonically inspected in accordance with ISO 10893-8 or ISO 10893-9, as applicable, amended as follows:

- UT shall be performed over 25 mm wide zone along each side of pipe weld seam or along each of the trimmed coil edges.

- Acceptance limit for laminar imperfection in the coil edges or side of the pipe weld seam shall be as per Table E.9 (New) of this specification. Disposition of defects shall be as per clause E.5.6 of this specification.

Table 2 of ISO 10893-8 or ISO 10893-9, as applicable, stands replaced by Table E.9 (New) of this specification.

#### Table E.9 - Acceptance criteria for laminar imperfection in coil/ pipe body (New)

<table>
<thead>
<tr>
<th>Location</th>
<th>Maximum Individual imperfection</th>
<th>Minimum imperfection size considered</th>
<th>Maximum Population Density $^a$</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Area $^b$ mm$^2$</td>
<td>Length $^b$ mm</td>
<td>Area $^b$ mm$^2$</td>
</tr>
<tr>
<td>Coils, except the longitudinal edges</td>
<td>1000</td>
<td>100$^d$</td>
<td>300</td>
</tr>
<tr>
<td>Longitudinal edges of the coil</td>
<td>500</td>
<td>40</td>
<td>-</td>
</tr>
</tbody>
</table>

*a Number of imperfections of size smaller than the maximum imperfection size and greater than the minimum imperfection size.

*b Length is the dimension at right angles to the scan track.

*c Width is the dimension parallel to the scan track.

*d Any planar imperfection which is not parallel to the coil surface is not acceptable.

*e For an imperfection to be larger than the minimum imperfection size, the minimum area, minimum length and minimum width given for the coil/pipe body, all have to be exceeded.
E.10 DISPOSITION OF PIPES CONTAINING DEFECTS

   c) The repaired area shall be 100% rechecked by magnetic particle or ultrasonic inspection to ensure complete removal of defects. However for repair of cosmetic type of defects, MPI may not be conducted if so directed by Purchaser's Representative on case to case basis. The pipes having a thickness less than the minimum allowed in accordance with this specification, after repair by grinding shall be treated for disposition in accordance with (e) or (t) of E 10 of API Spec 5L.

E.11 ROTARY ULTRASONIC INSPECTION OF PIPE (ALTERNATIVE METHOD)

   (New) As an alternative, full pipe may be ultrasonically inspected after welding of longitudinal seam by rotary ultrasonic testing method (pipe in rotating condition) in accordance with ISO10893-8 amended as follows:

   - The coverage area during ultrasonic inspection shall be 100 % of the pipe body including weld seam, sides of the weld seam and pipe ends.
   - The reference standard for the weld seam as per clause E.S.2.3.1 and Table E.7 of this specification shall be used for the rotary ultrasonic testing.

   If the manufacturer opts for rotary ultrasonic testing of full pipe in accordance with this clause, then, the requirement for ultrasonic inspection as per clause E.3.1.1, E.3.2.3, E.8 and E.9 of API Spec SL and as modified herein shall not be applicable.
Annex Q (New)

Purchaser Inspection

Q.1 INSPECTION NOTICE
Advance notice shall be given by the manufacturer prior to the start of production to the purchaser to inspect/witness the manufacturing activities including tests.

Q.2 PLANT ACCESS
The inspector representing the purchaser shall have unrestricted access, at all times while work of the contract of the purchaser is being performed, to all parts of the manufacturer's works that will concern the manufacture of the pipe ordered. The manufacturer shall afford the inspector all reasonable facilities to satisfy the inspector that the pipe is being manufactured in accordance with this specification. All inspections should be made at the place of manufacture prior to shipment, unless otherwise specified on the purchase order, and shall be so conducted as not to interfere unnecessarily with the operation of the works.

Q.3 COMPLIANCE
The manufacturer is responsible for complying with all of the provisions of this specification. The purchaser may make any investigation necessary to be satisfied of compliance by the manufacturer and any reject any material that does not comply with this specification.

Q.4 REJECTION
If the Purchaser Representative rejects pipes repeatedly for any recurring cause, this shall be adequate reason to refuse final inspection of subsequent pipes until the cause has been investigated and corrective action taken by the Manufacturer.
FIGURE: 10.2.4.9.1
REVERSE BEND TEST
FIGURE : 10.2.5.3

METALLOGRAPHIC SPECIMEN AND
LOCATIONS FOR HARDNESS MEASUREMENT
L1  Longitudinal inside notch (N10) at weld line
L2  Longitudinal outside notch (N10) at weld line

FIGURE: E.1
REFERENCE STANDARD FOR UT OF LONGITUDINAL WELD SEAM