

Welding of Pipelines and Related Facilities

API STANDARD 1104
TWENTY-SECOND EDITION, JULY 2021

ERRATA 1, SEPTEMBER 2023



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Foreword

This standard was prepared by a formulating committee that included representatives of the API, the American Gas Association (AGA), the Pipe Line Contractors Association (PLCA), the American Welding Society (AWS), and the American Society for Nondestructive Testing (ASNT), as well as representatives of pipe manufacturers and individuals associated with related industries.

The purpose of this standard is to present methods for the production of high quality welds through the use of qualified welders using approved welding procedures, materials, and equipment. Its purpose is also to present inspection methods to ensure the proper analysis of welding quality through the use of qualified technicians and approved methods and equipment. It applies to both new construction and in-service welding.

The use of this standard is entirely voluntary and is intended to apply to welding of piping used in the compression, pumping, and transmission of crude petroleum, petroleum products, fuel gases, carbon dioxide, and nitrogen and, where applicable, to distribution systems.

This standard represents the combined efforts of many engineers who are responsible for the design, construction, and operation of oil and gas pipelines, and the committee appreciatively acknowledges their wholehearted and valuable assistance.

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Shall: As used in a standard, “shall” denotes a minimum requirement in order to conform to the standard.

Should: As used in a standard, “should” denotes a recommendation or that which is advised but not required in order to conform to the standard.

May: As used in a standard, “may” denotes a course of action permissible within the limits of a standard.

Can: As used in a standard, “can” denotes a statement of possibility or capability.

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Suggested revisions are invited and should be submitted to the Standards Department, API, 200 Massachusetts Avenue, Suite 1100, Washington, DC 20001, standards@api.org.

Contents

	Page
1	Scope 1
2	Normative References 1
3	Terms, Definitions, Acronyms, and Abbreviations 2
3.1	Terms and Definitions 2
3.2	Acronyms and Abbreviations 8
4	Specifications 11
4.1	Equipment 11
4.2	Materials 12
5	Qualification of Welding Procedures with Filler Metal Additions 13
5.1	Procedure Qualification 13
5.2	Record 13
5.3	Welding Procedure Specification 13
5.4	Essential Variables 19
5.5	Welding of Test Joints-Butt Welds 22
5.6	Testing of Welded Joints-Butt Welds 22
5.7	Welding of Test Joints-Branch and Fillet Welds 30
5.8	Testing of Welded Joints-Branch and Fillet Welds 31
6	Qualification of Welders 32
6.1	General 32
6.2	Single Qualification 33
6.3	Multiple Qualification 36
6.4	Visual Examination 40
6.5	Destructive Testing 40
6.6	Nondestructive Testing (NDT)-Butt Welds Only 41
6.7	Retesting and Disposition of Test Results 42
6.8	Records 42
7	Design and Preparation of a Joint for Production Welding 42
7.1	General 42
7.2	Alignment 42
7.3	Use of Lineup Clamp for Butt Welds 43
7.4	Bevel 43
7.5	Weather Conditions 43
7.6	Clearance 43
7.7	Cleaning Between Beads 43
7.8	Position and Roll Welding 43
7.9	Identification of Welds 44
7.10	Preheat, Interpass Temperature, Postheat, and PWHT 44
8	Inspection and Testing of Production Welds 44
8.1	Rights of Inspection 44
8.2	Methods of Inspection 44
8.3	Qualification of Inspection Personnel 44
8.4	Certification of NDT Personnel 45
9	Acceptance Standards for NDT 45
9.1	General 45
9.2	Rights of Rejection 45

