City of Duluth, Minnesota

Public Works & Utilities Department - Engineering Division

Standard Construction Specifications - 2019 Edition

APPENDIX A

STANDARD SPECIFICATIONS FOR HIGH PRESSURE GAS MAINS, TRANSMISSION LINE AND SERVICE INSTALLATION, WELDING QUALIFICATIONS, AND QUALIFICATIONS FOR JOINING PE PIPE

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Gas Utility Standard Details are in Appendix D Standard Detail Drawings of this Construction Standards manual.

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10.01 Installation Criteria for Distribution Line Valves (192.181)

A. At a spacing so as to isolate less than 500 customers for sectionalizing valves and 100 customers for operating valves

B. At plastic branch mains off steel mains

C. At branch mains off 4" or larger mains

D. At inlet and outlet piping of regulator station to permit its operation in the event of an emergency at the station. Valves shall be installed at a minimum distance of 25 feet from regulator station unless designated otherwise by Engineering.

E. At each end of 2" mains, which loop between larger feeder mains.

10.02 Valve Types/Uses

TYPE	USES
PE Valves, ball type all sizes	Underground on PE mains and/or services
Steel gate valves with resilient seating	Below grade as line valves or branch valve off a steel system Meter stop valves - 2" plus Above grade at regulator station
Steel gate valves without resilient seating	Bypass facilities
Steel Plug Valves	Above grade as meter stop valves
Steel Ball Valves	Above grade at regulator station Below grade as line valve or branch valve

Existing valves, when replaced, should conform to the above policy.

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14.01 General

This section of the Standard Specifications establishes requirements and policies for the materials of construction of high pressure gas distribution systems operating at pressures ranging from 1 psig to 275 psig and a transmission line which operates at a pressure ranging from 550 psig to 974 psig. Low pressure gas mains and services, the remaining systems of which were abandoned in 1992, are only specified to the extent of involvement with high pressure construction, such as conflicts in location, abandonments, etc.

All excavation, backfilling and restoration and horizontal direction drilling required for the construction of high pressure gas distribution systems shall be performed in accordance with the City of Duluth, Minnesota Public Works & Utilities Department – Engineering Division, Standard Construction Specifications, most current edition.

For contracted projects, these specifications also establish responsibilities between the Contractor and the Department for supplying materials and providing labor and equipment for installations. The Plans and Special Provisions may change these responsibilities for particular projects; therefore, it is essential that those parts of the documents be carefully reviewed for each project, since they take precedence over this Standard Specification.

14.02 General Material Requirements

All materials required for this work shall be new material conforming to requirements of the referenced specifications for the class, kind, type, size, grade, and other details indicated in the Contract. Unless otherwise indicated, all required materials shall be furnished by the Contractor. If any options are provided for as to type, grade, or design of the material, the choice shall be limited as may be stipulated in the Plans, Proposal, or Special Provisions.

All manufactured products shall conform in detail to such standard design drawings as may be referenced or furnished in the Plans. Otherwise, the Department may require advance approval of material suppliers, product design, or other unspecified details as it deems desirable for maintaining adopted standards.

14.03 High Pressure Gas Pipe

All pipe furnished for gas main and branch line installation shall be of the type, kind, size, and class indicated for each particular line segment as shown in the Plans and designated in the Contract Items.

Normal pressure range is 10 psig to 275 psig for distribution and 550 to 974 psig for transmission.

Minimum number of samples taken for acceptance/rejections testing by the Department will be based on the current Military Standard 105 D entitled SAMPLING PROCEDURES AND TABLES FOR INSPECTION BY ATTRIBUTES. The sampling plan consists of: General Inspection Level II, Single Sampling, Normal Inspection, and an Acceptable Quality level of 2.5; failure to pass this inspection is the minimum basis for rejection of lot. Rejected material shall be returned to supplier at supplier's expense.

Supplier shall certify with each shipment that the material shipped has been inspected by the supplier and conforms to the Material Specification.

14.03.01 Steel Gas Main Pipe (1 1/2"-16") and Fittings

One and one half inch and two-inch steel gas main pipe shall be class 1; grade B; seamless, electric weld or submerged-arc weld steel pipe, conforming to the 42nd Edition of API Standard 5 L Specifications for Line Pipe and as specified herein.

Steel gas main pipe in diameters 3-inch through 16-inch shall be class 1; grade B, X42, or X52; seamless, electric weld or submerged-arc weld steel pipe, conforming to the 42nd Edition of API Standard 5 L Specifications for Line Pipe and as specified herein.

Pipe shall be in double random lengths. Ends beveled 30º, +5º, -0º for butt weld joining.

The minimum wall thickness and the standard wall thickness are specified in the following table. Standard wall thickness should be used unless specified otherwise by the Engineering Division. Changes to wall thickness shall be based upon the calculations contained in O&M Section 03.04.

Nominal Size Inches)	OD (Inches)	Least Nominal Wall Thickness (Inches)	Standard Wall Thickness (inches)
1 1/2	1.900	0.145	0.145
2	2.375	0.154	0.154
3	3.500	0.216	0.216
4	4.500	0.237	0.237
6	6.625	0.280	0.280
8	8.625	0.250	0.322
10	10.750	0.250	0.365
12	12.750	0.250	0.375
16	16.000	0.250	0.375

Exterior pipe coating shall be factory applied thin film epoxy or fusion bonded epoxy (FBE). Thin film epoxy shall be from manufacturer's chart below. Thin film epoxy shall be applied according to the manufacturer's standards and recommendations, and

conforming to the National Association of Pipe Coating Applicator's Specification 12-78-90. Coating thickness shall be 12 mils with a maximum tolerance of minus 2 mils.

Any pipe installed by directional drilling shall be coated with a sacrificial or abrasive top coat. The top coat is required to be minimum thickness of 0.030" (30 mils). Coating shall be factory applied unless approved by Engineer. This coating shall be from manufacturer's chart below.

Manufacturer	Base FBE	Abrasive Top Coat
Lilly Industries	2000	2040
3M Scotchkote	206N or 6233	6352
NapGuard	2500	2610
Power Lone Star		Powercrete

For field applied coatings and sleeve information see 14.06.04 & 14.06.05.

Exterior coating shall be cutback on pipe ends as follows:

For nominal sizes thru 12" - 2" cutbacks

Markings indicating the standard to which the pipe was manufactured shall be applied to the coated pipe.

Manufacturer, when requested, shall furnish ladle and check analysis of all heats used to make this pipe. For butt weld Class I pipe, supplier shall certify that the material furnished has been analyzed and meets the chemical requirements of API STD 5 L.

14.03.02 Steel Gas Main Pipe (3/4” and 1”) and Fittings

Steel pipe in 3/4” and 1” diameter shall be black, standard weight, Schedule 40, conforming to the requirements of ASTM A106 or A53, and manufactured by a domestic supplier.

14.03.03 Polyethylene Pipe (1/2", 1", 2", 3", 4”) and Fittings

Polyethylene pipe shall be made from Phillips TR-418, "Gulf" HID 9300-T, or Plexco P23BC resins (orange or yellow). Materials shall conform to ASTM D-2513, PE2708 or PE2406. Pipe and fittings shall conform to ASTM Specification D-2513 "Standard Specification for Thermoplastic Gas Pressure Pipe, Tubing, and Fittings."

Pipe weights and thicknesses shall be as follows:

Size	OD	SDR No.	Minimum Wall Thickness	Lbs/Ft
1/2" CTS	0.625"	7	0.090"	0.06

1" CTS	1.125”	11.5	0.099”	0.14
1" CTS	1.125"	9.3*	0.121"	0.17
2" IPS	2.375"	11.0	0.216"	0.63
3" IPS	3.500"	11.5	0.304"	1.33
4” IPS	4.500”	11.5	0.391”	2.20

*SDR 9.3 pipe shall not be used for new installations.

Pipe shall be marked as shown in the current ASTM D-2513 standard; and in addition, the resin manufacturer's material designation shall be marked on the pipe. If any data marked on the pipe is coded, the supplier shall furnish the code key. Pipe shall be new or stored for a period of time that does not exceed the manufacturer’s recommended maximum period of exposure, regardless of the method of storage. (192.321g)

Polyethylene fittings shall be the socket fusion type conforming to the current ASTM D-2683 Specification "Socket Polyethylene Fittings for SDR 11 Polyethylene Pipe, or Butt Fusion pipe conforming to the current ASTM D-3261 specification."

An electrofusion type coupling or saddle fitting shall be manufactured by Georg Fischer Central Plastics. Other electrofusion fittings may be substituted upon approval of the Engineer.

Polyethylene service tee fittings shall be saddle fusion type or electrofusion type by Georg Fischer Central Plastics or Engineer approved equal conforming to the current ASTM D-2513 standard.

Cutter punch size for 1" CTS service taps shall be 11/16" or larger.

Straight lengths of 2" or 3" pipe will only be permitted when specified or with approval of the Engineer, where it is determined to be most suitable for a particular installation.

Coiled pipe or tubing delivered to the work site shall have the ends capped.

Pipe Size	Minimum Coil ID	Maximum Coil OD	Maximum Coil Width
1/2"	30"	44"	6"
1"	44"	48"	12"
2"	48"	78"	41"
3"	70"	102"	44"
4”	70”	-	45”

Pipe strapping shall be made of plastic or other non-metal material. Coils shall have strapping around the interior portions of the coil to prevent partial coils from collapsing, as well as a sufficient number of straps around the completed coil. Polyethylene pipe and fitting shall be Driscoplex, Continental, Dura-Line, or Phillips or approved equal.

14.03.04 Polyethylene Pipe (6” & 8”) and Fittings

Polyethylene pipe shall be made from "Phillips TR-418" (orange or yellow), "Gulf HID 9300-T" (orange or yellow), or "Plexco P23BC" (orange or yellow) resins. Material shall conform to ASTM D-2513, PE2708 or PE2406. Pipe and fittings shall conform to ASTM Specification D-2513 "Standard Specification for Thermo-plastic Gas Pressure Pipe, Tubing and Fittings".

Pipe weights and thicknesses shall be as follows:

Size	OD	SDR No.	Minimum Wall Thickness	Lbs/Ft
6"	6.625±.011	11.5	0.581"	4.7
8"	8.625±.011	11.5	0.750"	7.99

Pipe shall be marked as shown in the current ASTM D-2513 standard, and, in addition, the resin manufacturer's material designation shall be marked on the pipe. If any data marked on the pipe is coded, the supplier shall furnish the code key. Pipe shall be new or stored for a period of time that does not exceed the manufacturer’s recommended maximum period of exposure. Pipe older than the maximum period of exposure will still be accepted if the manufacturer or supplier submits written documentation that the pipe was stored inside under conditions not exposed to UV light. The written documentation must include the location where the pipe was stored and the corresponding dates it was stored there.

Polyethylene fittings shall be the butt fusion type conforming to the current ASTM D-3261 Specification "Butt Heat Fusion (PE) Plastic Fittings for (PE) Plastic Pipe and Fittings". Electrofusion fittings are an acceptable alternative.

Pipe shall be furnished in straight lengths. Length shall be in a minimum of 40 foot lengths. Straight lengths shall have plain ends without couplings unless otherwise specified.

Straight lengths of pipe shall be strapped with a sufficient number of non-metallic straps so the bundle will remain intact during shipping and warehousing.

Only with the Engineer’s approval, pipe may be furnished by the contractor in coils. Contractor shall be responsible for the straightening of the pipe according to the manufacturer’s instructions.

14.03.05 Polyethylene Pipe (8” and 12") and Fittings

Polyethylene pipe shall be Yellowstripe 8300 by Performance Pipe or equivalent by JM Eagle or Dura-Line. Other brands shall receive prior approval from the Chief Engineer.

Materials used for manufacture of polyethylene pipe shall be PE3408/PE4710-PE100 high density polyethylene. Pipe and fittings shall conform to ASTM Specification D2513 "Standard Specification for Thermo-plastic Gas Pressure Pipe, Tubing and Fittings".

Pipe weights and thicknesses shall be as follows:

Size	OD	SDR No.	Minimum Wall Thickness	Lbs/Ft
8”*	8.625±.011	11.0	0.784”	8.49
12”	12.750±.017	11.0**	1.159”	17.58

* All 8” HDPE Gas Main will be supplied by the Department and shall only be used where detailed in 8” to 12” pipe size transitions.

** 12” Gas Mains installed in 2014, 2015, and some from 2016 were installed as SDR 13.5 prior to the SDR 11.0 Standard.

Pipe shall be marked as shown in the current ASTM D-2513 standard, and, in addition, the resin manufacturer's material designation shall be marked on the pipe. If any data marked on the pipe is coded, the supplier shall furnish the code key. Pipe shall be new or stored for a period of time that does not exceed the manufacturer’s recommended maximum period of exposure, regardless of the method of storage.

Polyethylene fittings shall be the butt fusion type conforming to the current ASTM D-3261 Specification "Butt Heat Fusion (PE) Plastic Fittings for (PE) Plastic Pipe and Fittings". Electrofusion fittings are an acceptable alternative.

Pipe shall be furnished in straight lengths. Length shall be in a minimum of 40 foot lengths. Straight lengths shall have plain ends without couplings unless otherwise specified.

Straight lengths of pipe shall be strapped with a sufficient number of non-metallic straps so the bundle will remain intact during shipping and warehousing.

Pipe shall be black with a minimum of 4 yellow stripes.

14.03.06 PTFE Hose

PTFE (polytetrafluoroethylene) hose shall have a PTFE bore with a braided stainless steel covering to provide adequate pressure rating and protect the core. Hose ends shall be threaded stainless steel. Hose shall have the following pressure ratings:

Size	Pressure Rating (PSI)
1/2”	1500
3/4”	1100
1”	750

1 1/2”	700
2”	525

14.04 Valves

14.04.01 Steel Gate Valves

Valve shall be a non-lubricating full port, steel body valve with a single disc which, when closing, results in a wedging action against the double seats, or compression of an elastomer against the seating area. Valve shall have a non-rising stainless steel stem, and the following features:

Pressure Rating:	285 WOG
Ends:	150# ANSI Flat or Raised Face Flanges (as specified)
Operator:	2" Square and open Counter-clockwise
Coating:	"Scotchkote" #306 resin - 9 mils min.

Each valve shall have attached label indicating brand name or manufacturer, model number, pressure rating, and standard by which it was manufactured, such as API #, MSS-SP#, ANSI#, etc.

Valve shall be manufactured by Kerotest and be Model EV-11. For throttling applications on bypass lines, valves shall be Kerotest Model M-1 Flanged End (1F2). Other valves may be used with the written approval of the Engineer.

When specified, locking devices (not including the lock) shall be provided by the valve manufacturer and shall consist of a two-part unit, a cap and a swivel nut which fits onto the stem and over the operating nut. Device shall be equal or similar to Kerotest's Model 1 Locking Device.

14.04.02 Steel Ball Valves

A. Steel Valves – Trunnion Mounted Ball Valves. Valves shall be non-lubricating with emergency sealant ports, full port, double block and bleed, steel body, non-rising carbon steel nickel plated stem and the following features:

Pressure rating:	ANSI 150,300,600
Ends:	150# ANSI flat or raised face flanges 300#, 600# ANSI raised face flanges
Operator:	2”-4” valves to be lever operated except when specified otherwise (2” square operating nut) 6” and larger valves to be gear operated with hand wheel except when specified otherwise (2” operating nut)

Coating: Below ground valves to be tar-set coated-30 mils thick.

Each valve shall have attached label indicating manufacturer, model & serial number, pressure rating and standard by which it was manufactured. Valves shall be Balon Series T, Broen Ballomax, Cameron Grove B4-D, B-5 or approved by the Engineer.

B. Steel Valves – Floating Ball Valves. Valves shall be non-lubricating, full port, steel body, non-rising stem and the following features:

Pressure rating:	285 PSI
Ends:	ANSI 150#-Flat face flanges (except when specified otherwise)
Operator:	2”-6” to be lever operated with locking plate (open or close) 8” and larger to be gear box operated

Each valve shall have attached label indicating manufacturer, model number, pressure rating. Valve shall be Balon series “F”, Broen Ballomax, Kerotest Weldball, or approved by the Engineer.

Balon series “F” valves are approved for standard 2” meter stop valve applications.

14.04.03 Polyethylene Valves

Valves shall be Polyvalve (formerly known as Nordstrom Polyvalve), Polyball by Kerotest, Polytec by Lyall, Elster Perfection Corporation, Ballomax by Broen or approved equal. Valves up to 8” shall have a PE2406/2708 (orange or yellow) polyethylene body conforming to the following requirements. 12” valves shall have a PE4710 (black) polyethylene body conforming to the following requirements. 8” valves may be supplied with a PE4710 body and factory installed MDPE pipe pups.

Valves shall NOT be supplied with bypass lines.

All valves shall be ported as specified below unless approved otherwise by the Chief Engineer of Utilities. Valve ends shall be sufficiently long to fit into fusion machines for butt fusion to SDR 11.5 (4-inch, 6-inch and 8-inch) and SDR 11.0 (12-inch) pipe. Valve operators shall be as specified.

Size	Bore/Port	SDR	Connection End Min. Length	Operator
1” CTS	Full port	9.3 / 11.5	Socket Type	Slotted
2” IPS	Full port	11.0	Socket Type	2” Square nut
3” IPS	Full port	11.5	Socket Type	2” Square nut

4” IPS	3.50” diameter	11.5	Min. 7” long	2” Square nut
6” IPS	4.75” diameter	11.5	Min. 7” long	2” Square nut
8” IPS	6.60” diameter	11.5	Min. 5” long	2” Square nut
12” IPS	10.10” diameter	11.0	Min. 3.5” long*	Gear Reducing with 2” Square nut

* For 12” valves purchased directly by the City for installation by the City, a minimum 30” pup shall be factory installed on each side of the valve to allow it to fit in current City-owned fusing equipment. Pup length for Contractor purchased valves shall be determined by the Contractor.

Each valve shall be clearly marked or labeled to show: the standard such as B16.40 to which it was manufactured; the manufacturer's name or trademark; the size; the pressure rating; SDR number and material standard, i.e. PE2306, 2406, 4710 of connecting end material.

14.04.04 Excess Flow Valves

Excess flow valves shall meet or exceed all requirements of CFR Title 49 Part 192.381, ASTM F 2138, and MSS-115.

Excess flow valves used on gas services that operate continuously throughout the year at a pressure not less than 10 psig shall be manufactured and tested by the manufacturer according to an industry specification, or the manufacturer’s written specification, to ensure that each valve will comply with the following performance standards:

A. Function properly up to maximum operating pressure at which the valve is rated;

B. Function properly at all temperatures reasonably expected in the operating environment of the service line;

C. At 10 psig:

1. Close at, or not more than, 50 percent above the rated closure flow rate specified by the manufacturer; and
2. Upon closure, reduce the gas flow as follows:
    a) For an excess flow valve designed to allow pressure to equalize across the valve, to no more than 5 percent of the manufacturer’s specified closure flow rate, up to a maximum of 20 cubic feet per hour; or
    b) For an excess flow valve designed to prevent equalization of pressure across the valve, to no more than 0.4 cubic feet per hour;

D. Not close when the pressure is less than the manufacturer's minimum specified operating pressure and the flow rate is below the manufacturer's minimum specified closure flow rate.

