Inspection Packs for AAS-2AG2

ID	Fluid Category	Enhanced Inspection	Notes
2	Normal Fluid	Minimum 5% random RT or UT selected so that work from each welder is included in inspection. Longitudinal weld coverage will be 1-1/2" and selected with butt welds to maximize coverage of intersections.\r\nHydrotest and 20% MT for carbon steel or 20% PT for stainless steel\r\nVisual inspection; random for mechanical joints, 5% during fabrication, 100% of longitudinal welds	If the two attaching field welds cannot be hydrotested then the alternative ASME B31.3 tests are to be used.\r\n1. 100% radiography on the untested welds\r\n2. 100% LPI or 100% MPI on the untested welds\r\n3. Sensitive leak test ie. Snoop test at 5 psig\r\n4. Fatigue and vibration analysis for the untested welds.\r\nAll four of the above steps are required in order to waive the hydrotest. Only the two field welds are exempt all other welds are to be hydrotested.
3	Innocuous	Visual inspection is to be completed to the extent to satisfy the examiner that B31.3 conformance is met.\r\nLesser of 5 psig or 25% of Design Pressure snoop test of random mechanical joints for vapour / gas commodities. 5% MT for carbon steel pipe \r\n5% PT for stainless steel pipe	In service visual inspection to be completed during initial commissioning of lines.
4	Hazardous	Minimum 20% random RT or UT of all circumferential welds, shot locations will be selected to maximize coverage of longitudinal welds. Longitudinal weld coverage must be 1-1/2" of weld length. Welds shall be selected so that work of each welder is included in examination.\r\nHydrotest and 20% MT for carbon steel or 20% PT for stainless steel Visual inspection; random for mechanical joints, 5% during fabrication, 100% of longitudinal welds	If the two attaching field welds cannot be hydrotested then the alternative ASME B31.3 tests are to be used.\r\n1. 100% radiography on the untested welds\r\n2. 100% LPI or 100% MPI on the untested welds\r\n3. Sensitive leak test ie. Snoop test at 5 psig\r\n4. Fatigue and vibration analysis for the untested welds.\r\nAll four of the above steps are required in order to waive the hydrotest. Only the two field welds are exempt all other welds are to be hydrotested.