Contents

	Page
9.3 Radiographic Testing.....	46
9.4 Magnetic Particle Testing.....	52
9.5 Liquid Penetrant Testing.....	53
9.6 Ultrasonic Testing.....	54
9.7 Visual Acceptance Standards for Undercutting.....	56
9.8 Visual Acceptance Standards for Internal Concavity.....	56
10 Repair and Removal of Weld Defects.....	56
10.1 General.....	56
10.2 Repair Requirements.....	57
10.3 Repair Procedure.....	58
10.4 Repair Welder Qualification.....	67
10.5 Inspection of Repair Welding.....	71
10.6 NDT and Weld Repair Acceptance Criteria.....	71
11 Procedures for Nondestructive Testing (NDT).....	71
11.1 General.....	71
11.2 Magnetic Particle Testing Method.....	83
11.3 Liquid Penetrant Testing Method.....	83
11.4 Ultrasonic Testing Methods.....	83
12 Mechanized Welding with Filler Metal Additions.....	94
12.1 Acceptable Processes.....	94
12.2 Procedure Qualification.....	94
12.3 Record.....	95
12.4 Welding Procedure Specification.....	95
12.5 Essential Variables.....	99
12.6 Testing of Welded Joints-Butt Welds.....	102
12.7 Qualification of Welding Operators.....	107
12.8 Records of Qualified Operators.....	111
12.9 Inspection and Testing of Production Welds.....	111
12.10 Acceptance Standards for NDT.....	111
12.11 Repair and Removal of Defects.....	111
12.12 Radiographic Testing.....	111
12.13 Ultrasonic Testing.....	111
Annex A (normative) Alternative Acceptance Standards for Girth Welds.....	112
Annex B (normative) In-service Welding.....	137
Annex C (normative) Requests for Interpretation and Requests for Revision to the Document.....	161
Bibliography.....	163
Figures	
1 Sample Qualification Weld Report Form.....	15
2 Sample Welding Procedure Specification Form.....	16
3 Location of Test Butt Weld Specimens for Procedure Qualification Test.....	23
4 Tension Test Specimen.....	25
5 Nick Break Test Specimen.....	27
6 Dimensioning of Imperfections in Exposed Weld Surfaces.....	28
7 Root and Face Bend Test Specimen: Wall Thicknesses Less than or Equal to 0.500 in. (12.7 mm).....	28