Excess flow valves shall be LYCO EFV by R.W. Lyall for 1/2" CTS (0.090" wall thickness) or 1" CTS (0.099" wall thickness) unless specified otherwise by the Chief Engineer of Utilities. The series used on each service shall be determined by Engineering.

14.04.05 Meter Stop Valves (3/4" and 1" sizes)

Meter stop valves shall be 175 psi, black iron body, brass or bronze key, stem nut and stem washer, tamperproof, lubricating type, lockwing with 1/2" hole. Inlet and outlet to have iron pipe inside threads. Outlet to have insulated union. Valves shall be A.Y. McDonald 6276B, Mueller H-11179, or an approved equal.

14.04.06 Plug Valves

Plug valves shall be rated for minimum WOG 175, with high strength cast iron body conforming to ASTM A 126-42, Class B. Valve shall have a lubricating fitting centered on top of the stem where lubricant will travel through the stem, a double ball check, and to sealant grooves to the well at the base of the plug.

Valves shall be short pattern with 125# ANSI flanges and have a 2-inch square operating nut. Valve shall be Walworth 1797F, Nordstrom 143, Homestead 602 or 612, or an approved equal.

14.04.07 Meter Stop Valves for Multiple Meters

Meter stop valves shall be 175 psi, black iron body, brass or bronze key, stem nut and stem washer, tamperproof, lubricating type, lockwing with 1/2" hole. Inlet and outlet to have iron pipe inside threads. Valves shall be A. Y. McDonald 6276B, Mueller H-11179, or an approved equal.

14.04.08 Miscellaneous Transmission Main Ball Valves

These valves are located at the Pig Launch, Pig Receiver, and GL Regulator Station, 1/2", 3/4", and 1". The design of the ball valve shall meet or exceed all requirements of ASME B16.34, MSS SP-110, and the end connections shall meet or exceed all requirements of ASME B1.20.1. The ball valves shall be either 3000# WOG black iron body type or 1000# WOG Stainless Steel, Grade CF8M/316SS, threaded NPT end, full port, two piece manufactured by FNW, model Figure 200A.

14.05 Miscellaneous Fittings and Materials

14.05.01 Locating Wire, Connectors and Locating Boxes

Locating (tracer) wire shall be #12 solid copper with “HMWPE” 30 mil yellow insulation. Wire shall be supplied on spools of not less than 500 feet. If main and locate wire are to be placed by horizontal directionally drilling, tracer wire shall be #6 hard drawn copper (ASTM B-1) or annealed 49-strand braided 304 alloy stainless steel. The conductors shall be insulated with 45 mil yellow high-density polyethylene (HDPE) jacketing. The wire shall be tested in accordance with ASTM B-1 and D-1248 and spark tested at 7500 VAC. The breaking strength of the wire shall be at least 1260 pounds or approved equal.

Splices in the copper tracer wire should be made with solder, split bolt type connectors or other type approved by the Engineer. Splices in the stainless steel tracer wire should be made with split bolt type connectors or other type approved by the Engineer. Wire nuts or clip type connectors shall not be used. All connections shall be protected to make them watertight. Waterproofing material shall be 3M 2200 pads or equal.

Locating Boxes shall be Snake Pit’s magnetized tracer boxes from Copperhead Industries, LLC, (or approved equal) as follows:

Color	Installation Type	Model
Yellow	Turf	Snake Pit Lite Duty Box Model LD14YTP
Yellow	Bituminous	Snake Pit Roadway Box Model RB14YTP
Yellow	Concrete	Snake Pit Concrete/Driveway Box Model CD14YTP

The tracer box shall have a yellow powder-coated cast iron cover for natural gas.

All tracer box covers shall have insulated brass connecting lug for direct connection hook-up for a locator transmitter.

All tracer box covers shall have an alpha character stamped on top of the pentagon security bolt. Character shall be “G” for natural gas.

The Contractor may also use Snake Pit Style boxes with an adjustable top as an acceptable equal for turf installations only. All other substitutions must be approved by the City prior to bidding.

14.05.02 Service Riser (3" and larger services)

All 3” and larger risers shall be fabricated and provided by the Department. Riser shall be welded steel to a below grade depth of 18” minimum, then transition to PE pipe with a 90 bend at 36” minimum bury depth. The risers shall have a 150# flange on top and provisions made for anode attachment. Cathodic protection shall be provided per soil to air interface requirements as specified in Section 14.06.05. Steel pipe shall be in conformance to ASTM A106, ASTM 53, or API 5L, all Grade B.

Risers 3” in size may also be anodeless angle type with Phillips TR-418 plastic carrier pipe encased in a galvanized or a fusion bonded epoxy coated metal casing. Vertical rise shall be 30 inches of which the top 15 inches shall be centered in the casing so that air or a heat resistant material occupies the space between. Carrier pipe to casing shall be sealed in the upper end by means of insert stiffener and compressed O-Rings or rubber seals. Horizontal leg shall be steel casing a minimum of 12 inches and a maximum of 20 inches plus a 12" pigtail of plastic pipe not encased. Below grade, end of casing shall be effectively sealed against water intrusion. The 3" anodeless riser may be installed in a 66 PSI system and shall have a carrier pipe wall of 0.304” and a top connection of 3” 150# welded flange. Riser shall be one of or an approved equal to Georg Fischer Central Plastics, Perfection, Dresser, or R W Lyall and Company.

14.05.03 Service Risers (1/2" CTS x 3/4" IPS and 1" CTS x 1" IPS and 2" IPS)

Riser shall be anodeless angle type with PE 2406 or 2708 plastic carrier pipe encased in a galvanized or a fusion bonded epoxy coated metal casing.

Vertical rise shall be 30 inches of which the top 15 inches shall be centered in the casing so that air or a heat resistant material occupies the space between. Carrier pipe to casing shall be sealed in the upper end by means of insert stiffener and compressed O-Rings or rubber seals. Horizontal leg shall be steel casing a minimum of 12 inches and a maximum of 30 inches plus a 12" pigtail of plastic pipe not encased. Below grade, end of casing shall be effectively sealed against water intrusion. The 2" anodeless riser may be installed in a 66 PSI system.

An approved alternate service riser for 1/2” CTS x 3/4” IPS and 1” CTS x 1” IPS is a Georg Fischer Central Plastics anodeless flex service riser, Lyco flexible service riser by R.W. Lyall, Elster Perfection flexible riser, or an approved equal. Riser shall be anodeless angle type with PE 2406 or 2708 plastic carrier pipe encased in a galvanized or a fusion bonded epoxy coated metal casing and sunlight resistant flex tubing. Vertical rise shall be 30 inches of which the top 18 inches shall be centered in the casing so that air or a heat resistant material occupies the space between. Carrier pipe to casing shall be sealed in the upper end by means of insert stiffener and compressed O-Rings or rubber seals. Horizontal leg shall be sunlight resistant flex tubing a minimum of 24 inches long plus a 12" pigtail of plastic pipe not encased. Below grade, end of casing shall be effectively sealed against water intrusion.

	1/2 CTS x 3/4 IPS	1" CTS x 1" IPS	2" IPS
Carrier Pipe Wall	0.090"	0.099”	0.216"
Top Connection	3/4" IP outside	1" IP outside	2" I.P. threads

14.05.04 Transition Fittings (PE to Steel)

Transitions shall be resin coated Schedule 40 steel pipe connected to the polyethylene pipe with a factory-made permanent type compression joint meeting the requirements of ASTM D-2513 and ANSI B-31.8. Steel end shall be for weld type connection. Plastic portion shall conform to the minimum requirements for PE pipe as indicated below.

Size	Wall	Material	Type of Connection
1" CTS	SDR 11.5	PE 2406 or 2708	Steel Socket
2" IPS	SDR 11.0	PE 2406 or 2708	Steel Socket
3" IPS	SDR 11.5	PE 2406 or 2708	Steel Socket
4” IPS	SDR 11.5	PE 2406 or 2708	Butt
6" IPS	SDR 11.5	PE 2406 or 2708	Butt
8" IPS	SDR 11.5	PE 2406 or 2708	Butt
12" IPS	SDR 11.0	PE 4710	Butt

14.05.05 Valve Box

Box shall be two section, screw type with a cast iron top section and a plastic bottom section with a 5-1/4-inch ID, threaded shaft integral with a 9-inch diameter bonnet or bell. Heights of the sections shall be selected to fit the installation depth when the base is over the operating nut, but not closer than 2 inches to the valve flange. Plastic may be sawed off as required. Refer to Detail Drawing G-5 in the Appendix.

Valve boxes for valves with gear box operators shall be constructed as detailed in the Standard Construction drawings.

Cover shall be the stay-put type cast iron having 2 recessed lift holes. The identification "GAS" shall be cast into the cover.

Valve boxes shall be manufactured by Bingham and Taylor 500 series, High Line Products, or approved equal.

14.05.06 Casing Seals

For PE carrier pipe, casing seals shall be the pull-on "S" or "U" type made of oil and water resistant rubber, complete with stainless steel thumb screw clamps. Casing seals shall be P.S.I., Type S, F.H. Maloney Multiflex, T.D. Williamson U-Seal, or approved equal.

For steel carrier pipe, casing seal shall be link seal type similar or equal to Link-Seal manufactured by GPT or approved equal.

14.05.07 Strainers

Strainers shall be self-cleaning "Y" type, ductile iron or cast-steel body-125# ASA rating with screwed ends for up to 2-inch sizes and 150# ANSI raised face flanged ends for

sizes 2-inch and larger. Screen shall be monel or stainless steel wire, 30 mesh, with openings 1/50". Effective screen ratio shall be at least 2:1 or greater. Screen access cover shall be tapped FI PT for blowoff. Strainers shall be manufactured by Mueller, Fabrotech, or Keckley.

Strainers for large regulator stations having flow metering shall be equipped with 100 mesh screens accessible through a removable flange. Manufacturer shall be Fabrotech Industries or approved equal.

Strainer for transmission line use is a 6” or larger simplex basket style with 600# ANSI flanges and body, 100 mesh liner.

14.05.08 Bolt-Type Couplings (no longer used)

Use was discontinued by or before 1993. Couplings no longer used on gas systems include Dresser Style 39-62, Style 38, Style 40, Style 711 and CS1 CLa Maxi-Grip.

14.05.09 Steel Weld Flanges

Flanges shall be either welding neck or slip-on, flat face unless specified otherwise, 150# or 300# ANSI B16.5, and conforming to the ASTM Specification A181, except for transmission which are 600# ANSI, raised face.

14.05.10 Gaskets

Gaskets for Flanged Connections shall be PSI Linebacker Sealing gasket with G-10 core and nitrile sealing element. Transmission line gaskets shall be 600# Flexitallic, PSI Linebacker Sealing gasket with G-10 retainer and Teflon or Viton sealing element or approved equal.

14.05.11 Bolts

Bolts for flanged connections shall be ASTM449 medium carbon steel, SAE Grade 5, medium carbon quenched-tempered and the head marked with a "Y" to indicate grade. B7 stud is an acceptable alternative when bolts do not fit the application. Bolts for transmissions will be ASTM A320 L7 grade, 600# ANSI.

BOLT INFORMATION FOR FLANGED CONNECTIONS (150# CLASS)

Size	Flange OD Inches	No of Bolts Per Flange	Diameter of Bolts*	Bolt Length*	Stud Length	Suggested Torque Ft-Lbs **
2"	4-1/8”	4	5/8"	2-1/2"	3-1/2"	80
3"	5-3/8”	4	5/8"	3-0"	3-3/4"	110
4"	6-7/8”	8	5/8"	3-0"	3-3/4"	100
6"	8-3/4”	8	3/4"	3-1/4"	4-1/4"	130

8"	11”	8	3/4"	3-1/2"	4-1/2"	130
10"	13-3/8”	12	7/8"	3-3/4"	4-3/4"	215
12"	16-1/8”	12	7/8"	3-3/4"	5-0"	220
16"	20-1/4”	16	1"	4-1/4"	5-1/2"	320

Notes:

1. Bolt or stud length for Insulating Flanges shall be ½” longer than length shown in chart.
2. Bolt or stud shall have a minimum of two (2) exposed threads on the nut end.
3. Torque is based on lubricated bolt and bolt stress of 45 ksi.

On Transmission system, Engineering must be contacted prior to work for approval of diameters, length, number, and recommended torque.

14.05.12 Amp-Fit Couplings (no longer used)

Amp-Fit Transition Couplings (1/2" CTS PE to 5/8" OD Copper). Fitting was designed to connect 1/2" CTS - .09" wall polyethylene to 5/8" OD - Type K Copper. Fitting was Amp-Fit Part No. 332643-1.

Amp-Fit Repair Coupling (1/2" CTS, 1" CTS, 2" IPS - PE to PE). Fitting was designed to connect the following polyethylene pipe sizes:

1/2" CTS PE - .09" wall - SDR 7 - Part No. 332629-2
1" CTS PE - .121" wall - SDR 9.3 - Part No. 561414-1
2" IPS PE - .216" wall - SDR 11 - Part No. 561124-2

14.05.13 Mechanical Plastic Pipe (1/2") Coupling, End Caps, and Cap-N-Go Couplings

Coupling shall have a plastic body with plastic end sleeves designed to compress the pipe over plastic barbed ends with a metal stiffener that extend the length of the coupling or couplings shall have a plastic body with two internal seals, a fixed stiffener, self-locking gripper and a moisture lip. Couplings and end caps shall be tested to conform to ASTM D2513. Coupling and end caps shall be labeled to indicate a pipe size and wall thickness as follows:

1/2" CTS - 0.09" Wall - SDR 7

Coupling shall be Continental Con-Stab ID Seal Full Coupling.

Mechanical End Caps and Cap-N-Go fittings should only be used for temporary disconnections and shall not be used for capping permanently removed segments.

14.05.14 Electrofusion Plastic Pipe Coupling (1", 2", 3", 4”, 6", 8", 12”)

Couplings shall be compatible with an approved electrofusion unit. Electrofuse coupling shall be Lycofuse, Integrity or Central Plastics. Couplings for medium density pipe shall

be PE2406/2708 or PE4710 (orange, yellow, tan or black). Couplings for high density pipe shall be PE4710 (black only).

14.05.15 Service Tees for 3-inch & Smaller PE Services on Steel Mains

Service tee shall be steel, designed for at least 100 psi working pressure with a weld-on inlet end, incorporate an internally-contained tap, and have an outlet designed to connect polyethylene pipe, PE2406/2708. The connection to the polyethylene pipe shall be designed so that the pullout resistance exceeds the strength of the pipe in accordance with D.O.T. Pipeline Safety Regulations, Part 192.283(b). An insert stiffener shall be attached to each compression end.

Service Tee for 1/2-inch and 1-inch services shall be equal or similar to the table below:

Compression Outlet	Weld Inlet	Tap Size	Model
½" CTS PE, 0.090" Wall	3/4-inch	3/8-inch 3/8-inch	Mueller 18702 Mueller 18104
½" CTS PE, 0.090" Wall *	1/2-inch	3/8-inch 5/16-inch	Mueller 18198 Mueller 18104
1" CTS PE, 0.090" Wall	3/4-inch	1/2-inch 3/8-inch	Dresser 501 Mueller 18104

***** For connection on steel mains sizes 2-inch and smaller.

Service Tee for 2-inch and 3-inch services shall be equal or similar to the table below:

Weld Outlet	Weld Inlet	Tap Size	Model
2-inch	2-inch	1-1/2 inch	Mueller H-17650

14.05.16 Steel Extrube or Copper to P.E. Coupling - 5/8" OD (no longer used)

Coupling shall be designed to connect either 5/8" OD steel or copper tube to 1/2" (5/8" OD) - 0.090" wall or SDR7 polyethylene tube. Coupling shall be brass or bronze and have a built-in stiffener in one end. The connecting ends must be designed so that the P.E. pipe will fail before the pipes could be pulled out of either end of fitting.

Markings on coupling shall show manufacturer, OD of connecting pipes, and wall thickness for P.E. connection.

Coupling shall be Chicago fitting, Part No. M785DC23S090 or approved equal.

14.05.17 Rock Shield

Rock shield shall be Liberty HD Rockshield, Tuff-N-Nuff Rockshield, or similar product approved by the Chief Engineer. Rock shield shall be 3/8" thick and made of random

yellow looped resilient non-woven web mat manufactured using flexible, lead free, PVC material. The PVC material shall consist of small diameter (0.031" to 0.036") strands bonded non-directionally to each other.

Rock shield shall be double wrapped around the pipe.

14.05.18 Weather Caps

Weather caps shall be a non-toxic blend of PVC, plasticizer and ultraviolet inhibitors designed to seal out rain, ice, snow, sand, salt spray, insects, and birds. Weather caps shall remove with minimal backpressure.

14.05.19 Pipe Thread Sealants

Acceptable pipe thread sealants are Gasoila Soft Set with PTFE (preferred), Megaloc, Teflon tape, or approved equal. If anti-seize is utilized, it shall be Permatex 80078 Anti-Seize lubricants.

14.05.20 Mechanical Pressure Gauges

Mechanical Pressure Gauges shall be 2 ½" diameter, silicone or glycol filled, stainless steel case and base, and spiral tube with a polycarbonate lens. Piping connection shall be ¼" NPT male pipe connection and must be installed downstream of an isolation valve. Gauge shall display units in PSI from 0 to 120 or 160 and shall have intermediate increments of 2 PSI.

14.05.21 Pipe Supports

Acceptable pipe supports shall be manufactured by E-Z Line Pipe Support Co. or approved equal. Pipe supports shall have a nylon or neoprene shoe that contacts the supported pipe, all other materials shall be hot-dip galvanized steel. The pipe support collar shall have an adjustable height with a threaded column and securing nuts. Typically, the support will be supplied with a base plate containing slotted holes for anchoring to a floor or concrete support column.

14.05.22 Closed Cell Polyurethane Foam

Closed cell foam shall be Touch'n Seal 1.75 PCF polyurethane spray foam or equal. Open cell foams are not allowed.

14.05.23 Alcohol for Pipe Cleaning

Alcohol used for pipe cleaning prior to fusion shall be minimum 96% isopropyl alcohol. Alcohol containers shall be properly labeled to meet SDS standards.

14.05.24 Below Grade Tap Tee and Fitting Utility Markers

Below Grade Utility Markers shall be constructed of polyethylene, designed to fit over, zip-tied, or adhered to a pipeline, fitting, or tap-tee cap. The marker will be equipped with a 24” tall, utility color coded, vertical identifier that contains a locate-able magnet. The vertical identifier may include an adhesive flag with customizable message. Below Grade Utility Markers shall be Tee’d Up Markers by Cumberland Products or approved equal.

14.06 Cathodic Protection Materials

14.06.01 Anodes

Anodes for gas main and structure protection shall be the packaged type consisting of a cast magnesium anode having a silver soldered #12 TW lead wire at least 10 feet long attached to a steel core. Anode shall be encased with cloth bag containing a prepared backfill mixture of: hydrated gypsum, bentonite, and sodium sulphate. Weight of magnesium anode shall be 17 lbs. minimum or as specified for pipeline cathodic purposes.

