



MOODY INTERNATIONAL

**API
MULTIPLE STENCILING of
LINE PIPE**

**Presented to
NAPCA
August 20, 2009**



SUBJECT at ISSUE

What is it ??????

The common practice by pipe manufacturers of certifying to and marking of pipe to several API grades (as long as pipe has been tested to and meets requirements of all grades marked)



WHY THE CONCERN NOW ?

- In recent years there seems to have been some confusion among some auditors that it was not allowed by API.
- Other auditors accepted the practice
- API 5L doesn't clearly address the issue



RECENT ACTIVITY

- API WG formed
- Lively discussions ensured
- Input received from various sources
- At June API meetings WG presented a proposal to MAG and to TGLP
- Proposal was revised and passed votes to go to Letter Ballot



WHAT DOES LETTER BALLOT MEAN

- Formal ballot sent to voting members of TGLP
- Voting members consist of users, mfgs, consults.
- Votes are submitted with or without comments
- All negative votes and comments must be addressed



THEN WHAT HAPPENS ??

- Votes received by API
- If Letter Ballot passes and all negatives are satisfied, then issue is scheduled for publication
- If Letter Ballot fails, issue may be dropped or returned to TGLP for further revision and re-balloting



PROPOSAL For DUAL MARKING OF LINEPIPE

This proposal is out for letter ballot to eligible members of the TGLP

- 11.4 – Marking of Pipe to Multiple Grades:

Marking of pipe to multiple grades is permitted only by agreement between the purchaser and the manufacturer within the following limits:



PROPOSAL (cont.)

- Pipe may have multiple markings within the following grade ranges:
 - \leq L290 (X42)
 - $>$ L290 (X42) to $<$ L415 (X60)

For L415 (X60) and above, each grade is marked individually.



PROPOSAL (cont.)

- The manufacturer is responsible to assure that the pipe conforms to all requirements of each of the certified grades. This allows pipe to be used as any of the grades individually.
- Pipe shall be marked to only one PSL level.



PROPOSAL (cont.)

- Where pipe is marked to multiple grades, a single inspection document shall be issued referencing the grade combination as marked on the pipe. The inspection document may contain a specific statement that pipe conforms to each grade individually.



PROPOSAL (cont.)

- After delivery of the pipe, no remarking or re-certification of the pipe to a different grade shall be permitted.
- Pipe shall only be re-graded and re-marked under the manufacturer's control. Certificates for re-graded pipe may only be issued by the pipe manufacturer.



DIFFERENT INTERESTS

- DISTRIBUTORS
 - Commercial
 - Reduces area of stock yard
- MANUFACTURERS
 - Commercial
 - Destination for Excess inventory
- USERS
 - Availability of supply
 - May have regulatory issues
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EXAMPLES OF REGULATORY ISSUES

- Weld Procedure Qualification
- Welder Qualification
- DOT Rules
- State Rules



FOR INSTANCE - - - - -

- Major Electrode Mfg's group their rod's in ranges of yield strengths

Mfg. A	Mfg. B	Mfg. C
A25, A, B, X42, X46 → x56	X52 → X65 X42 → X70	X52 → X65 X56 → X70
X60 → X70	X56 → X70	X65 → X90



OTHER “FOR INSTANCES”

- User A - “Pipeline operators are required to validate all their utilized welding procedures including items such as what grades of materials are welded---”
- “ a change in base material constitutes an essential variable. When welding pipe of two separate materials, the procedure for the higher strength shall be used.”



OTHER “FOR INSTANCES” (cont.)

- USER B – “The State of XXXX argues that when we deal with multi-graded pipe we must use the procedure for the highest grade pipe in the line (for the entire line--- exp. if an X52/X60 pipe is put into an X52 line, all welds must be qualified as X60)



MORE “FOR INSTANCES” (cont.)

- USER C - “----relating to field bending of pipe. When laying pipe parallel to an existing pipeline (inside the original ROW) it may be difficult to cold bend the multiple stenciled pipe and maintain the required pipe separation. If the original installed pipeline was Grade B and the parallel pipe is ordered as Grade B but arrives with higher grade certification, then fittings or induction bends may have to be used”.



SO WHERE DO WE GO FROM HERE ??

- Letter ballot is out, but voting closes on September 23
- Only voting members of the API TGLP receive a ballot and can vote.



POSSIBLE OUTCOME

- May fail. Many mfgs think proposal is not liberal enough.
- Some users think their regulatory situations are not satisfied.
- Most users feel that if proper wording is in place, which they can cite as authority, then they find multiple stenciling as acceptable (revisions in API 1104 ?)



END !























