Contents

Page

8	Jig for Guided-bend Tests.....	29
9	Side Bend Test Specimen: Wall Thicknesses Greater than 0.500 in. (12.7 mm).....	30
10	Location of Nick Break Test Specimens: Branch and Fillet Weld Procedure and Welder Qualification Test Welds	30
11	Location of Nick Break Test Specimens: Branch and Fillet Weld Procedure and Welder Qualification Test Welds, Including Size-to-size Branch Connection Welder Qualification Test	31
12	Location of Test Butt Weld Specimens for Welder Qualification Test (Full Circumference).....	38
13	Location of Test Butt Weld Specimens for Welder Qualification Test (Half Circumference)	39
14	Inadequate Penetration Without High-low	46
15	Inadequate Penetration Due to High-low	46
16	Inadequate Cross Penetration	47
17	Incomplete Fusion at Root of Bead or Top of Joint.....	47
18	Incomplete Fusion Due to Cold Lap.....	48
19	Internal Concavity.....	48
20	Maximum Distribution of Gas Pockets: Wall Thickness (t) less than or equal to 0.500 in. (12.7 mm)	50
21	Maximum Distribution of Gas Pockets: Wall Thickness (t) Greater Than 0.500 in. (12.7 mm).....	51
22	Hardness Locations for Full-thickness Repair Procedure Qualification	64
23	Hardness Locations for External Partial-thickness Repair Procedure Qualification at Weld Centerline....	64
24	Hardness Locations for Cover Pass Repair Procedure at Weld Centerline	65
25	Hardness Location for Back Weld Repair or Internal Partial-Thickness Repair Procedure at Weld Centerline.....	65
26	Hardness Locations for Cover Pass Repair Procedure at Fusion Line.....	66
27	Hardness Locations for External Partial-Thickness Repair at Fusion Line.....	66
28	Calculation for Determining Beam Width	75
29	Example of Reference Standard for Manual Ultrasonic Testing.....	89
30	Example: Establishing Distance, Refracted Angle, and Velocity.....	89
31	Example: Attenuation and Transfer Procedure.....	90
32	Example: V Prep Reference Standard—Example Reflector Positioning.....	93
33	Example: J and K Prep Reference Standard—Reflector Positioning	93
34	Example—J Prep Reference Standard—Top View.....	93
35	Sample Coupon Test Report.....	96
36	Sample Welding Procedure Specification Form.....	97
37	Location of Test Butt Weld Specimens for Procedure Qualification Test.....	104
38	Tension Test Specimen	105
39	Root and Face Bend Test Specimen: Wall Thicknesses Less Than or Equal to 0.500 in. (12.7 mm)	106
40	Jig for Guided-bend Tests.....	106
41	Side Bend Test Specimen: Wall Thicknesses Greater than 0.500 in. (12.7 mm).....	107
A.1	Top View (Width in Circumferential Direction) of the Tensile Test Specimen.....	119
A.2	Charpy Specimen and V-notch Location for HAZ Impact Testing.....	120
A.3	Orientation of CTOD Test Specimen	121
A.4	Machining Objective for CTOD Test Specimen with Respect to Pipe Wall	121
A.5	Location of Notch for Weld Metal Specimen.....	122
A.6	Location of Notch for Heat-affected Zone Specimen	123
A.7	Option 1 Imperfection Limits for $CTOD \geq 0.010$ in. (0.25 mm).....	125
A.8	Option 1 Imperfection Limits for 0.004 in. (0.10 mm) $\leq CTOD < 0.010$ in. (0.25 mm).....	125
A.9	Allowable Imperfection Size Curves Before and After Height Adjustment.....	128
A.10	Schematic Overview of the Option 2 Procedure	129
A.11	Criteria for Evaluation of Imperfection Interaction	136
B.1	Examples of Typical Temper Bead Deposition Sequences	138

Contents

	Page
B.2 An Example of Procedure and Welder Qualification Test Assembly	143
B.3 Suggested Location of Test Specimens	144
B.4 Suggested Location of Test Specimens for Weld Deposition Repair	145
B.5 Example Macro Test Specimen—In-service Fillet Welds	147
B.6 Face Bend Test Specimen	149
B.7 Reinforcing Pad	153
B.8 Reinforcing Saddle	154
B.9 Encirclement Sleeve	154
B.10 Encirclement Tee	155
B.11 Encirclement Sleeve and Saddle	155
B.12 Encirclement Saddle	156

Tables

1 Essential Variables for Qualification of Welding Procedure Specifications	20
2 Filler Metal Groups	22
3 Type and Number of Test Specimens for Procedure Qualification Test	24
4 Filler Metal Groups for Welder Qualification	33
5 Qualified Thickness Range for Single Qualification Test	35
6 Qualification Scope for Single Qualification Test Using a Branch Connection	36
7 Type and Number of Butt Weld Test Specimens per Welder for Welder Qualification Test and Destructive Testing of Production Welds	41
8 Maximum Dimensions of Undercutting	56
9 Essential Variables for Qualification of Repair Welding Procedure Specifications	60
10 Repair Type Qualification Matrix	60
11 Type and Number of Butt Weld Test Specimens per Repair Type for Repair Procedure	62
12 Repair Weld Maximum Hardness Values, Non-Sour Service, HV10	67
13 Repair Welder Qualification Scope	68
14 Type and Number of Butt Weld Test Specimens per Repair Type for Repair Welder Qualification	69
15 Essential Variables for Repair Welders	70
16 Repair Welder Qualification Matrix	71
17 ASTM E747 Wire Type IQI Selection	77
18 ISO Wire Type IQI Selection	77
19 ASTM E1025 Hole Type IQI Selection	77
20 Essential Variables for the Qualification of Mechanized Welding Procedure Specifications	100
21 Filler Metal Groups	102
22 Type and Number of Test Specimens for Procedure Qualification Test	103
23 Type and Number of Test Specimens for Welding Operator Qualification Test	109
A.1 Essential Variables for Qualification of Welding Procedure Specifications in Accordance with this Annex	116
A.2 Allowed Range of Variation from the Targeted Mean Values for a Lot Defined by Controlled Chemical Composition	118
A.3 Initial Allowable Imperfection Size for $P_r = 0.825$	127
A.4 Example Acceptance Table	128
A.5 Acceptance Limits for Buried Volumetric Imperfections	134
A.6 Acceptable Limits for Unrepaired Arc Burns	134
B.1 Essential Variables for Qualification of Welding Procedure Specifications in Accordance with this Annex	140
B.2 Essential Variables Applicable to Procedure and Welder Qualification	141
B.3 Type and Number of Specimens—In-service Welding Procedure Qualification Test	146