Anodes, when specified to protect service risers or isolated fittings, shall be magnesium weighing at least one pound with at least 5 feet copper THNN wire. Anode shall be effectively attached to the protected material with a stainless steel base clamp.

Magnesium anodes for tracer wire applications shall be 1 lb. minimum.

Anodes shall be similar or equal to Galvomag by Harco or Maxmag by Federal Metals.

14.06.02 Test Terminal Box

Grade mounted box for use in nonpaved locations shall be ABS or PVC plastic, at least 17 inches long with slight flare at the base. Inside diameter shall be at least 2-3/8 inches. Cap shall be of the same material as the box with a rim which extends over the top of the box to prevent entry of foreign materials. Cap shall lock by a wedging action when the center steel bolt is turned. Bolt shall be magnetic for easy locating. Attached to the inside of cap shall be a 5 bolt terminal block which will bring the wires out of the box with the cap. Cap shall be impressed with the letters "TEST STATION". Box shall be "Handley Industries" Model TP-5B, "Flush Fink" by Cott Industries, or an approved equal.

Free standing test stations/markers shall be "Rhino TriView Post" test stations or an approved equal.

Pole mounted test stations shall be Crouse-Hines condulet E-27 with 3/4" threaded outlet attached to a minimum 24 inches of 3/4" galvanized conduit with plastic end protector or approved equal.

Face plate shall be Crouse-Hines No. 2770, terminal plate supplied with No. E type of terminal connection or approved equal. The grade mounted, pole mounted, and free standing test stations to be supplied by Public Works & Utilities Department, Utility Operations, 520 Garfield Avenue, unless otherwise specified.

14.06.03 Insulators

Flange insulators for ANSI 150# through 300# full face flanges shall be phenolic retainers with nitrile sealing elements, complete with full length Mylar sleeves and glass clad phenolic washers for insulating bolts on one side of flange. Flange insulators for ANSI 600# full face flanges shall be G-10 retainers with Teflon or Viton sealing elements, complete with full length G-10 sleeves and G-10 washers for insulating bolts on one side of flange. Gasket shall be Type E faced, 1/8-inch thick, for ANSI 150# through 600# full face flanges, as manufactured by Pipe Seal and Insulator Company (PSI), Central Plastics Company, or an approved equal.

Casing insulators shall be two or more segments of molded polyethylene bolted together so the segments fit tightly around the carrier pipe. Insulator shall be "Pipeline Seal and Insulator" Model PE, F H Mahoney Pipeline Products, Model 60, or T D Williamson, Inc., Model N-2, or approved equal.

Pipe support insulators shall be molded fiberglass shaped to conform to fit over specified pipe sizes, one or two pieces as specified, complete with epoxy seam sealer which fills all voids between pipe and insulator. Pipe support insulators shall be similar or equal to "Glas Mesh Type 180, Type 240, or Type 220/240.

Pipeline insulators for electrically isolating sections of steel gas lines shall be one-piece weld end spools, fabricated with API 5L Grade B Steel, rated for ANSI 150# or 300#, coated internally and externally with epoxy resin coating except for weld end cutbacks. Dielectric materials shall be compatible with natural gas.

Size (OD)	Wall Thickness	Size (OD)	Minimum Wall Thickness
4.500"	0.188"	10.75"	0.219"
6.625"	0.188"	12.75"	0.250"
8.625"	0.188"	16.00"	0.250"

Pipeline insulators shall be "IsoJoint" by Advance Products & Systems, Inc.; "PSI Electro-Stop Isolators" by Pipeline Seal & Insulator Inc.; Kerotest "Zunt" Type 1-A, or pre-approved equal.

14.06.04 Field Coatings (Below Grade)

See Section 25.05 for appropriate application.

A. Cold Type Applications. Cold applied coatings shall be one of the following approved commercial types or approved equals:

- Polyken 930-35 mill tape with #927 brush primer or #935 spray primer
- Tapecoat H-35G mill tape
- Scotchkote Corrosion Protection Tape #50 with Scotchrap pipe primer
- Royston Greenline Tape with 747 Primer
- T C Mastic (common hand applied bitumastic)
- Wax Tape by Trenton Corporation or approved equal for irregular fittings
- Scotchkote Liquid Epoxy Coating 323 or 328
- Denso Protal 7125 (brush on applications)
- Alternative fusion bonded epoxies only by Engineering approval.

B. Hot Type Applications. Hot applied coatings shall be one of the following tape-prime combinations or approved equal:

- Tapecoat 20 with T C Omniprime
- Thermofit (shrink) pipe sleeves by Raychem (Ultratec Division) or T C Omniprime
- Holidays less than two square inches in the epoxy pipe coating may be repaired using hot melt patch sticks, Scotchkote 226P or equivalent.

C. Directional boring pipe (shrink) sleeves shall be Dirax (by Raychem).

14.06.05 Field Coatings (Above Grade)

See Section 25.06 for appropriate application.

A. Rust-O-Leum Primer #678 or 769, Rustex, Derusto, shall be used when specified in Section 15.08(F). Color shall be gray unless otherwise specified.

B. Polyamide epoxy, high build, two part, one coat, similar or equal to Pittsburgh "Pit Guard" DTR or Rust-O-Leum High Performance Epoxy 9100V shall be used when specified. Polyamide epoxy in color white shall be applied to irregular fittings when tape coating is not practical. Color shall be gray unless otherwise specified.

C. Acrylic Urethane enamel with a compatible primer similar or equal to Pitthane Acrylic Urethane enamel with Medalhide 1001 inorganic zinc rich primer, or Aquapon Polymide-epoxy organic primer shall be used when specified. Color shall be gray

unless otherwise specified. An approved equal is Devthane 379 Top Coat with Devoe Bar Rust 235. Primer shall be Devoe.

D. Tape coating, when specified for above grade applications, shall be similar or equal to Tapecoat H35 grey. Tapecoat H50 grey shall be used where abrasion from street grit is evident. System shall be resistant to ultraviolet light, shrinkage, ambient temperature changes.

E. Soil to air interfaces shall be coated with Polyken 930-35 mill tape with #927 brush primer or #935 spray primer, Tapecoat H-35G mill tape, or Scotchkote Liquid Epoxy 323. Above grade the pipe shall be double wrapped with rock shield.

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SECTION 15: GENERAL CONSTRUCTION REQUIREMENTS FOR HP GAS PIPELINES

15.01 General

This section of the Standard Specifications establishes requirements and policies for the installation of high pressure gas distribution systems operating at pressures ranging from 1 psig to 275 psig and a transmission line which operates at a pressure ranging from 550 psig to 974 psig. Low pressure gas mains and services, the remaining systems of which were abandoned in 1992, are only specified to the extent of involvement with high pressure construction, such as conflicts in location, abandonments, etc.

All excavation, backfilling and restoration and horizontal direction drilling required for the construction of high pressure gas distribution systems shall be performed in accordance with the City of Duluth, Minnesota Public Works & Utilities Department – Engineering Division, Standard Construction Specifications, most current edition.

For contracted projects, these specifications also establish responsibilities between the Contractor and the Department for providing labor and equipment for installations. The Plans and Special Provisions may change these responsibilities for particular projects; therefore, it is essential that those parts of the documents be carefully reviewed for each project, since they take precedence over this Standard Specification.

15.02 Excavation and Backfill Standards

Requirements for site clearing, excavation, preparing trench, backfilling, compaction and restoration are contained in the City of Duluth Public Works and Utilities Department – Engineering Division Standard Construction Specifications book, most current edition, and any addendums or supplements, and shall govern the execution of work where they are not in conflict with more specific requirements contained in the Plans, the Special Provisions, or in this section.

15.03 Clearance Requirements (192.325)

A. Clearance requirements between underground gas mains and non-associated mains, utilities, structures, or rock shall be maintained at least as follows:

General Clearance -	6" - for rock, non-metallic pipe, structures, etc.
Special Clearances -	12" - for metallic pipe, structures, electrical conductor wires, etc. 30" - between plastic gas pipe and steam lines 12” - between plastic gas pipe and HDPE jacketed hot water lines

Where these clearances cannot be maintained, the Contractor shall notify the Engineer, who will determine the method or materials required to protect the gas main.

B. Preventing Sewer Service Lateral Cross Bores

Acceptable installation practices and documentation requirements when installing gas mains and services shall be as follows. Gas pipelines must be installed using one or more of the following methods. Every individual sewer service lateral must be protected by use of one of these methods. Each description below includes documentation requirements.

1. Open Trench Method
   The open trench must extend the full width of the property or the full length of the installation. Document all addresses/locations where the installation was performed by open trench.

2. Map and Record Method (Trenchless)
   Maps and records of sewer service laterals may be used to demonstrate that no conflict between the gas pipeline and the sewer service lateral is possible. For example, if the gas service enters the front of a structure and the sewer service exits the back of the same structure, the two utilities will not cross. The excavator's complete confidence in sewer service lateral maps is essential. Document the criteria by which the lack of conflict was established and all addresses/locations where this method was used.

3. Exposed Sewer Method (Trenchless)
   Pothole and expose the sewer service lateral at the gas crossing; the cutting head must be visible in the pothole. Document the distance between the drilling head and the sewer service lateral at all addresses/locations where this method was used. Photographic documentation showing both the drilling head and the sewer lateral is optional, but recommended.

4. Sonde Method (Trenchless)
   Sewer service lateral location and depth may be determined by a sonde transmitter at the crossed location. If this method is used, the drilling head must be equipped with a sonde, and must be at least three feet from the sewer service lateral. Each sonde must be calibrated daily. Document the sewer service lateral depth and the drilling head depth at each crossed location along with all addresses/locations where this method was used.

5. Relative Elevation Method (Trenchless)
   The highest elevation of an individual sewer service lateral may be determined by entering the structure and verifying the sewer drain's elevation as it leaves the

structure. The drilling head must be equipped with a sonde, and the drill must at all times be at least three feet above the highest sewer service lateral elevation. The three-foot separation must be maintained across the entire width of the property. The sonde must be calibrated daily. Document the highest sewer service lateral elevation relative to the drilling head elevation along with all addresses/locations where this method was used.

6. Televising Method (Trenchless)
   Individual sewer service laterals may be televised after the gas pipe has been installed. No gas may be introduced into the new pipeline until the sewer service lateral has been televised. Document with an electronic, visual record of the televising along with a written report. Correlate the sewer lateral connection (wye) location with the street address in written report. Use of this method does not alleviate the excavator's responsibility to obtain all available information regarding the location of sewer service laterals prior to installation of a gas pipeline (maps, drawings, diagrams or other records). Upon request, excavator should be prepared to produce such information at the job site. The Contractor shall coordinate televising with the property owner. Televising must extend from the structure all the way to the sanitary sewer main.

7. Other Trenchless Sewer Service Lateral Verification Methods
   With prior approval from the Engineer, other gas pipeline installation methods that demonstrate and document protection of sewer service laterals may be used.

In all methods, documentation must be retained for the life of the pipeline.

These methods do not replace the need to mark and locate sewer service laterals prior to construction.

After installation of new gas pipeline by methods 3 through 7, gas pipeline installers should report to the local sewer operators the verified locations of individual sewer service laterals. These verifications improve location records of sewer operators.

Unacceptable Practices:

1. Listening devices may be used to supplement acceptable practices, but must not be used in lieu of them. Because there is no positive visual verification and no way to accurately document the results, the use of listening devices alone is unacceptable.

2. Any procedure that does not allow for positive documentation of cross bore prevention is unacceptable.

C. Required Procedures to Maintain Clearances When Moling or Horizontal Directional Drilling across Sewers

Sanitary Main, Storm Main, or Storm Inlet Lead

Remove nearest manhole lid and measure depth to sewer. If the proposed crossing is within 50' to manhole, then inspection of only one manhole is adequate. If the manhole is further than 50' away, the manhole at the other end shall also be inspected.

If sewer is greater than 7' deep, no additional precautions are necessary.

If sewer is between 4.5' to 7' deep, keep track of mole or drill distance. If possible, visually check inside pipe to ensure no damage. After crossing sewer, perform a video inspection.

If sewer is less than 4.5' deep, excavate in street over sewer and mole or drill each way.

15.04 Alignments for mains

Alignments for mains shall be as indicated on the Plans. The Department will establish exact alignment prior to construction, and reserves the right to make minor changes as work progresses at no additional compensation. Major changes may be considered for extra payment only to the extent where: They are major deviations from Plan alignment; the Contractor informs the Department and obtains a written understanding for the basis of payment for extra work prior to construction of that portion. Fittings necessary to fit the Plan, whether indicated on the Plan or not, shall be considered incidental to the pipeline.

15.05 Grade for mains and services (192.327)

Grade shall be established by the depth of cover, except where indicated on the Plans or specifically established by the Engineer.

Table 15-1
Minimum and Maximum Depth of Cover

Type	Minimum Cover (inches)	Maximum Cover (inches)
Transmission Main	48	72
Main – general	36	48
Main – rock trench	24	48
Service – less than 2"	18	48
Service – 2" and larger	36	48

Service – under driving surface	36	48
Service – rock trench	12	48

When these depths cannot be maintained, the Contractor shall notify the Engineer, who will determine the method or material required to protect the main.

15.06 Backfill for trenches

All excavation, backfilling and restoration and horizontal direction drilling required for the construction of high pressure gas distribution systems shall be performed in accordance with the City of Duluth, Minnesota Public Works & Utilities Department – Engineering Division, Standard Construction Specifications, most current edition and any supplements or addenda.

For gas mains and services installed under the following conditions:

A. Under a driving surface, including graveled shoulders, driveway, parking lots
B. Under a sidewalk
C. To provide a base for undercut foreign utilities, curbs, walks, etc.

Class 5 granular material conforming to MnDOT 31328 shall be used.

15.07 Certification of Welders and Fusers

All pipeline welding shall be done by qualified Welders in accordance with Section 27 of these Standards.

All pipeline fusing shall be done by qualified fusers in accordance with Section 28 of these Standards.

15.08 Load Considerations

Special protection shall be provided to avoid direct extraordinary loads or external forces on the pipe. The Engineer will determine if and what kind of special protection shall be provided. A pipeline must be designed and installed so that each joint will sustain longitudinal pullout or thrust forces caused by the contraction or the expansion of the piping or by anticipated external and internal loading.

15.09 Installation of Protective Barriers

The Department or Contractor, when specified, shall install protective barriers to protect gas pipeline facilities from traffic or other hazards.

When above grade gas mains, service risers, regulators, or meter sets meet one of the following conditions, pipe bollards shall be installed in accordance with Detail Drawing G-33:

A. Where the edge of the travel lane is within 10 feet of a pipeline or meter

B. Where a licensed motor vehicle can park or drive by, including driveways and alleys, within 5 feet of an uncurbed pipeline or customer meter. A curb is considered to be adequate if it is continuous and parallel to the direction of normal vehicular travel. The extension of the vehicle's front or rear extremities shall be considered.

C. At any location that is susceptible to vehicular stresses or forces that have the ability to damage a pipeline or customer meter.

15.10 Casings

A. Casings containing a carrier pipe with the purpose of transporting natural gas shall be classified as one of the following:

1. Highway or Rail Road Crossing Casing is a casing installed under the requirements of a permitting authority with the general purpose of facilitating construction, providing access for future repairs, and providing protection from external loadings or differential movement. This type of casing must be engineered to meet the requirements of 192.323.

2. Insertion Casing is a conduit utilized during construction to simplify the installation process of a new gas main. Commonly the casing will be an existing pipe which has been abandoned from its original purposes.

3. Protective Casing is a conduit which is chosen to be structurally sufficient to protect the carrier pipe from external loadings that have potential of damaging the gas main. Protective casings are commonly installed where minimum cover depth is not satisfied or other buried infrastructure is crossing within close proximity.

B. Casings which will contain a gas main or service shall be installed subject to the following requirements:

1. The type of material, weight or thickness, grade shall be sufficient to withstand trench load and anticipated live loads, including impact.

2. Casings which will contain steel gas pipes shall have approved end seals that electrically insulate casing from gas pipe and provide a water-tight seal to prevent groundwater from entering the casing annulus.

3. Casings which contain plastic gas pipes shall have special protection such as injected sealant foam or other material where plastic pipe exits the casing to prevent earth backfill load from pressing plastic against the casing. Also, 2" and larger plastic mains shall be provided with anchorage where main exits a casing.

4. All casings which contain steel gas mains shall be vented. Casings which carry P.E. gas mains shall be reviewed by Engineering for venting requirements if the ends of the casing are sealed with materials other than expanding closed cell polyurethane foam insulation.

5. One or two vents shall be installed on each casing installed under interstate highways, railroads, buildings and runways or taxiways. Vents must terminate in a manner which prevents rain or surface waters from entering the casing. Vents are not required on wall sleeves or short casings used for special (shallow main) protection. Vent to outdoors is required if casing runs through a habitable enclosed space.

6. Approved casing insulators must be installed when a steel gas line runs through a steel casing.

7. For plastic gas pipe installed in casings within the 5-foot frost zone, the casings must not exceed the size permitted in 17.05.I.

C. If existing conduits or pipes are going to be repurposed as a casing, the proposed casing pipe shall be cleaned of debris and obstructions. Then the proposed casing pipe shall be televised to confirm the casing is free of imperfections that could potentially damage the gas main as it is being inserted. Additional cleaning or spot repairs are required until the carrier pipe can be inserted without risk of damage.

D. All casing installation shall follow the corrosion protection requirements of Section 09.06.

15.11 Above Grade Piping Supports

Above grade distribution system piping, regulator stations, town border stations, and services 4” and greater shall be supported with the following practices:

A. Supports shall be constructed of concrete and steel or other approved metals. Supporting saddles and pipe hoops shall have other isolating materials to protect from metal to metal contact.

B. Supports must be installed such that expansion and contraction, differential settling, or frost will not induce excessive stresses upon the pipe.

Where pipeline supports have not been designed with the applicable stresses in mind, they shall be fabricated with continuous adjustability.

C. Supports shall be installed in horizontal piping runs that contain non-welded connections and a mechanical component (such as a valve or regulator) that could potentially be removed, leaving a cantilevered pipe 5 feet or longer. With welded joint connections, pipe supports shall be installed when horizontal runs exceed 14 feet.

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16.01 General

This section of the Standard Specifications establishes requirements and policies for the installation of steel gas distribution systems and a transmission line.

16.02 Handling of Pipe and Fittings

The Contractor shall have adequate equipment on the site for unloading, supporting, and lowering pipe and fittings into trench. Pipe shall not be rolled, dragged, dropped, or allowed to contact sharp or hard objects which could cause injury to the pipe or coating. Fabric slings or soft padded devices shall be used so as to protect the pipe or coating. Pipe and fitting should be adequately secured to limit movement during transporting. Pipe stored outside shall have ends capped to prevent entry of water or debris, except when it is possible to visually determine that the pipe is clean before installation.