Contents

	Page
B.4 Weld Maximum Hardness Values, Non-Sour Service, HV10	148
B.5 Type and Number of Test Specimens for Longitudinal Groove Seam—Welder Qualification	152
B.6 Essential Variables for Qualification of Repair Welding Procedure Specifications in Accordance with this Annex	158
B.7 Type and Number of Specimens—In-service Welding Repair Procedure Qualification Test.....	159

Welding of Pipelines and Related Facilities

1 Scope

This standard covers the gas and arc welding of butt, branch, and fillet welds in carbon and low-alloy steel pipe and piping components used in the compression, pumping, and transmission of crude petroleum, petroleum products, fuel gases, carbon dioxide, nitrogen, and, where applicable, covers welding on distribution systems. It applies to both new construction and in-service welding. The welding may be done by a shielded metal arc welding, submerged arc welding, gas tungsten arc welding, gas metal arc welding, flux-cored arc welding, plasma arc welding, or oxyacetylene welding process, or by a combination of these processes using a manual, semiautomatic, or mechanized 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.

This standard also covers the procedures for radiographic, magnetic particle, liquid penetrant, and ultrasonic testing, as well as the acceptance standards to be applied to production welds tested to destruction or inspected by radiographic, magnetic particle, liquid penetrant, ultrasonic, and visual testing methods.

The values stated in either U.S. customary units (USC) or metric units (SI) are to be regarded separately as standard. Each system is to be used independently of the other, without combining values in any way.

The figures depicted in this standard are not drawn to scale.

It is intended that all work performed in accordance with this standard meets or exceeds the requirements of this standard.

While this standard is comprehensive, it may not address all issues that may arise. The absence of guidance or requirements is not to be considered prohibitive to a particular activity or approach that is based upon sound engineering judgment. For example, other industry standards, reliable engineering tests and analyses, or established industry practices may provide useful reference to establish sound engineering judgment.

2 Normative References

The following referenced documents are indispensable for the application of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

API Specification 5L, *Specification for Line Pipe*

ASNT¹ SNT-TC-1A, *Recommended Practice for Personnel Qualification and Certification in Nondestructive Testing*

ASTM² E23, *Standard Test Methods for Notched Bar Impact Testing of Metallic Materials*

ASTM E165, *Standard Test Method for Liquid Penetrant Examination*

ASTM E384, *Standard Test Method for Knoop and Vickers Hardness of Materials*

ASTM E709, *Standard Guide for Magnetic Particle Testing*

ASTM E747, *Standard Practice for Design, Manufacture and Material Grouping Classification of Wire Image Quality Indicators (IQI) Used for Radiology*

¹ American Society for Nondestructive Testing, 1711 Arlingate Lane, Columbus, Ohio 43228-0518, www.asnt.org.

² ASTM International, 100 Barr Harbor Drive, West Conshohocken, Pennsylvania 19428, www.astm.org.