16.03 Inspection of Pipe and Fittings

Before installation, all fittings, lengths, and sections of pipe shall be thoroughly cleaned inside and inspected for defects. Steel pipe shall be inspected for damaged ends, coating defects, and other abnormalities (192.461) (b).

Upon completion of the welds, they shall be visually inspected to insure compliance with the qualifying weld procedure.

Steel pipeline sections, after being welded and the joints coated, shall be electrically inspected by the Contractor in the Inspector's presence immediately before lowering the pipeline section into the trench. Each section of pipe must also be protected from damage resulting from adverse ditch conditions or damage from supporting blocks. Holiday inspection shall be performed on all pipe and fittings with an electronic holiday detector, supplied by the Contractor, and operated in such a manner as to audibly and visually detect the presence of all holidays. The inspection shall be performed as outlined in the latest revision of NACE Standard RP 0490-2001 with a certified holiday detector. This inspection shall occur on all buried piping. This shall be done by use of a "geeper" which detects coating defects. Coatings found defective shall be immediately repaired and geeped again. Correct geeper voltage (1800 volts for 12-mil 3M Coating) shall be verified with the Inspector for the particular pipe coating before starting operation. Salvaged pipe to be reinstalled, which has wrapped bitumastic coating, shall have geeper voltage set at 7200 V for 3/32" and 9600 V for 1/8" coating thickness. If a geep voltage is not specified by the manufacturer then the holiday detection voltage shall be determined by $V= 525\sqrt{T}$, where T = coating film thickness in mils. Proper voltage settings shall be confirmed by detecting three artificial holidays placed in the initial pipe joint. For fabrication inspection, the electrode shall be a wet sponge detector supplied by the Contractor. For pipe inspection, the electrode size shall be the pipe OD and consist of a rolling spring composed of square stainless steel wire. The spring

length shall fit securely to the surface of the pipe. The holiday detector manufacturers approved by the Department are:

A. D. E. Stearns Company
B. Spy Holiday Detectors
C. Tinker & Rasor

Upon completion of the pipeline construction prior to final clean up, the Department may conduct a Pearson Survey to detect coating holidays. The Contractor shall uncover all of the holidays detected. The coating shall be cleaned, dried, geeped and uncovered coating defects shall be repaired. Any uncovered Pearson indications that do not require coating repair will be at the Department's expense and limited to the excavation, inspection, backfill and final cleanup. In either instance, all costs associated with the repair, including the excavation, coating repair, backfill and final cleanup will be borne by either the Contractor or the Department.

16.04 Cleaning Pipe Interior

Before joining, all fittings, lengths, and sections of pipe shall be inspected and thoroughly cleaned to remove all rust scale, dirt, snow, ice, water, or any other foreign material.

The Contractor shall install mechanical caps on the ends of all partially constructed mains and services for overnight periods or other periods of extended inactivity to prevent soil, water, and other materials from entering the pipe.

The completed pipeline shall be cleaned in the presence of the Inspector as follows:

A. Steel pipe, 2" and smaller, shall be cleaned by blowing with air.
B. Steel pipe, 3" and larger, shall be cleaned by blowing through a pig with air.

Alcohol shall be introduced in mains tested between September 1 and May 15. This shall be done prior to pigging. Contractor shall be furnished alcohol by the Department at 520 Garfield Avenue in amounts not to exceed the following per 1,000 feet:

2" - 0.4 Gallons	6" - 2.0 Gallons
3" - 0.6 Gallons	8" - 4.0 Gallons
4" - 1.0 Gallons	10" - 6.0 Gallons

16.05 Steel Pipe Installation

A. Expansion joints shall be furnished and installed in accordance with Sections 14.02.04(P) at locations indicated on the Plans or designated by the Engineer in the distribution system.

B. Bends in steel gas mains shall be made with weld fittings, approved bending equipment, except where deflections do not exceed 12-1/2 degrees, miter bends are permitted.

   Wrinkle bends are not permitted.

   No attempt shall be made to bend pipe except with bending equipment designed specifically for bending. Bending shall be within the allowable limits and meet the requirements of DOT Regulation, Section 192.313.

C. Damaged sections of pipe shall be removed and replaced by cutting the section out as a cylinder, applying half-sole patch, or a full encirclement closure. Damage shall include dents, scratches, gouges, grooves, or arc burns which, in the opinion of the Engineer, could cause stress concentrations.

D. A directionally drilled pipe that is installed which has the sacrificial coating partially or completely missing and the FBE coating intact shall be considered a successful bore. The Contractor shall provide means of internal inspection (geometry pig or approved alternate) to insure that the installed pipe is free of deleterious dents before tying the bore into the pipeline, as required by the Engineer.

E. Pipe in open trench shall be installed as shown on detail drawing number EX-2 unless indicated otherwise on the plan. Where it is impossible or impractical to use encasement materials, rock shield (double wrapped around the circumference of the pipe and supplied by the Contractor) may be used as determined by the Engineer.

F. Before backfilling, the pipe must be geeped with a holiday detector to confirm that no coating defects remain. Short replacement pieces or repairs to steel pipe need not be geeped.

16.06 Repair of Damaged Steel Pipe (192.307)

16.06.01 Transmission Main

Any repair on the transmission pipeline will require a procedure prepared by Engineering prior to any work. The pipeline will be taken out of service and pressure reduced below 20% of SMYS before any repair is made.

16.06.02 Distribution

A. Damaged steel pipe which must be corrected includes:

   1. Dent which in addition contains a stress concentrator such as a weld joint, an arc burn, scratch, or gouge.
   2. Dent which exceeds twice the wall thickness.

3. A scratch, gouge, or groove deeper than 12-1/2% of the wall thickness.
4. Arc burn.

A gouge, groove, arc burn or dent may not be repaired by insert patching or by pounding out. If these defects are removed, they may only be removed by cutting out the damaged portion as a cylinder.

Each segment of generally corroded distribution pipe with a remaining wall thickness less than that required for the MAOP of the pipeline or a remaining wall thickness less than 30% of the nominal wall thickness must be replaced or permanently repaired.

B. Repairs requiring correction during construction should be accomplished by cutting the damaged section out as a cylinder unless an alternate method is approved by the Engineer.

Temporary repairs may be made with band clamps, sleeves or couplings, provided they are appropriately rated by manufacturer for pressure, size and suitability for use on steel gas lines. The permanent repair should be made within nine (9) months of temporary repair.

Permanent repairs required on a damaged steel pipeline which is in service may include:

1. Cutting out and replacing portion as a cylinder.
2. Complete full encirclement weld sleeve.
3. Halve sole weld-on repair patch for 6” and larger pipe.
4. Alternative repair composite reinforcement sleeve as approved by the Engineer.

Full encirclement weld sleeves and half-sole weld-on repair materials shall meet the more stringent of the following steel grade and thickness requirements: the current steel pipe specifications for each nominal size or match the steel grade and thickness of the pipe to be repaired.

All repairs of transmission and distribution steel gas pipe which require the replacement of pipe will be made using sections of pre-tested pipe that has been pressure tested to MAOP x 1.5 (Section 19) or at least 100 psi, whichever is greater. Repaired or replaced portions shall be rewrapped and/or coated in accordance with Section 25.

16.07 Joining Pipe and Fittings

16.07.01 General

Approved joints to be used for assembly of underground pipelines shall be according to the following tables unless detailed otherwise:

Table 16-1
Steel to Steel Joints

Jointing Between	Type of Joint
Steel Pipe Sections	Welded
Steel Pipe and Fittings	Welded
Steel Pipe and Plastic (1", 2", 3", 6", 8")	Weld End Transition Fitting
Steel Pipe and Valves	Weld Flanges, 150# or 300# or weld end
Steel Pipe Insulators	Weld Flanges, 150# or 300#
Steel Pipeline Expansion Joint within long casings	Stainless Steel Bellows Type in manhole

Table 16-2
Plastic Pipe to Steel Pipe or Copper Risers

Jointing Between	Type of Joint
5/8" Steel Service replaced with 1/2"plastic and 1"P.E. service replaced with P.E.	Existing old style Dresser 88 service tees must be refitted with new lock insert gasket, retainer cup & follower nut to conform to pullout resistance regulations. Otherwise, the tee must be abandoned & new 1" tees installed per 14.05.15 & Detail G-2.
5/8" O.D. steel or copper tube to 1/2" P.E.	Chicago Fitting

16.07.02 Welded Joints

Welders must be qualified according to the requirements of Section 27-Welding Qualifications.

A. Cutting — The edges or surfaces of parts to be joined by welding must be prepared by machining, grinding, flame cutting, or with a sanding disk. Edges prepared by flame cutting shall be dressed with a file, grinder, or sanding disk to produce a reasonably smooth and uniform surface. A flame cutting beveling machine shall be used to cut all 2" and larger pipe except that, where a beveling machine cannot be used, the pipe may be cut with a wheel pipe cutter and grinder beveled. The inside edge of pipe cut with a wheel cutter must be filed or reamed to remove the cutting burr.

B. Cleaning	All surfaces within 1" of the weld area must be dry, cleaned of all rust, scale, primer, oil, or other foreign material. The parts to be welded shall be free from greasy or oily matter at least 2" from the weld edge or surface.
C. Mitering	Miter joints may be made but not to exceed a total pipe deflection of 3^{o} on the transmission gas line and 10^{o} on the distribution gas mains. Increasing the deflection by using multiple miter bends properly spaced is permitted but discouraged in favor of cutting a standard bend fitting. If multiple miter joints are used, the minimum distance measured at the crotch from joint to joint must not be less than 1-1/2 pipe diameter.
D. Alignment	Line up clamps shall be maintained in place until at least 50% of the root bead is deposited at uniform spacing around the joint.
E. Protection	Tents or shields must be used when necessary to protect the weld area from rain, snow, or high winds. Liquid must not be permitted to come in contact with the weld area.
F. Preheat	The environment or weld material shall be preheated to at least 50^{o}F.
G. Clearance	**At least 24 inches of clearance under and around a joint should be provided for proper working space.**
H. Configuration	See Standard Detail No. G-4.
I. Gas Vapors	Welding must be done only under controlled conditions in the presence of gas. A controlled flame at the weld or removing the combustible mixture from the weld area are the alternatives to be selected. Air movers or other means must be employed if gas is to be kept from the area. Gas detection instruments must be used to measure environment to insure any method employed to keep gas away is effective.
J. Cleaning Between Passes	Scale and slag shall be removed from each bead and grove between passes by grinding, brushing, or chipping.
K. Inspection	Acceptability of a weld that is nondestructively tested or visually inspected is determined according to API 1104, Section 9. All welds must be visually inspected to ensure compliance with the welding procedure.

Each person responsible for inspecting welded joints must be qualified by training or experience to ensure that the welding is performed to the procedure in this manual.

The Inspector reserves the option and without notice to have weld radiographed or to have test coupon cut as a supplement to visual examination. Cost of testing will be charged to Contractor if welds are not acceptable.

L. Inspection of Transmission Welds

All welds must be visually inspected to ensure compliance with the welding procedure. Inspection of welds on the transmission line will normally be done by a third party. The Department will keep on file and accept the NDE procedures utilized by the third party of their methods.

The welds on a pipeline to be operated at a pressure that produces a hoop stress of 20 percent or more of SMYS must be nondestructively tested in accordance with § 192.243, except that welds that are visually inspected and approved by a qualified welding inspector need not be nondestructively tested if:
1. The pipe has a nominal diameter of less than 6 inches (152 millimeters); or
2. The pipeline is to be operated at a pressure that produces a hoop stress of less than 40 percent of SMYS and the welds are so limited in number that nondestructive testing is impractical.

M. Repair of Welds

Welds found unacceptable according to API Standard 1104, Section 9, must be removed or repaired. Weld must be removed if it has a crack that is more than 8% of the weld length. Rejected welds on lines not in service shall be removed. Rejected welds on lines in service may be repaired or encapsulated. Welds which are permitted to be repaired must have the defect removed down to sound metal and the segment to be repaired must be preheated if conditions would adversely affect the quality of weld repair. The repair of a previously repaired weld will not be permitted and shall be removed.

16.07.03 Flanged Connections

Flange faces must be similar. Flat face flanges may not connect to a raised face flange.

Alignment of the flanges to be joined shall be done before bolting. Bringing unaligned pipelines together by tightening, resulting in a permanently sprung connection, is prohibited. Bolts or studs shall be long enough that, with the gasket or insulator

installed, they will extend completely through the nut with not less than two (2) exposed threads when tightened. Bolts or studs shall be tightened gradually and alternately so as to bring the flanges together with uniform and increasing pressure on all parts of the face.

See section 14.05 for torque requirements.

16.07.04 Steel (Extrube) to PE Repair Coupling, 5/8" ST to 1/2" PE Installation

The following procedure shall be used to connect 5/8" OD Steel or copper tube to 1/2" CTS (5/8" OD) PE pipe.

Installers of this fitting must be qualified according to Section 28.

A. Cut plastic square and deburr O.D. and I.D. Clean exposed plastic line with a clean, dry, grease-free cloth.

B. Mark tubing to stab depth at 1 1/2" from end with felt pen or suitable marker. Make sure not to scratch surface of plastic tubing with marker. Loosen nut 1 to 2 turns. Stab stiffener end of fitting over plastic service until plastic is bottomed. Flush with mark.

C. Tighten body onto nut using suitable wrenches until body meets nut shoulder, that is, "metal to metal”.

D. Cut steel tube square, remove 1 1/2" of coating from end and deburr O.D. and I.D.

E. Loosen nut one to two turns.

F. Stab fitting over tubing until tube is bottomed and flush with edge of coating.

G. Tighten nut onto body using suitable wrenches, until nut shoulder meets body, that is, "metal to metal”. Steel end connection must have bitumastic applied and then taped.

16.08 Branch Main Connections, 2" and Larger

16.08.01 Connections to mains not in service

Connections to mains not in service may be made by the Contractor. Weld tees shall be installed where the branch and main are the same size or one size under. For branches more than one size under, saddles or tees and reducers may be used.

16.08.02 Connections to mains in service

Connections to mains which are in service (live) shall be done by the Department. The Department shall furnish and install saddles, nipples, and tapping valves, if required. The Department will furnish and install no-blo tees, stop off fittings, or bottom out fittings, if required.

Excavation, backfill and restoration shall be included as the Contractor's responsibility for all planned connections.

Hot tapping shall be performed only by trained & qualified personnel according to Section 16.09.

Department will furnish tools, machines, and personnel for any required operation as follows:

A. Operate gas valves.

B. Line stopper, bottom out connections, or by-pass operations.

C. All tapping, drilling, cutting of mains.

Branch connections to mains in service (live) will follow these policies.

16.08.03 Branch Connection Policy to Steel Mains in Service
(Refer to detail G-3 or as spec on plan)

Branch Size	Main Size	
	Same as Branch	Larger than Branch
2”	2” No-Blo Valve Tee	2” No-Blo Valve Tee Weld Saddle w/Tap Valve
3”&4”	One Size Reduced Weld Saddle w/Tap Valve Bottom Out Stop (2” No-Blo Valve Tee for 3” PE Branch)	Weld Saddle w/Tap Valve Bottom Out Stop (2” No-Blo Valve Tee for 3” PE Branch)
6”-12”	One Size Reduced Full Encirclement Tap Tee w/Tap Valve Bottom Out Stop	Full Encirclement Tap Tee w/Tap Valve Bottom Out Stop

16.09 Hot Taps on Gas Main - Procedures, Training and Qualifications

Tap fittings shall be connected to mains only by qualified welders or fusers. No hot taps will be allowed on the transmission line without taking it out of service, pressure reduced and a procedure developed.

Tap fitting connection must be pressure tested for leakage before tapping begins.

Operators performing hot taps shall be restricted to trained personnel listed in "Table of Hot Taps, Tools, Instructions and Qualifications". The operator (or at least one operator in the crew) shall have had the minimum training or certification listed in the schedule for each respective type of tap.

Instruction reference manuals or procedures shall be made available on the job site for each respective tap, except the self-tapping tees.

Table 16-3
Hot Taps, Tool, Instructions, Qualification

Type of Tap	Size	Detail	Machine Used	Operator(s)	Instruction Ref. & Qual.
3/4"x 5/8"Tap-N-Valve 1/2" x 5/8" mini-tee 3/4"x 1 1/8" Style 501	3/4" 1/2" 3/4"	G-2 G-2 G-2	None - self tap w/tool " "	Certified U.O. Personnel	Manuf. Manual " " Apprentice Program
Weldolet or Weld Saddle & Valve Weldolet or Weld Saddle & Valve Full Encirclement Tap Tee	2" & 3" 4" 6",8",10",& 12"	G-3 G-3 G-3	D-5 Mueller C1-36 Mueller C1-36 Mueller	Certified U.O. Personnel Certified U.O. Personnel Certified U.O. Personnel	 Operating Instructions, Form 8513 Apprentice Program and Mueller Sch
No-Blo Valve Tee (Completion plug for No-blo &drill nipples)	1¼" & 1½" & 2" 1", 1¼", 1½" & 2"	G-4	D-5 Mueller H 17145 Mueller	Certified U.O. Personnel Certified U.O. Personnel	 Apprentice Program & Mueller Sch
Stop (Completion Plugs)	1¼" & 2"		D-5 Mueller H 17145	Certified U.O. Personnel Certified U.O. Personnel	Low Pressure Line - Stopper Fitting Training Manual by Apprentice Program & Mueller Sch
Stop (Completion Plugs)	All Sizes 3", 4", 6" & 8" 10" & 12"		C1-36 Mueller 3SW Mueller 4SW Mueller	Certified U.O. Personnel Certified U.O. Personnel Certified U.O. Personnel	Operating Instructions, Form 8513 Operating Instructions, Form 8834 Apprentice Program & Mueller Sch

Table of Contents

17.01 General

This section of the Standard Specifications establishes requirements and policies for the installation of plastic gas distribution systems.

17.02 Handling of Pipe and Fittings

The Contractor shall have adequate equipment on the site for unloading, supporting, and lowering pipe and fittings into trench. Pipe shall not be rolled, dragged, dropped, or allowed to contact sharp or hard objects which could cause injury to the pipe or coating. Fabric slings or soft padded devices shall be used so as to protect the pipe or coating. Pipe and fitting should be adequately secured to limit movement during transporting. Pipe stored outside shall have ends capped to prevent entry of water or debris, except when it is possible to visually determine that the pipe is clean before installation.

Care shall be exercised at all times to protect plastic material from fire, excessive heat or harmful chemicals.

Plastic pipe and tubing shall be adequately supported during storage. Thermoplastic pipe, tubing, and fittings shall be protected from long term exposure to direct sunlight.

Extra care shall be taken when handling plastic pipe in cold weather below 40°F to avoid damage to the pipe ends caused by impact with hard surfaces such as frozen earth or concrete. Pipe shall not be dropped. Coils of pipe shall be warmed before pipe is uncoiled and shall be mounted on a device which rotates to permit a straight pipe when unreeled. Sprung or spiraled pipe shall be straightened by hand.

When it is necessary for the pipe ends to be cut during construction, the cut can be accomplished by various methods below:

- for sizes 3” or less, using a blade type of cutter, or a tubing cutter
- for sizes 4” or larger a guillotine pipe cutter shall be used.

Short pipe segments cut from pipes not installed can be cut with a sawsall, hand saw, or a chain saw (without bar oil) if the Department can visually inspect the pipe to be free of pipe shavings.

17.03 Inspection of Pipe and Fittings

Before installation, all fittings, lengths, and sections of pipe shall be thoroughly cleaned inside and inspected for defects. Plastic pipe shall be inspected for cuts, scratches, gouges, kinks, severe out-of-roundness, and other imperfections.

17.04 Cleaning Pipe Interior

Prior to fusion of fittings, the pipe shall be inspected and thoroughly cleaned to remove all dirt, snow, ice, water, pipeline shavings, or any foreign material. If any foreign materials are found in a section of pipe, the section must be pigged repeatedly until pig exits clean and dry prior to joining pipe sections or fittings. The first pass shall be done without adding alcohol. The use of new pigs is necessary to prevent contamination from dirty pigs, as directed by the Inspector.

The contractor shall install mechanical or fusion caps on ends of all partially constructed mains and services for overnight periods or other periods of extended inactivity to prevent soil, water, and other material from entering the pipe. Duct taping of pipe ends is not acceptable. Fusion caps may be required on any main or service installed in the ground where ends of pipe cannot be raised above trench.

The pipeline must be cleaned prior to installing of tees.

The completed pipeline shall be cleaned in the presence of the Inspector as follows:

A. Plastic pipe, 1" and smaller, shall be blown with air.

B. Plastic pipe, 2" and larger, shall have a foam pig blown through with compressed air. The pig shall be sent through the main repeatedly until it exits clean and dry. If any dirt or water is present on the pig, a new clean pig must be resent through the main.

Methanol (ALKY) shall be introduced in mains tested between September 1 and May 15. ALKY shall be introduced before pig is installed for final pigging. Contractor shall be furnished methanol ALKY by the Department at 520 Garfield Avenue in amounts not to exceed the following per 1,000 feet:

2" - 0.4 Gallons
3" - 0.6 Gallons
4" - 1.0 Gallons
6" - 2.0 Gallons

For mains 8-inch and larger, the actual amount will be determined by Engineering.

17.05 Plastic Pipe Installation

A. Plastic pipe shall be laid with uniform support on undisturbed or well compacted soil. Pipe bed shall not contain large rocks, blocks, or any other material which could injure the pipe or result in non-uniform support.

B. Plastic pipe shall be laid and backfilled with its natural slack in trenches. Excessive tension to straighten out pipe is not permitted.

C. Locating wire shall be laid 6 inches above every plastic gas pipe when open cut. Locating wire shall be tested for continuity.

Service locating wire shall be connected to main locating wire.

Locating wire shall remain continuous to the greatest extent possible. All connections shall be protected to make them watertight except the ends where they are brought up in valve boxes or at service risers.

Locating wire, at valves, shall be brought up in valve box using 1/2" PE section to enclose the wire.

Two wires shall be pulled on all directional drilled installations of main and 2” or larger services.

Locate wire and connectors placed during directional boring must be approved prior to work being performed. Locating wire pull-out prevention is required at all buried wire connections as follows:

Copper wire - Bend and fold ends around split bolt connector
Stainless cable - Tie an overhand knot in the cable with the splice located in the loop of the knot.

All locating wire shall be tested for continuity. Payment shall not be made for main or service without a properly functioning locator wire.

D. Bending plastic pipe is permitted up to the radius of its shipping coil. Pipes 4 inch and larger may be deflected to a minimum radius of 125 times pipe diameter at joints and 20 times the pipe diameter otherwise.

E. Pulling plastic pipe through auger and bore holes may be done with power equipment only if a "weak link" section, approved by the Engineer, is used in the pulling assembly. Every effort should be made to pull and/or push the inserted pipe through by hand. If winch or machine power is required, a "weak link" designated by the Engineer shall be used in the pulling assembly. Weak link may be a pulling head or next smaller diameter pipe of the same SDR or greater than that being pulled.

F. Pipe shall not be installed in cold weather (40°F or less) except in a special arrangement and with approval of the Engineer.

G. Installation of plastic pipe by plowing is permitted provided the pipe is not stretched at any time in the operation. Plow chute shall not bend pipe more than a radius of 15 times pipe diameter.

H. Installation of plastic pipe by pull plug is not permitted.

I. Installation by insertion in casing pipes or abandoned mains shall meet all requirements of Sections 9.06 and 15.10. Insertion shall be preceded by proper preparation of the existing abandoned main. Obstructions such as old service taps, bends, drips, etc., shall be cut out and the leading pipe ends padded as necessary to prevent scratching the inserted pipe. Locating wire shall be laid to and attached to casing or laid inside the casing or both depending upon conditions. Pipe inserted through more than 100' of casing will require anchors at each end to restrain the plastic main. The Engineer will provide an anchor detail. Openings at casing ends where pipe is inserted through less than 100 feet of casing and without anchors shall be sealed with closed cell polyurethane foam.

   When plastic gas pipe is inserted through a steel casing, the tracer wire shall be attached by cadweld to each end of the casing prior to pipe insertion.

   Ends of casing or cut pipe shall be at least 12 inches from any connecting service with branch tee.

   Plastic pipe installed through casings which are in the 5-foot frost zone are subject to being squeezed off by ice. Casings subject to these conditions must be sized as follows:

1/2" PE Gas Pipe	3/4" or 1" Casing
1" PE Gas Pipe	1 1/4" or 1 1/2" Casing
2" PE Gas Pipe	2 1/2", 3", 4" Casing
3" PE Gas Pipe	4", 6" Casing
4” PE Gas Pipe	6”, 8” Casing
6" PE Gas Pipe	8", 10" Casing
8” PE Gas Pipe	12” Casing
12” PE Gas Pipe	16” Casing

J. Pneumatic tunneling (moling) shall be done with caution to avoid damage to foreign utilities. When it is not clear that elevation or location clearance can be maintained, the Contractor shall expose the foreign utility before tunneling. The Engineer may further limit lengths between excavations to insure that depth limitations are not either excessive or insufficient. Follow procedure in Section 15.03 for sewer main or service crossing.

K. Plastic gas mains 4" or larger in size and in open trench shall always be installed as shown on detail drawing number EX-2 unless otherwise indicated on the plans. This shall not apply when pipe is inserted through bored holes. Cost of bedding and cover shall be included in unit bid price for pipe installation.

17.06 Repair of Damaged Plastic Pipe

Damaged pipe requiring repair or replacement include scratches or gouges which have a depth of 10% or more of the wall thickness, pipe which has been stretched or kinked beyond the elastic limit; i.e., will never recover original shape or length, except for a squeeze off location.

Repair of defects during the construction of plastic pipelines should be accomplished by cutting out the defective parts and replacing section by using the same materials and methods for new construction.

After a plastic pipeline has been in service, a number of approved fittings (Section 16.07) may be used to repair or replace defects. Repairs must also be made to plastic pipe using sections of pipe that has been pre-tested to 100 psi.

Whenever plastic pipe is squeezed off for any reason, the location of the squeeze or pinch must be permanently marked with wraps of electrical tape or a split plastic clamp so the location will not be used for another squeeze-off in the future.

When repairs have been made, the tracer wire must be reconnected for continuity. Connections are to be made with 3M type connectors or approved equivalent and must be made waterproof by the use of 3M 2200 pads or approved equivalent. Tracer wires are not to be attached to the steel gas main, steel services, or service tees.

17.07 Joining Pipe and Fittings - General

Approved joints to be used for assembly of underground pipelines shall be according to the following tables unless detailed otherwise:

Table 17-1
Plastic to Plastic Pipe Joints

Jointing Between	Type of Joint
1/2"	Socket Fusion The following may be installed only by the Department in the following conditions: • Continental Con-Stab Coupling for existing service relocations • Continental Con-Stab Cap-N-Go for temporary services • Continental Con-Stab End Cap for temporary abandonments
1”	Socket Fusion or Electrofusion
2" and 3"	Socket, Butt Fusion, or Electrofusion
4”, 6", 8”, 10” and 12”	Butt Fusion & Electrofusion*

* Where electrofusion couplings are used to join pipe to fittings (tees, elbow, etc.), a minimum 2' stub shall be installed between the fitting and coupling to allow for future repairs.

** MDPE pipe and HDPE pipe shall not be directly butt fused to each other.

Table 17-2 Plastic to Plastic Repair	
Jointing Between	Type of Joint
1/2"	Socket Fusion Coupling or “”Continental Con-Stab” Type Plastic Pipe Repair Coupling, Cap-N-Go, or End Cap when installed by the Department
1”	Socket Fusion Coupling or Electrofusion
2” and 3”	Electrofusion coupling, socket fusion coupling, or butt fusion
4”, 6”, 8”, 10” and 12”	Butt fusion and electrofusion coupling*
4”, 6", 8”, 10” and 12" (temporary)	Band clamp may be used for temporary repairs. Permanent repairs must be scheduled.

* Where electrofusion couplings are used to join pipe to fittings (tees, elbow, etc.), a minimum 2' stub shall be installed between the fitting and coupling to allow for future repairs.

Table 17-3 Plastic to Plastic Tapping Tee	
Jointing Between	Type of Joint
1/2", 1", & 2" tee on 2”, 3", 4”, 6", 8", 10” & 12” main	Saddle & Electrofusion

* Where electrofusion couplings are used to join pipe to fittings (tees, elbow, etc.), a minimum 2' stub shall be installed between the fitting and coupling to allow for future repairs.

17.08 Fusion Joining of Plastic Pipe

All fusion joining shall be done only by persons currently certified by the Public Works and Utilities Department according to these Standards.

All fusion joining equipment shall be maintained in accordance with the manufacturer's written procedures or recommended practices that have been proven to reliably produce acceptable joints through testing and experience (192.756). To sustain

reliability, all fusion joining equipment shall be inspected for damage, defects, and proper performance no less than annually.

Skillful application of techniques and the use of proper materials and equipment in good condition are required to achieve sound joints in plastic piping by the heat-fusion method. Inspection provisions shall be adequate to assure that sound joints are being made. The quality of the joints shall be checked visually. If there is any reason to believe the joint is defective, it shall be removed and replaced.

Alcohol shall be used for cleaning and preparing the fusion surfaces on the pipe. Alcohol shall be 96% or greater isopropyl concentration.

No fusion joining shall be done unless the proper and full quantity of tools is used.

Fusion joining between different types of plastics shall only be made to connect a service tee or branch saddle to the tan Dupont Aldyl "A" 6" pipe. Respective heating cycles for each type of plastic are listed in Table 17-10.

Connections between MDPE and HDPE shall only be made with electrofusion couplings. Direct butt fusion between the materials is not allowed.

Direct application of heat with a torch or other flame is prohibited.

Special procedures outlined below shall be applied for fusion joining in cold weather. No work shall be done when it is below 0°F, raining, sleeting, or snowing, unless an artificial shelter is provided to enclose the work sufficiently to maintain an environment to comply with these specifications.

17.09 Socket Fusion Joint Procedure

A. End Preparations

1. Using a pipe cutter, cut off damaged or oval ends of pipe squarely.

2. Using chamfering tool to remove about 1/16" of the sharp corner at the pipe end on the outside surface of pipe. Remove burrs and chips inside pipe ends.

3. To prepare pipe for correct penetration into socket, place depth gauge down flush on end of pipe.

4. Place cold ring clamp around pipe, adjacent to depth gauge. After securing cold ring clamp, remove depth gauge.

5. Fitting surfaces should be clean and dry--wipe with cloth--do not touch with hands. Clean surfaces with alcohol and lint free material.

6. The socket faces of the heating tool should be at 500° ±10°F and clean.

7. First, firmly seat the socket fitting on the male face of the heating tool. Then place the female face on the end of the pipe firmly against the cold ring clamp. Heating time starts now.

B. Heating

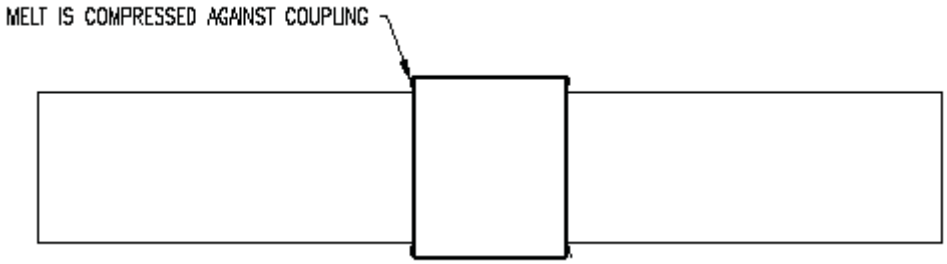
1. While holding the fitting firmly in a fixed position, rotate heating tool slightly to feel the melt, and promote uniform heating of pipe and fitting.

2. Snap the heating tool and fitting from the melted pipe by holding upper part of tool handle with one hand and rapping sharply on the handle with the free hand. Immediately remove fitting from heating tool.

3. The heated parts are inspected quickly to make sure all surfaces have been melted. See Figure 17-1.

4. If melt is not complete, cut off melted pipe end, use a new fitting, and repeat fusion process from the beginning.

Figure 17-1
Socket Fusion



C. Fusion and Cooling

1. Within 3 seconds after the heating tool has been removed, firmly push the melted fitting squarely onto the pipe and until it makes firm contact with the cold ring clamp. DO NOT TWIST. Hold the fitting firmly in place for total cooling time shown in Table 17-4 to insure proper alignment.

2. After waiting 3 additional minutes cooling time, remove the cold ring clamp and inspect the joint. A good joint will have a uniform melt ring that is flat against

the socket and perpendicular to the pipe. There should be no cavity between the fitting and the pipe.

3. Wait an additional 10 minutes to complete cooling before the pipe joint is tested or stressed during burial.

Table 17-4
Socket Fusion Time Cycles – Yellow or Orange Pipe

Pipe Size (inches)	*Heating Time Cycle (seconds)	Cooling Time Cycle (seconds)
1/2" CTS	6	30
1" CTS	9	30
2" IPS	16	45
3" IPS	20	60

* Guidelines only, exact time depends on environmental conditions and condition of fusion equipment.

17.10 Saddle Fusion Joint Procedure -Yellow or Orange Pipe

The use of application tool is required for installing service tap tees and service saddles. An application tool is required for installing branch saddles. Assemble application unit according to manufacturer's instructions and position on pipe.

A. Surface Preparation

1. Remove surface skin from the melt areas of the clean, dry pipe and saddle fitting by roughening with medium grit emery or garnet cloth.

2. Brush away residue with dry rag after roughening. Clean area with alcohol and lint free material.

B. Heating

1. With the heating surfaces of the tool at 500°±10°F place the tool in position on pipe. Place fitting against heater faces and apply pressure.

2. Heat for time shown in Table 17-5 or 17-6.

3. With experience, the iron can be rotated slightly and slowly as the melt forms--do not rotate excessively as this will enlarge the melt pattern on the pipe.

Table 17-5 Service Tap Tee and Service Saddle Fusion Time Cycles		
IPS PIPE SIZE (INCHES)	*HEATING TIME CYCLE (SECONDS)	COOLING TIME CYCLE (SECONDS)
2	30	60
3	40	60
4	40	60
6	40	60
8	40	60
12	40	60

Table 17-6 Branch Saddle Fusion Time Cycles - with 2" Outlet		
IPS PIPE SIZE (INCHES)	*HEATING TIME CYCLE (SECONDS)	COOLING TIME CYCLE (SECONDS)
2	60	120
3	70-80	120
4	75-90	180
6	80-90	180
8	80-90	180
12	Visual	180

* Guidelines only, exact time depends upon environmental conditions and conditions of fusion equipment.

4. After proper melt time, raise fitting and remove heater from pipe. DO NOT displace melt on pipe and fitting surfaces. Check melt pattern on pipe and fittings--heated surfaces on fitting and pipe should be 100% melted with no cold spots. (Use a mirror to check the melt on the under surface of the saddle base.)

C. Fusion and Cooling

1. If melt patterns are satisfactory, press the fitting on the pipe quickly (within 3 seconds) with a pressure of 60-80 psi until a melt bead of the following size appears around the entire base of the fitting:

PIPE SIZE	BEAD THICKNESS
2"	1/8"

3" & larger	larger than 1/8"

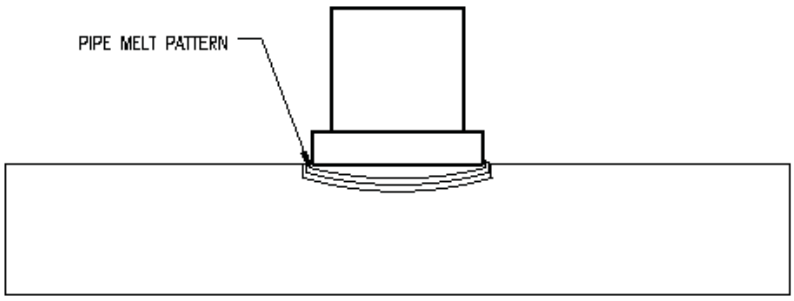
Adjust fusion unit to maintain pressure of fitting on pipe. Allow fusion joint to cool for at least the times indicated in Table 17-5 or 17-6 before releasing pressure. If melt pattern on fitting or pipe is unsatisfactory after heating, apply fitting to pipe and let cool. Remove cutter from tapping tee and cut off fitting top to avoid misuse later. Repeat procedure from Step (a).

2. After letting joint cool 3 minutes beyond that shown in the tables, remove application unit from pipe.

3. Visually check fitting for fusion melt bead around entire fitting base. See Figure 17-2 for visual parameters of proper Saddle Fusion. If fusion joint quality is unacceptable or doubtful, cut off fitting top and apply a new fitting to a new section of pipe.

4. Let fusion cool an additional 10 minutes prior to pressure testing and tapping the main.

Figure 17-2
Saddle Joint



17.11 Butt Fusion Joint Procedure

A. End Preparation

1. Clean each pipe end with alcohol using lint free materials.

2. Insert facing unit between pipe ends and lock onto guide rods. Face ends of pipe to be fused.

3. Check alignment of pipe ends. Adjust high-low if necessary. If adjustment is made, reinsert facing unit and give several additional turns without repositioning the pipes in the clamps.

4. Check heater plate for temperature and wipe surface clean.

B. Heating

1. Insert heater plate between aligned ends and bring ends firmly in contact with plate, but DO NOT APPLY PRESSURE.

2. Heat for times shown below.

Table 17-7
Butt Fusion Time Cycles for Orange or Yellow MDPE Pipe

IPS PIPE SIZE (INCHES)	*HEATER AT 500°(+)10°F	*HEATER AT 440°(+)10°F	COOLING TIME CYCLES (SECS.)
2	15	40	150
3	20	50	200
4	30	60	260
6-SDR 21	25	60	210
6-SDR 11.5	40	90	390
8-SDR 11.5	62	100	495

Table 17-8
Butt Fusion for Dupont Aldyl "A" (Tan) Pipe

IPS PIPE SIZE (INCHES)	*HEATER AT 340(+)5°F	COOLING TIME CYCLE (SECONDS)
6" - SDR 21	120	120
6" - SDR 11.5	150	150

Table 17-9
Butt Fusion for Black HDPE Pipe

IPS PIPE SIZE (INCHES)	*HEATER AT 440(+)5°F	COOLING TIME CYCLE (SECONDS)
12" - SDR 11	Visual	732

* Guidelines only, exact time depends upon environmental conditions and conditions of fusion equipment.

** MDPE pipe and HDPE pipe shall not be directly butt fused to each other.

C. Fusion and Cooling

1. Remove heater plate after achieving proper melt bead.

2. Bring melted ends together rapidly. DO NOT SLAM. Apply enough force to achieve a double roll back of each bead onto the pipe.

3. Allow the butt fusion to cool, under pressure, for the time shown in Table 17-7, Table 17-8, and Table 17-9.

4. DO NOT remove the fused joint from the equipment for an additional 3 minutes after cooling time or until the joint temperature has cooled to 140 degrees F.

   DO NOT test, stress, pull or lay in ground for 10 minutes after removal from fusion unit.

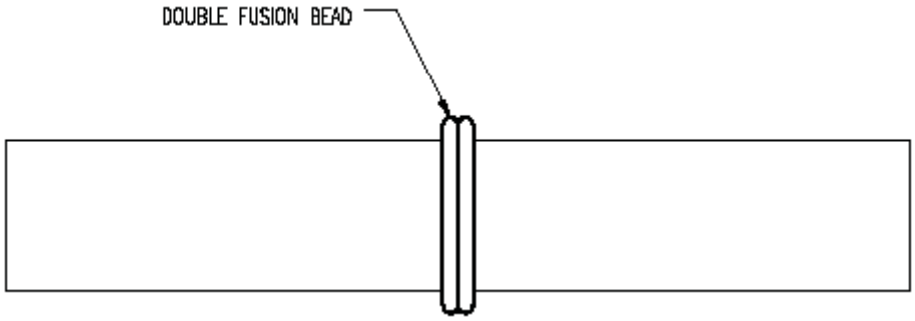
5. See Figure 17-3 for visual parameters of a proper fusion.

   Each bead after fusion should have approximately the following diameters:

Table 17-10
Bead Diameter after Fusion

PIPE SIZE	SDR NO.	BEAD THICKNESS
2" IPS	11	1/16" TO 1/8"
3" IPS	11 - 13.5	1/8"
6" IPS	11 - 13.5	3/16"
8" IPS	11 - 13.5	1/4"
12” IPS	11 - 13.5	1/4” TO 3/8”

Figure 17-3
Butt Joint



17.12 Procedure for Fusion Joining of Fittings and Pipe Having a Different Base Plastic

Orange and yellow pipe and fittings are of the same base plastic and require no differential time for fusion joining.

Orange or yellow fittings, when being fusion joined to tan colored Dupont Aldyl "A" pipe, require a differential in the required heating times. The tool temperature (500°F ± 5°) does not change for orange/yellow or tan material when making saddle type fusions.

The heating tool shall be first placed on the yellow or orange saddle fitting, which requires a longer heating time; then after the difference in heating time has lapsed between the materials, the companion heating tool is applied to the tan pipe. Both tools are to be removed simultaneously when the remaining time expires. Tables 17-5 and 17-6 shall be used for the orange or yellow heating cycles and the following Table 17-11 for tan colored Dupont Aldyl "A" material.

Table 17-11
Fusion Time Cycles for Tan Dupont Aldyl "A" Pipe and Yellow or Orange Saddle Fittings

*HEATING TIME ON TAN DUPONT ALDYL PIPE YELLOW SADDLE (SECONDS)	*HEATING TIME ON ORANGE OR COOLING TIME (SECONDS)	CYLCLE (SECONDS)
Service Tap Tee/ Service Saddle 20	40	120
Branch Saddle 35-45	60	120

DO NOT remove the fused joint from the equipment for an additional 3 minutes after cooling time.

* Guidelines only, exact time depends upon environmental conditions and conditions of fusion equipment.

17.13 Cold Weather Fusion Procedures for Socket, Saddle, and Butt

Cold weather fusion procedures established below shall be used when temperature is between 0°F and 40°F.

1. All traces of frost, ice, and water shall be removed from both the joining and clamping surfaces. Heating tools shall not be used for this purpose.

2. Cold ring clamps shall be used to check ends of pipe to be joined. If ends of pipe are damaged or distorted, they shall be cut off.

3. Two cold ring clamps may be necessary (one behind the usual location of the first clamp) to prevent slipping due to pipe construction. Shim material of paper or tape must only be inserted in the secondary cold ring, allowing room for expansion of the pipe in the first cold ring during heating cycle.

4. Socket Fusions. The fitting shall be placed on the tool before stabbing the pipe into the tool. Time, in the following table, begins when the pipe is completely on tool. When time is up, snap the pipe from the tool first, followed by the fitting.

5. For cooling times, see Procedures A through D.

   FUSION TIME (SECONDS) - COLD WEATHER

Temperature	40°	30°	20°	10°	0°
1" & 2" Sockets	21	22	23	27	28
3" Sockets	22	23	24	28	29

   Saddle Fusions. Apply the heating cycle in the above table, substituting main size. If melt is not satisfactory, begin at new location and increase time by not more than 3 seconds per trial.

   Butt Fusions. Apply the same heating cycle as in warm weather. If good joint is not obtained, cut out joint, repeat procedure increasing heating cycle. Do not increase pressure on joint to compensate low temperatures.

17.14 Plastic Pipe Couplings, LYCOFIT Installation Procedure, 1/2" SDR 7 Pipe

A. Make sure size and wall thickness or SDR marked on LYCOFIT matches those of pipe to be joined. Refer to illustration package with each fitting.

B. Make sure inside and outside of pipe and LYCOFIT are clean and dry. **DO NOT LUBRICATE PIPE, TUBING OR LYCOFIT!**

C. Slide LYCOFIT SLEEVES onto pipe first.

D. Position pipe jaw vise grip on pipe. Use only the LYCOFIT assembly tool, insert LYCOFIT spigot into pipe until pipe covers last barb on spigot. DO NOT INSERT AGAINST PIPE STOP.

E. Remove vise grip, advance the LYCOFIT sleeve over the pipe until it meets the flange on the spigot.

F. Pressure test to comply with Construction Specifications.

17.15 Plastic Pipe Stab Couplings, Con-Stab Installation Procedure, ½" SDR 7 Pipe

A. Verify the pipe or tubing being assembled is the correct size.

B. Cut pipe ends square.

C. Clean piping thoroughly to assure there is **no dirt, grease or oil in assembly area**.

D. Chamfer end of pipe using the Continental O.D./I.D. chamfering tool.

E. Mark the stab depth using one of the methods listed below.

1. Holding the piping against the collar on the fitting, mark the pipe at the entrance of fitting.

2. O.D./I.D. chamfering tool is also a depth gauge. Insert pipe into tool until it stops, mark pipe at entrance of tool.

3. Measure stab length, which is 1-7/8" from chamfered end of piping.

F. Stab pipe completely into fitting so that the mark on the pipe is within 1/8" from the fitting entrance.

G. Pressure test to comply with Construction Specifications.

17.16 Electrofusion Couplings (1", 2", 3", 4", 6", 8", 10", 12") Installation Using an Approved Electrofusion Unit

A. Electrofusion Joining Equipment Calibration

Electrofusion processing equipment shall be factory calibrated annually, not to exceed 15 months. Each electrofusion processor shall be identifiable with a unique serial number. A sticker affixed to the equipment or documentation accompanying new equipment shall identify the most recent date of calibration and the company which performed the calibration. Electrofusion processing equipment not containing this documentation of calibration history shall not be used to perform electrofusion. At any time, electrofusion equipment with a history of poor performance may be rejected for use by an Engineering Division representative.

B. Electrofusion Joining Procedures:

1. Clean the pipe ends by removing dirt, mud, and other debris, with a clean, disposable lint free material. Clean water can be used for initial cleaning prior to peeling and isopropyl alcohol is recommended after peeling.

2. Check pipe for out-of-round condition. If fusion area is found to be out-of-round, take appropriate steps to bring fusion area back within required tolerances.

3. When preparing pipes to install an electrofusion coupling, cutting of the pipe ends shall be accomplished by using a blade type cutter, tubing cutter, or guillotine pipe cutter.

4. Cuts to pipe end shall be as square as possible with a maximum out of square of 3 degrees.

5. Measure the stab depth on both pipe ends by placing the coupling next to the pipe as required by the manufacturer and marking the depth with a non-greasy marker.

6. Check the pipe surface for any embedded debris that may cause damage to the peeling tools and once more make sure that the outer pipe surface is clean and free of any dirt or mud that could contaminate the peeled pipe surfaces.

7. Peel the outside of the pipe surface to remove oxidation and other contaminates. Use an appropriate peeling tool, as recommended by the pipe or fitting manufacturer and approved by the Public Works and Utilities Department. Peel the pipe surface until the outer layer or "skin" of the pipe has been removed to expose a clean, virgin pipe material as per pipe manufacturer's recommendation. Inspect the entire peeled area to ensure total peeling coverage. For pipe smaller than 6-inch, if a coupling is to be pushed completely over one pipe end, peel the pipe end for the entire length of the coupler to prevent contamination of the coupler by sliding over unpeeled pipe. **Do not use abrasives, grinding wheels, or other devices that do not cleanly remove the contaminated material.**

8. Clean peeled area thoroughly with a clean, lint free towel and isopropyl alcohol and allow to dry before assembly. Avoid touching the peeled pipe surface or the inside of the coupler as body oils and other contaminates can affect fusion joint performance. If the surfaces become contaminated, repeat cleaning procedure. Do not use alcohol with any additives other than water.

9. Place the fitting on the area to be fused and restrain using an approved restraint device.

10. Attach processor leads to the fitting and proceed with fusion as described for standard joining, per manufacturer's instructions.

11. Disconnect and remove processor leads when fusion cycle is complete.

12. Allow fitting to cool in accordance with recommended cooling time before pressure testing or rough handling.

C. Electrofusion Couplings:

1. For New Installation:

   Slide coupling half-way over one pipe end. Slide mating pipe into other half of coupling so that the coupling lines up between the marks made in step 4 of **Electrofusion Joining Procedures.**

2. For Repair:

   Slide one coupling over each end of repair section of pipe. Position repair section of pipe in place between existing pipe ends. Slide couplings over the joints to line up between the marks made in Step (d) of **Electrofusion Joining Procedures.**

17.17 Electrofusion Tapping Tees (2”, 3”, 4”, 6”, 8”, 12”) Installation Using an Approved Electrofusion Unit

Electrofusion Tapping Tee Procedures

1. Clean the area of the pipe to be fused by removing dirt, mud, and other debris, with a clean, disposable lint free material from pipe ends. Clean water can be used for initial cleaning prior to peeling and isopropyl alcohol is recommended after peeling.

2. Check pipe for out-of-round condition. If fusion area is found to be out-of-round, take appropriate steps to bring fusion area back within required tolerances

3. Identify the location of the fitting to be installed on the pipe, as recommended by the manufacturer, by marking the area with a non-greasy marker.

4. Check the pipe surface for any embedded debris that may cause damage to the peeling tools and once more make sure that the outer pipe surface is clean and free of any dirt or mud that could contaminate the peeled pipe surfaces.

5. Peel the outside of the pipe surface to remove oxidation and other contaminates. Use an appropriate peeling tool, as recommended by the pipe or fitting manufacturer and approved by the Public Works and Utilities Department. Peel the pipe surface until the outer layer or "skin" of the pipe has been removed to expose a clean, virgin pipe material per pipe manufacturer’s recommendation. Inspect the entire peeled area to ensure

total peeling coverage. **Do not use abrasives, grinding wheels, or other devices that do not cleanly remove the contaminated material.**

6. Clean peeled area thoroughly with a clean, lint free towel and isopropyl alcohol and allow to dry before assembly. Avoid touching the peeled pipe surface or the inside of the coupler as body oils and other contaminates can affect fusion joint performance. If the surfaces become contaminated, repeat cleaning procedure. Do not use alcohol with any additives other than water.

7. Remove the fitting from the bag. Clean fitting with alcohol and lint free towel if needed, then place it in the area to be fused.

8. Without moving the fitting, slide the under clamp onto the base of the fitting.

9. Make sure the fitting is centered in the under clamp and then pull the cantilever into the secure position.

10. Attach processor leads to the fitting and proceed with fusion as described for standard joining, per manufacturer's instructions.

11. Disconnect and remove leads when fusion cycle is complete.

12. Allow fitting to cool in accordance with recommended cooling time before pressure testing or rough handling.

17.18 Re-Fusion of Electrofusion Fittings

Central Plastics electrofusion fittings can be re-fused (Engineering or welders approval needed) only in the event of an input power interruption, i.e. fusion leads were detached during fusion, generator runs out of gas, processor malfunction, or other circumstance that results in processor input power interruption.

The recommended procedure for re-fusing fittings is:

a. Fitting should remain in clamped position and be allowed to cool to ambient temperature.

b. The fitting should be reconnected to the processor and fused for the entire fusion time.

This re-fusion procedure should be used for fusions that terminated due to input power reasons only.

Fittings that fault for any other reason should be cut out and replaced.

17.19 Branch Main Connections, 2" and Larger

Connections to mains not in service may be made by the Department or the Contractor. Fused tees shall be installed where the branch and main are the same size or one size under. For branches more than one size under, saddles or tees and reducers may be used.

Connections to mains which are in service (live) shall be done by the Department or the Contractor where tapping tees or high volume tapping tees are used. Connections to live mains which use saddles shall only be completed by the Department.

Excavation, backfill, and restoration shall be included as the Contractor's responsibility for all planned connections.

Hot tapping shall be performed only by trained & qualified personnel according to Section 17-21.

Department will furnish tools, machines, and personnel for any required valve operation on existing mains.

For squeezing of existing PE gas mains, the Contractor shall squeeze all 3-inch and smaller mains and services for the proposed work. The Department shall furnish tools, machines, and personnel for squeezing all 4-inch and larger mains.

Branch connections to mains in service (live) will follow these policies.

17.20 Branch Connection Policy to Plastic Mains in Service

Plastic branch connections to live plastic mains will be made with branching saddles or electrofusion high volume tapping tee. Saddle shall be the same plastic type and grade as the live plastic main. Different plastics shall join at socket joints when necessary.

17.21 Hot Taps on Gas Main - Procedures, Training and Qualifications

Tap fittings shall be connected to mains only by qualified welders or fusers.

Tap fitting connection must be pressure tested for leakage before tapping begins.

The person performing the hot tap shall be OQ qualified for the specific task.

Instruction reference manuals or procedures shall be made available on the job site for each respective tap, except the self-tapping tees.

Table 17-12
Hot Taps Schedule

Type of Tap	Size	Detail	Machine Used	Operator(s)
PE Service Tees	½" & 1"	G-10 G-11	None - self tap w/hex tool	Welders Contractor Certified U.O. Personnel
PE Branch Saddles	2" & 3"		Dupont 2" B.S. Tapping Tool	Welders
Electrofusion High Volume Tee	2”		High Volume Tapping Tee Tool	Welders Contractor Certified U.O. Personnel

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18.01 General

This section of the Standard Specifications establishes requirements and policies for the installation of both steel and plastic gas distribution and transmission valves.

18.02 Valves

Flanged valve shall be installed where indicated on the Plans. Valves shall be set upright, on blocks to undisturbed earth and backfill tamped around and up to a point 4 to 6 inches below the top of operating nut.

The box, as specified in Section 14.05.05, shall be adjusted to proper height by first cutting the top stem of the plastic bottom section. If necessary, the bonnet portion may be trimmed to shorten the height. Bottom section shall be set on 2-inch wood blocking and uniformly backfilled to keep the box plumb and on center. Box shall not rest on valve or on main.

Valves installed on the inlet side of regulator stations will be located at sufficient distance to permit the operation of the valve during an emergency.

Valve types, when not indicated on the Plans, shall be determined from the following current Department practice:

	PE Ball Valve 1”	PE Ball Valve 2” & 3”	PE Ball Valve 4”, 6”, & 8”	PE Ball Valve 12”	Steel Gate (Kerotest) 2” & over	Steel Ball 2” & over
Line Valves in PE Mains		X	X	X		
PE to PE Branch	X	X	X	X		
PE Service	X	X	X			
PE Branch Off Steel with No-blo Tee Connex		X				
Tap Off Steel Main					X	X
Reliefs (Above Ground)					X	X
Line Valves for Steel Mains		X	X	X	X	X
Steel Risers (2” & larger)					X	X
Reg. Station (Above Ground)					X	X

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19.01 General

All testing apparatus shall be furnished and installed by the Contractor. Cost of testing shall be incidental to the main or service. Mechanical test gauges used by the Contractor shall be a minimum 2 ½" diameter. Gauge shall display units in PSI from 0 to 120 or 0 to 160 and shall have intermediate increments of 2 PSI minimum. Electronic test gauges with digital readout and the capability to output data for recording purposes will also be accepted.

19.02 Transmission Line Testing (Operating at Hoop Stress of 30% or more of SMYS [192.505(a)])

A. Test Pressure: The minimum test pressure will be 150% of the maximum operating pressure in Class 3 and 4 locations, and will be 125% of the maximum operating pressure in Class 1 and 2 locations. The maximum test pressure depends on the strength of the pipeline and the components in it. If water is the test medium, elevation must be considered.

B. Test Medium: In Class 1 or Class 2 locations, if there is a building intended for human occupancy within 300 feet of a pipeline, a hydrostatic test is required (except as noted below) on the segment within 300 feet of such a building, but in no event may the test section be less than 600 feet unless the new or relocated pipe is less than 600 feet.

NOTE: Air or inert gas may be used if the building is evacuated while the hoop stress exceeds 50% of SMYS.

In Class 1 and Class 2 locations, the regulator station must be tested to at least Class 3 location requirements. [192.505(b)]

C. Test Duration: The test pressure must be maintained for a minimum of eight hours in addition to the stabilization period. [192.505(c)]

D. Fabricated Units and Short Sections: For fabricated units and short sections of pipe, where post installation test is impractical, pre-tested pipe shall be used. Pretested pipe must be pressure tested for at least four hours. [192.505(e)]

E. Components Other Than Pipe: No test is required for components that are the only item being replaced if:

The component was tested to at least the pressure required for the pipeline to which it is being added, or the component was manufactured under a quality control system that ensures that each item manufactured is at least equal in strength to the pressure required for the pipeline to which it is being added (fittings, valves, regulators, relief valves, etc.).

19.03 Gas Main Testing

All new or reinstated mains shall be pressure tested after backfilling but before being placed into service. Main shall be isolated from the existing system. Valves shall not be used to isolate or to hold test pressure. On tie-ins and appurtenances, where the air test is impractical, the test shall consist of soap testing all joints and fittings under operating pressure, provided pre-tested pipe is used (Section 16).

Mains to have an MAOP of 66 psig or less shall be pressure tested with air at 100 psig. Mains to have an MAOP greater than 66 psig, but operating at a hoop stress less than 30 percent of SMYS, shall be pressure tested to MAOP x 1.5 with air, inert gas, natural gas or water as approved by the Engineer. Mains to have an MAOP greater than 66 psig and capable of operating at pressures up to a hoop stress equal to 30 percent of SMYS shall be tested at a pressure equal to 30 percent SMYS with air, inert gas, natural gas, or water as approved by the Engineer. Test duration shall be in accordance with the following table, but in no case more than 24 hours for steel pipe or high density polyethylene pipe.

For medium density polyethylene pipe, the maximum test duration shall be 8 hours including time to pressurize, time for initial expansion, time at test pressure, and time to depressurize the test section. Time to pressurize the test segment shall not exceed 48 minutes. If the test is not completed due to leakage, equipment failure, or for any other reason, depressurize the test section completely, and allow it to relax at least 8 hours before pressurizing the test section again.

Table 19-1
Pressure Test Durations for Gas Main

Size	Test Time Hours per 1000' *	Minimum Time
1"	1.0	-
2"	1.0	2.0
3"	2.0	3.0
4"	3.0	4.0
6"	4.0	4.0
8"	4.5	6.0
10"	9.0	8.0
12"	12.0	8.0
16"	24.0	8.0

* For MDPE pipe test durations requiring longer than 8 hours, a testing plan shall be approved by the engineer.

Mains requiring a test duration greater than 12 hours shall have a recording gauge monitoring the test.

Qualified department employee shall monitor and certify the test, showing initial and final time and pressures, date, and signature. Records of all pipelines operating at more than 100 psi will be retained for the life of the pipe.

19.04 Gas Services Testing

All new or reinstated gas services installed on live mains shall be pressure tested. Reconnected services are not required to be tested. Refer to Section 29 for the definition of reconnected service. Services shall be pressure tested individually and separate from the main or meter connection plumbing unless approved by Engineering. Before it is tapped, test shall include the riser, meter stop valve, and the attached service tee.

A repaired service must be pressure tested from the repair to the meter stop valve. Final joint at repair coupling may be soap tested.

Test gauge shall be installed on the outlet side of the opened meter stop valve.

All service lines shall be tested with air and accepted if it maintains 100 psig for the duration shown below:

Table 19-2
Pressure Test Durations for Gas Service

Size	Test Time Hours per 1000'	Minimum Time
½”	0.5	0.5
1"	1.0	1.0
2"	1.0	2.0
3"	2.0	3.0
4”	2.0	4.0
6"	4.0	4.0

Accepted service can then be tapped to the main, the tap or punch tee cap soap tested, the service purged, and a threaded plug installed on the meter stop valve.

Service lines may be installed and tapped on PE mains not in service. Both main and service shall be tested to pressure and duration required for the main.

Mains not in service and to which services are to be connected and tested shall contain air pressure between 30 psi and 50 psi to enable a soap test of the tap or punch tee cap. Purging shall immediately follow or be done simultaneously with the main purging.

Each completed and purged service will have a pin type lock installed immediately by

Department personnel. Lock will be removed only by Department personnel or authorized personnel.

Qualified department employee or Utility Operations Leadworker shall monitor and certify the test, showing initial and final time and pressures, date, and signature.

19.05 Meter Set Testing

All meter sets shall be pressurized with air at 50 psi and submerged under water for one minute to inspect for leaks or tested for 30 minutes when not submerged. Meter sets may be pretested in a shop or field tested. Final connections shall be soap tested when placed into service.

Non-standard meter sets that are assembled in the field from 100% pre-tested components may be soap tested when completed and placed into service.

19.06 Fuel Line Testing

Where City personnel, or contractors working on behalf of the City, install fuel lines, the fuel lines shall be air tested at 1 and 1/2 times the operating pressure or 25 psi for 30 minutes except that fuel lines serving single family homes may have the test duration reduced to 10 minutes.

19.07 Test Records

All pressure test records shall be kept for the life of the facility +5 years. Document any leaks, failures, and their disposition, and any significant elevation variations on the applicable forms.

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20.01 General

This section of the Standard Specifications establishes requirements and policies for purging HP gas pipelines, transmission mains and services.

20.02 Purging High Pressure Gas Mains and Services, gas to air and air to gas

Safety and Preventing Accidental Ignition

A. Whether purging the line from air to gas or from gas to air, the purging material shall be introduced at a rate indicated in the purging table. If this rate cannot be achieved, then a slug of inert gas such as nitrogen must be introduced into the line before purging begins, to separate the gas and air.

B. Before purging begins, all sources of potential ignition must be removed from the area, and a fire extinguisher must be on site and visible.

C. Warning signs shall be posted where appropriate to caution or instruct others who are in or near the affected area.

D. Dispatch (218-730-4150) shall be notified if a gas main is to be purged to the atmosphere in the downtown or other commercial area.

20.03 Distribution System

20.03.01 Purging 2" or larger Pipes

A. Purging 2" and larger mains or services shall be by Department personnel or by the Contractor as directed by a Department inspector. Purge stacks at exit end of pipe are required.

B. Purging of mains and services smaller than 2-inch shall be done by the Contractor.

C. Entry and exit fittings and apparatus should not restrict flow velocity to less than 200 feet per minute through the purged pipe. The main shall not be purged through services with an EFV.

Table 20-1
Purge Venting

Pipe Size to be Purged	Volume (CFH) to obtain Vel of 200 FPM	*Max Length of ½" pipe if used to exit purge gas
2"	280	440'
3"	615	110'
4"	1060	35'
6"	2410	Engineer to Determine
8"	4325	Engineer to Determine
10"	6880	Engineer to Determine
12"	9825	Engineer to Determine
16"	15720	Engineer to Determine

*Based on 15 PSI min - inlet pressure

D. Stack shall be a grounded metal stack, a minimum of one size smaller than the line being purged. Stack shall extend at least 6' above grade and be directed upward but angled away from wall if at a building.

E. Person at purge location shall have visual or audio communication contact with person at control valve.

F. Purging air to gas should be continuous at each purge point until a gascope indicates at least 85% pure gas. Where possible, valved branches should be turned off until that branch is purged. Any connected services also purged consecutively and without delay. On a system with several purge locations not isolated by valves, the highest ends shall be purged first.

   Purging gas to air should be continuous until a mixture less then 10% LEL is measured at venting end.

20.03.02 Purging 1" or 1/2" Gas Services

Purging 1" or 1/2" gas services shall be done by the Contractor while under direct Department supervision.

20.04 Purging 10" Great Lakes Interconnect Transmission Line from Gas to Air

In general, the pressure in the transmission line should be reduced by closing the valves at the Great Lakes Custody Discharge Point (GLCDP) south of Oliver, Wisconsin, and letting the gas flow into the City of Duluth's distribution system through the Great Lakes Regulator Station (GL Reg Sta) in Gary New Duluth.

If there is an immediate hazard to human life, then the line should be isolated ASAP and the gas within the line should be vented to the atmosphere using the blowoff valves at either the GLCDP and/or GL Reg Sta. After the 10" pipeline has been isolated and the gas pressure reduced to near 0, it must be purged of all natural gas before work can begin on the 10" line. This line will be purged of all natural gas using the procedures as listed below.

A. A drawing depicting the work shall be prepared that at a minimum includes the following:

    1. Work site and work to be performed
    2. Location of shut off points
    3. Area to be affected

B. A coordination meeting must be held prior to purging the line to ensure all personnel understand the purging procedure.

C. Items to be reviewed and/or coordinated at this meeting shall include the following:

    1. Finalizing date and time for purging to take place.
    2. Schedule notification of affected companies/agencies (Great Lakes Gas Transmission Company, City of Duluth PW&U, police and fire departments, etc.).
    3. Discuss the hazards involved, such as weather conditions, power lines, public highways, railroads and other obstructions.
    4. Notification schedule for houses near the GLCDP and GL Reg Sta.
    5. Any other items deemed necessary.

D. Procedure for Purging Natural Gas from Line using Air Movers

    1. At least 2-20 lb. fire extinguishers shall be at the GLCDP and GL Reg Sta during the entire purging operation.
    2. Gas CGI's shall be recently calibrated and ready for use at the GLCDP and GL Reg Sta.
    3. The Operator will be responsible to ensure that no ignition sources are allowed in the work areas during purging operations.
    4. No flames, smoking, electric hand tools, or electrical equipment shall be used during purging operations.
    5. Do not purge any gas out of the line when an electrical storm is in the vicinity.
    6. Ensure all valves are in the closed position.
    7. Remove the blow off stack blind flange on 4" vertical valve #9738 at pig receiver.
    8. Install an air mover above the 4" vertical valve #9738 at the GL Reg Sta.
    9. Open the 4" vertical valve #9738 below the air mover and turn on the air mover.

10. Remove the blow off stack blind flange on 4” vertical valve #9736 at pig launcher.
11. Open the 4” vertical valve #9736 at pig launcher at the GLCDP. This is the inlet air supply for purging the line of natural gas.
12. Use a CGI at the outlet of the air mover to determine when all the gas has been purged from the main. No work can begin on the line until the gas has been completely purged.
13. The air movers must be continually staffed by personnel in contact with personnel performing work on the line.
14. The air movers must operate continuously until all welding has been completed.
15. Reduce the pressure settings on the air movers to reduce the vacuum on the pipeline to eliminate the blow-in of welds as the pipeline is closed to the atmosphere.
16. Once all work has been completed, the air mover can be removed.
17. Close 4” vertical valve #9724 at pig receiver. Reinstall 4” blind flange on blow off stack. Use a new gasket when reinstalling the blind flange.
18. Close 4” vertical valve #9738 at pig launcher. Reinstall 4” blind flange on blow off stack. Use a new gasket when reinstalling the blind flange.
19. Purge air from the pipeline in accordance with Section 13.03 and return it back into service.

20.05 Purging 10” Great Lakes Interconnect Transmission Line from Air to Gas

After all work on the transmission line has been completed, the pipe must be purged of all air before returning it to service. In general, the line will be purged from the Great Lakes Custody Discharge Point (GLCDP) south of Oliver, Wisconsin, to the City of Duluth’s Great Lakes Regulator Station (GL Reg Sta) in Gary New Duluth. This line will be purged using the procedures as listed below.

A. A drawing depicting the work shall be prepared that at a minimum includes the following:

    1. Work site and work to be performed
    2. Location of shut off points
    3. Area to be affected

B. A coordination meeting must be held prior to purging the line to ensure all personnel understand the purging procedure.

C. Items to be reviewed and/or coordinated at this meeting shall include the following:

    1. Finalizing date and time for purging to take place.

2. Schedule notification of affected companies/agencies (Great Lakes Gas Transmission Company, City of Duluth PW&U, police and fire departments, etc.).
3. Discuss the hazards involved, such as weather conditions, power lines, public highways, railroads and other obstructions.
4. Notification schedule for houses near the GLCDP and GL Reg Sta.
5. Any other items deemed necessary.

D. Procedure for Purging Air from Line

1. At least 2-20 lb. fire extinguishers shall be at the GLCDP and GL Reg Sta during the entire purging operation.
2. Gas CGI's shall be recently calibrated and ready for use at the GLCDP and GL Reg Sta.
3. The Operator will be responsible to ensure that no ignition sources are allowed in the work areas during purging operations.
4. No flames, smoking, electric hand tools, or electrical equipment shall be used during purging operations.
5. Ensure all valves are in the closed position.
6. Install a 0 to 100 psi pressure gauge near the GLCDP 10" pig launcher valve #9724 to be used for pressurizing the 10" line.
7. Remove the blow off stack blind flange on 4" vertical valve #9738 at pig receiver. Ensure stack is grounded.
8. Open the 4" vertical valve #9738 on pig receiver at GL Reg Sta.
9. To start purging, bring the inlet pressure at the GLCDP quickly to 12 psi using the 10" valve #9724 on the pig launcher. Maintain this pressure for 12 minutes.
10. At the end of the 12 minutes, turn off the 10" valve #9724 at the GLCDP.
11. Leave the 4" vertical valve #9738 on pig receiver at the GL Reg Sta open for an additional 6 minutes. Use a CGI to analyze the gas-air mixture throughout the purging operation and confirm that the gas is free of any air.
12. Close the 4" vertical valve #9738 on pig receiver at the GL Reg Sta.
13. Remove 0 to 100 psi gauge at pig launcher.
14. Open the valve at the GLCDP to load the pipeline at a controlled rate of 100 psi for the first hour.
15. After the pipeline has been pressurized to 100 psi, the loading rate can be increased @ 200 psi per hour.
16. Once the pressure has equalized on both sides of the valve, the 10" valve #9724 can be fully opened and the 10" pipeline can be placed back into service.
17. Reinstall the 4" blind flange on the blow off stack for valve #9738 on the pig receiver. Use a new gasket when reinstalling the blind flange.

20.06 Pigging Procedure for the 10" Great Lakes Interconnect Transmission Line

A. General Pigging Information

The City Engineering Division and Lake Superior Consulting developed the following pipeline pigging procedure for running cleaning pigs, gauge plate tools, caliper tools, and other smart pigging tools including MFL and IMU tools through the Great Lakes Interconnect Transmission Line beginning at the tap side on Irondale Road to the Great Lakes TBS. This procedure shall be approved for or modified by the Engineering Division prior to any pigging operations.

1. Additional safety precautions during pigging operations and purging of un-odorized gas:

    a. Employees shall take additional precautions with FR clothing within the tool launcher and receiving areas.
    b. Be prepared to test any pipeline debris removed from the receiver tube for NORM (Naturally Occurring Radioactive Material).
    c. Cell phones and other non-intrinsically safe devices are not permitted within the launching and receiving areas, use of Department intrinsically safe 800 MHz radios is recommended.
    d. Use only non-sparking tools within the launching and receiving areas during the procedure.

2. The City shall operate the transmission main during the pigging such that the tool speeds are generally maintained in the following ranges:

    a. Cleaning tools: < 8 mph
    b. Gauge plate and smart tools: 3-5 mph
        i. Historically, a 500 MCFH gas flow rate would approximately produce a tool speed of 3 mph.
        ii. Typical tool traveling duration from the launcher to the receiver should be between 2 and 3 hours.

3. Sequence and Procedure for Launching and Receiving Pigs

    a. Overview
        i. Sequence valves at Receiver Valve Site to receive pig
        ii. Preparation at Launcher Valve Site to load pig
        iii. Sequence valve to isolate and depressurize Launcher Barrel
        iv. Load pig, secure closure, and pressurize Launcher Barrel
        v. Sequence valves to launch pig
        vi. Return valves at Launcher to “Normal Operation” position
        vii. Gas Control to regulate flow to control speed of the pig during the run
        viii. Tracking and Deployment/Retrieval of AGM’s during pig run

ix. Receive pig, sequence valves to isolate and depressurize Receiver Barrel
x. Preparation of Receiver and removal of pig
xi. Secure Receiver Closure
xii. Return ALL valves to “Normal Operation” position

b. Refer to Exhibit 20-1 as the Pigging Procedure and Valve Sequencing – Pig Run Field Checklist.

Exhibit 20-1
Pigging Procedure and Valve Sequencing – Pig Run Field Checklist

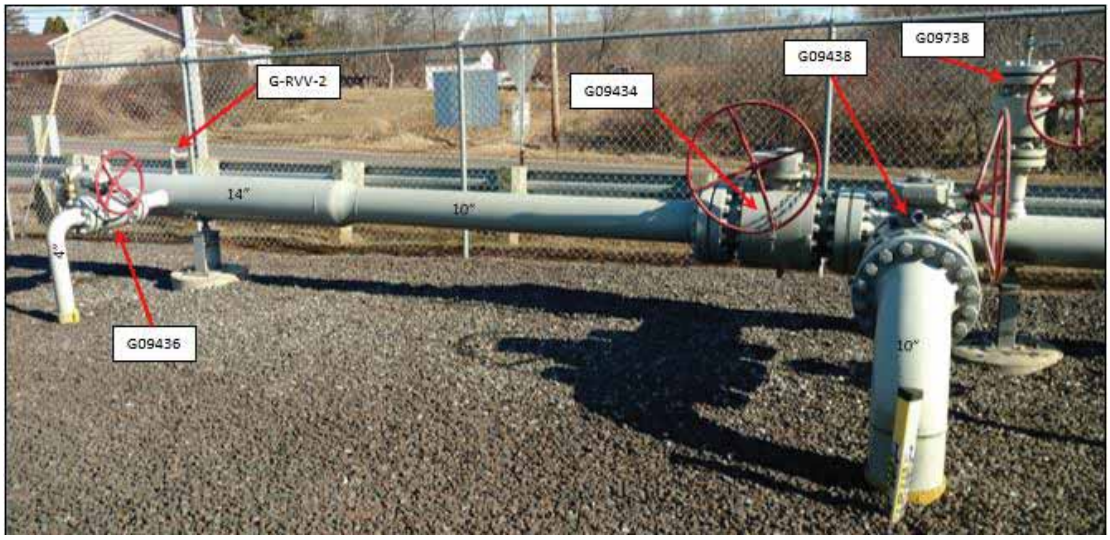
	CITY of DULUTH		
	LINE NAME: 10" NG Transmission		
	SEGMENT: GLGT VS to TBS		
	DATE of Run:		
	TYPE of Pig Run During This Procedure: FOAM Swab Pig: _____ POWER Brush Pig: _____ GAUGE Plate Pig: _____ CALIPER Pig: _____ MFL Pig: _____ EMAT Pig: _____ IMU Unit: _____ **Take Pre and Post pictures of Pig**		
	TAILGATE Meeting: YES NO N/A		
	Please attach a copy of the TAILGATE Meeting to this document		
	CITY of DULUTH Contact Names	**Phone**	**Number**
1			
2			
3			
4			
	CONTRACTORs Contact Names and Company Name	**Phone**	**Number**
1			
2			
3			
4			
5			
Team	**PIG TRACKERS**	**Phone**	**Number**
A			
B			
C			
	Weather:	**Temp:**	

USE PAGES 10 – 17 for Each Pig Run (No AGM Tracking)

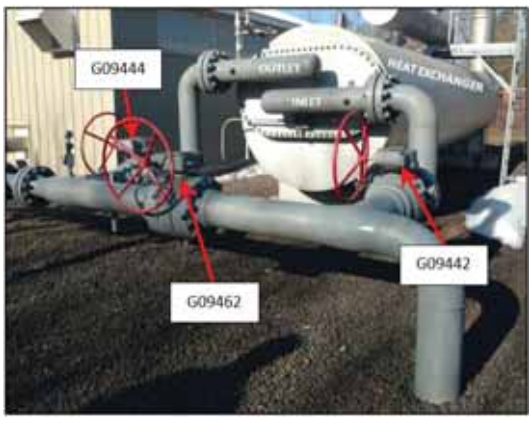
USE PAGES 10 – 20 for Each Pig Run When AGM Tracking

LAUNCH and RECEIVE ROCEDURE Steps

Step	Action	Initial	Time
	At the RECEIVER SITE (City of Duluth Town Border Station)		
PRE	**IF this pig run includes using AGMs (Above Ground Markers), the Pig Trackers will verify that the units are working and complete the form in Appendix 1 – Pages 18-19**		



1	OPEN Valve G09436 (4" ByPass Valve)		
2	OPEN Valve G09434 (10" Receiver Valve)		
3	CLOSE Valve G09438 by 50% (10" Main Line Valve)		



4	OPEN 8" Valve – G09442		
5	OPEN 8" Valve – G09444		
6	CLOSE 8" Valve – G-09462		
7	OPEN 6" Valve – G13466		
8	CLOSE 3" Valve – G-13444		
10	FLOW is through the 6" Strainer to the Meter Run Building		

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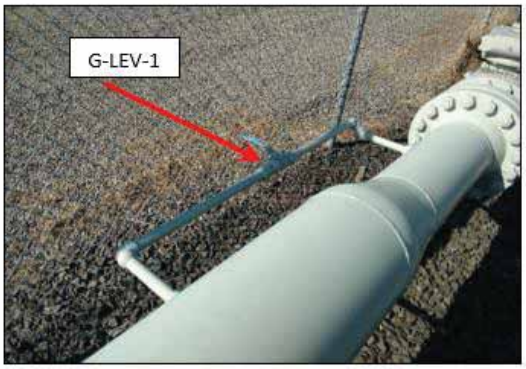
Step	Action	Initial	Time
	At the LAUNCHER SITE (GLGT Valve Station)		
PRE	**IF this is an ILI tool run, the tool vendor will have the tool in the "Run Mode" prior to opening the launcher closure.**		
PRE	**PRIOR to loading the ILI tool into the launcher, complete the Function Checklist in Appendix 2 - Page 20**		
PRE	INSTALL Air Mover unit onto Valve G-LVV-2 (1" Vent Valve)		



1	CLOSE Valve G09726 / LOTO (4" Kicker Valve)		
2	CLOSE Valve G09728 / LOTO (10" Launcher Valve)		
3	OPEN Valve G-LEV-2 (1" Reducer Equalization Valve)		
4	POSITION Personnel with Gas Detectors to Monitor for Air Quality as discussed during the Pre-Job meeting		

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Step	Action	Initial	Time
5	START Air Mover and Slowly open valve G-LVV-2 to Depressurize Launcher Barrel		
6	Leave Air Move running		
7	Do not operate door closure until 0.0 PSI has been confirmed in barrel		
8	LOOSEN the pressure interlocks on the closure door		
	 		
9	OPEN Launcher Closure – Look inside launcher for debris		
	IF this is the ILI tool run, the tool vendor will have bonding cables to bond the tool and transport tray to the launcher		
11	Load pig until front of pig is seated into nominal pipe past the reducer		
12	If pig has a transmitter, use a receiver unit to locate front of pig If pig has no locator, use tape measure to locate front of tool		
13	Service closure based on operating company manual (New O-ring, cleaning, lubrication…. Etc.)		
14	Secure Launcher Closure		
15	CLOSE Valve G-LVV-2 (1” Vent Valve)		
16	STOP Air Mover		
17	Remove LOTO from Valve G09726 (4” Kicker Valve)		
18	Remove LOTO from Valve G09728 (10” Launcher Valve)		
19	SLOWLY Open Valve G09726 and bring the pressure in the launcher up to mainline pressure – make sure not to move pig		
20	FULLY OPEN Valve G09726 (4” Kicker Valve)		
21	**IF tool is equipped with a Transmitter, have Pig Tracker confirm that it is operational before launching**		
22	Communicate with key personnel pig is ready to launch i.e. Pig Trackers, Gas Control, Station Operators		
23	OPEN Valve G09728 (10” Launcher Valve)		
24	CLOSE Valve G-LEV-1 (1” Reducer Equalization Valve)		
25	START to Close Valve G09724 and listen for pig to leave launcher		
26	Communicate with key personnel pig has launched i.e. Pig Trackers, Gas Control, Station Operators		

Continued next page….

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Step	Action	Initial	Time
27	**PIG LAUNCH TIME:**		
28	Contact GAS Control for: Flow Rate: _____ Pressure: _____ @ Launcher		
29	OPEN and Lock Valve G09724 – **Gas Control Will Control Pig Speed**		
30	CLOSE and Lock Valve G09726 – (4" Kicker Valve)		
31	CLOSE and Lock Valve G09728 – (10" Launcher Valve)		
32	REMOVE Air Mover from Valve G-LVV-2 (1" Vent Valve)		
33	RECORD the passage time at each AGM site, relay Pig Speed to Gas Control to maintain a pig tool speed for the type of pig being run FOAM Pig: < 8 mph - GAUGE/BRUSH Pig: 3-5 mph - MFL/CALIPER/EMAT Pig: 3-5 mph		

AGM #	PASSAGE TIME (Hrs:Min:Sec)	Distance From Start (Miles)	CoD STATION # (Feet)
LAUNCHER VALVE		0.00	1+40.76
AGM 1		0.03	3+11.45
AGM 1A		0.45	25+39.00
AGM 2		0.83	45+42.97
AGM 3		1.13	71+74.03
AGM 3A		1.64	88+00.00
AGM 4		1.95	104+23.20
AGM 5		2.16	115+54.53
AGM 5A		2.49	132+97.00
AGM 6		2.82	150+26.16
AGM 6A		3.28	174+35.00
AGM 7		3.77	200+38.84
AGM 7A		4.13	219+29.00
AGM 8		4.15	220+46.18
AGM 9		4.39	233+23.65
AGM 11		5.13	272+33.02
RECEIVER VALVE		5.28	280+12.00

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Step	Action	Initial	Time
	At the RECEIVER SITE (City of Duluth Town Border Station)		
PRE	Install Air Mover onto Valve G-RVV-2 (1” Vent Valve)		

1	**PIG RECIEVE TIME:**		
2	IF pig stops prior to Valve G09434 (10” Receiver Valve) Start to CLOSE Valve G09438 (10” Mainline Valve) Listen for pig to move into oversize section of trap		
3	OPEN Valve G09438 (10” Main Line Valve)		
4	CLOSE Valve G09436 / LOTO (4” ByPass Valve)		
5	CLOSE Valve G09434 / LOTO (10” Receiver Valve)		
6	**SHUTDOWN Heat Exchanger Unit until closure has been secured**		
7	POSITION Personnel with Gas Detectors to Monitor for Air Quality as discussed during the Pre-Job meeting		
8	START Air Mover and Slowly open valve G-RVV-2 to Depressurize Launcher Barrel		
9	Leave Air Move running		
10	Do not operate door closure until 0.0 PSI has been confirmed in barrel		

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Step	Action	Initial	Time
11	LOOSEN the pressure interlocks on the closure door		
	 		
	IF this is the ILI tool run, the tool vendor will have bonding cables to bond the tool and transport tray to the receiver		
12	REMOVE pig ➢ Cleaning pigs to be placed in appropriate containers for disposal ➢ Gauge plate pig to be cleaned, gauge plate removed and photos with measurements will be sent to ILI vendor ➢ ILI Tool to be placed on transport tray and moved onto the vendors truck to be taken for data download/cleaning		
13	Check receiver for debris left behind pig		
14	Service closure based on operating company manual (New O-ring, cleaning, lubrication…. Etc.)		
15	SECURE Receiver Closure		
16	CLOSE Valve G-RVV-2 (1” Vent Valve)		
17	REMOVE all LOTO Tags from Valves		
18	LEAVE Locks on Valves: G09436 (4” ByPass Valve) G09434 (10” Receiver Valve)		
19	START Heat Exchanger Unit		
20	VERIFY **ALL** Valves at the Launcher and Receiver Sites are in the “Normal Operating” Position		
21	REMOVE Air Mover from Valve G-RVV-2 (1” Receiver Vent Valve)		
22	PROPERLY dispose of any debris from the pig run		
23	COMPLETE Tool Function Checklist – Appendix 2		

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PIG RUN SUMMARY	
LAUNCH Time:	
RECEIVE Time:	
AVERAGE Tool Speed:	
WAS Pig Run Acceptable:	YES NO
WILL a Rerun need to be scheduled?	YES NO
COMMENTS:	

APPENDIX 1 – AGM UNIT FUNCTION CHECKLIST

Unit Function Checklist **Date:** _____

AGM	Serial #	STATUS	AGM	Serial #	STATUS
1			16		
2			17		
3			18		
4			19		
5			20		
6			21		
7			22		
8			23		
9			24		
10			25		
11			26		
12			27		
13			28		
14			29		
15			30		

Transmitter Function Checklist

Txmitter #	Manufacture	Serial #	Pulse	Steady	START Time	Comments
1						
2						
WAS Transmitter(s) Checked Just Before Launching?			YES		NO	
WAS Pig Equipped with Magnets Only?			YES		NO	

Tracking Receiver Function Checklist

Receiver #	Manufacture	Serial #	MAG Only	TX Only	Both	Comments
1						
2						
3						
4						

GeoPhone Function Checklist

GeoPhone #	Manufacture	Serial #	Comments
1			
2			
3			
4			
5			
6			
7			

Run Date:		Type of Pig Tracked: CLEANING - GAUGE - CALIPER - MFL	Prepared By:

APPENDIX 2 – CALIPER AND/OR MFL TOOL FUNCTION CHECKLIST

TOOL COMPONENT	Pre-Run	Post Run	# of Bad Sensors	Comments
Main ML Sensors				
Internal ML Sensors				
Caliper Sensors				

TOOL COMPONENT	Pre-Run	Post Run	Comments
Odometers #1			
Odometers #2			
Odometers #3			
Locate Transmitter			
IMU (Internal Mapping Unit)			
Cleanliness of ILI Tool	N/A		
Damage to ILI Tool	N/A		

ATTACH PHOTOs of CALIPER or ILI TOOL DAMAGE

Prepared By:	Print:	Sign:	Date:

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21.01 General

This section of the Standard Specifications establishes requirements and policies for abandoning existing gas pipelines and services.

21.02 Abandoning Transmission Lines

Any transmission pipeline abandoned in place will require a procedure prepared by Engineering prior to any work. Each transmission line section abandoned in place must be physically disconnected from all sources of gas supply.

Any transmission line section abandoned shall be purged of gas following the procedures outlined in Section 20.02, Purging High Pressure Gas Mains & Services.

Purge shall continue until a mixture less than **10% LEL** is measured at vented end.

The Department will provide labor and materials to seal any end still connected to a gas source using standard welded end caps or blind flanges.

21.03 Abandoning Gas Mains

Each pipeline abandoned in place must be physically disconnected from all sources of gas supply. Any main being abandoned which is 2" or larger and a length of 50 feet or longer shall be purged of gas following the procedures outlined in Section 20.02, Purging High Pressure Gas Mains & Services.

Purge shall continue until a mixture less than **10% LEL** is measured at vented end. Mains specified on the Plan to be abandoned shall be abandoned in place except where noted otherwise. The Contractor shall effect the cutoffs where the main is steel or plastic and has been depressurized and purged, if necessary.

The Department or Contractor will provide labor and materials to seal any end still connected to a gas source using standard fuse or welded end caps.

Openings at ends which have been disconnected from any gas source shall be sealed either by Department or Contractor as follows:

2"+ Steel Mains	by weld-on plate, coupling and end cap, blind flange, injected polyurethane foam, fernco cap, or concrete
2"+ Plastic Mains	by fused end cap or injected polyurethane foam
Cast Iron Mains	by M.J. cap, M.J. coupling & plug, tamp on plastic pipe plug, fernco cap (previously injected sealant foam or concrete abandoned)

When removing sections of the previously abandoned low-pressure cast iron gas system, it is necessary to provide at least a 1" Type K copper or PE jumper drain to allow the abandoned system to continue draining freely. The Engineering Division may provide exemptions to this requirement, with alternative directions in areas where the old abandoned low-pressure gas system is on level terrain or the length of the jumper drain becomes excessive.

Injected sealant foam shall be closed cell type. Open cell foam shall not be allowed.

21.04 Abandoning Services (Cut off at main)

Any abandoned service must be disconnected from gas source and depressurized. Purging of gas is required if service is 1" or larger and longer than 50 feet. When purging a service, the same procedure as purging abandoned main (Section 21.02) shall be followed.

A. P.E. Services (1/2" & 1" with P.E. Service Tees). Turn down self-tap cutter, soap and reinstall cap, cut service and attach short capped 1/2" stub with mechanical fitting or fuse-on P.E. cap as close to service tee as practical.

B. P.E. Services (2" with P.E. High Volume Tapping Tees). Turn down self-tap cutter, soap and reinstall cap, cut service and attach short capped stub with mechanical fitting or fuse-on P.E. cap as close to service tee as practical.

C. 1/2" P.E. or 5/8" Service with steel tap tee. Turn down self-tap cutter in mini-tee, reinstall cap, remove extrube steel service, insert short capped +" P.E. stub in compression fitting and retighten nut to seal. P.E. stub must have stiffener installed.

D. P.E. Services (2" & 3" with Tee or branch saddle off P.E. main). Squeeze off service and fuse on end cap as close to main tee as practical. If a P.E. Service valve is too close to main, then shut valve, install end cap just downstream, and do not replace box.

E. Steel Service (1-1/4", 1-1/2" & 2"). Connected to main with weld on No-Blo tee. Remove cap, insert rubber stopper using machine, cut off service, weld a sized steel slug in end, reinstall completion plug and cap.

F. Steel Service (2" & larger which have no tap valve or No-Blo tee). Stopple service as close to main as possible; weld on end cap.

21.05 Partially Abandoning Services (Cut off at service valve)

Steel Service (2" & larger which have tapping valve at main). Shut off service valve, install blind flange on valve, **do not** replace box. If valve is a plug type, it must be

lubricated before burying. Record to remain in active service file and noted as "cut off at valve."

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22.01 General

This section of the Standard Specifications establishes requirements and policies for the installation of service meter connections.

22.02 General Requirements

This work consists of plumbing in gas piping less than 2 inches in diameter above the outside meter stop valve, installing the regulator, meter, and inside stop valve. Plumbing shall conform to Section 2200, Uniform Mechanical Code, with Chapter 1346 MN Amendments, the National Fuel Line Code, as applicable, the Detail Drawings, and the following requirements.

General provisions for installing meters and regulators are contained in Section 30 and in the following provisions.

A. When relocating meters from inside to outside, buildings having 1 or 2 inside meters shall have the new meters installed outside. Buildings with 3 or more inside meters will have the new meters installed inside, unless otherwise specified.

B. Piping shall be extended from inside stop valve to existing gas piping, and piping shall be restored or removed, as necessary, where meters were removed.

C. Abandon any unused underground service piping in accordance with Section 21.

A schedule of connections will be provided.

The Department shall furnish the following materials to Contractor, who shall pick them up from 520 Garfield Avenue:

Service regulator, meter and meter bar or meter mounting bracket, test plugs, or relief devices, as may be required.

All other materials shall be furnished by the Contractor, including:

Gas pipe for plumbing shall be black iron or steel, conforming to Section 14.02.02. Fittings shall be threaded black iron or steel.

Pipe shall not be less than 1" between regulator and small meters whether single or duplex.

Inside Stop and other materials incidental for the installation.

Outside threads of all pipe and fittings shall be doped with Gasoila or Teflon tape.

Prior to installing meters, the meter swivel threads shall be lubricated with "Permatex Anti-Seize" or a similar approved compound.

Pipe supports shall be installed as required to adequately support all piping.

All piping, fittings, valves, and brackets outside of the building shall be cleaned of oil, dirt, scale, and primed with Rust-Oleum Primer #678 or #769, Rustex or DeRusto. Color shall be gray. Spray painting is not permitted. Paint shall be brushed on after the pipes are wiped with a cloth wet with oil cutting solvent.

Removed piping shall be disposed of according to the wishes of the building owner.

One Pete's Plug or equivalent shall be located on the high pressure side of the regulator and a second shall be located on the low pressure side of the regulator on any meter larger than 415,000 BTUs unless approved by the Measurement Services Supervisor.

22.03 Valve Requirements for Gas Meter Connections

A. Inside shutoffs. Each service entering a building must have a lever-operated valve at a convenient location and as close to the entry location as possible. Valves shall be ball type as specified in Department Standard Specifications. Approved lever handle plug type may be used for larger sizes.

B. Meter Stop Valves. Each meter shall have an independent shutoff valve capable of being locked in a closed position with a 1/2" pin type lock. Single or master meter stop (3/4" and 1") are specified in Section 14.04.05. Valves for multiple meter stops shall be as specified in Section 14.04.07, and be tamper-proof, lock-wing type, suitable for locking in a closed position.

Department personnel will immediately install a pin lock on each closed meter stop following installation, testing, and purging of a new gas service. The pin lock shall be removed by Department personnel or Department-authorized person only when testing meter connection work and for light-up purposes.

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25.01 General

This section of the Standard Specifications establishes requirements and policies for the installation of cathodic protection materials.

25.02 Anode Installation

For the protection of steel mains, anodes shall be placed as shown in the Detail Drawing. The backfill immediately surrounding the anode must be saturated with a pail of water before finishing the backfill. Wires shall have slack and be hand backfilled.

25.03 Insulator Installation

A. Casing Insulator Installation. Casing insulators shall be installed between steel carrier pipes and steel casings. Insulators shall conform to Section 14.06.03. Insulators shall be spaced at intervals between 10 and 15 feet and not farther than 2 feet from the ends.

B. Pipe Support Insulator Installation.

Installation of Glas Mesh Type 180 or Type 240 Pipe Saddles
All defective coating, loose paint, rust, and corrosion products to be removed under the proposed pipe saddle or casing insulator. Surface to be free of moisture, grease and oil. The surface may be painted or taped to match the color of the pipe prior to the installation of pipe saddle. For the pipe saddles type 180 or 240 must be attached to the pipe with seam sealer and all exposed edges to be beveled. This is to prevent moisture entrance into the saddle.

Installation of the Glas Mesh Type 220/240 Casing Insulator
The type 240 (larger of the two) shall be installed on the bottom of the pipe and the type 220 on top and overlapping the type 240. Both of these insulators must be installed with seam seal, all voids must be filled so that moisture can not enter either insulator.

25.04 Test Stations

Test Stations shall be installed at locations indicated on the Plans, according to the Standard Detail Drawing. Box shall be plastic, as specified in Section 14.06.02.

For installations in areas subject to vehicular traffic, where it is impractical to locate the box outside the pavement, the plastic box shall be set in the top section of a CI valve box. When installation is intended to be on poles or other structures, such will be noted on the Plans.

Test Stations located at valves shall have the test box placed adjacent to the valve box.

Each test lead wire must be connected to the pipeline so as to remain mechanically secure and electrically conductive. Each test lead wire must be attached to the pipeline so as to minimize stress concentration on the pipe. Each bared test lead wire and bared metallic area at point of connection to the pipeline must be coated with an electrical insulating material compatible with the pipe coating and the insulation on the wire. (See Standard Drawing G-18)

Before any new test lead is connected to the transmission line, the pressure in the line must be reduced such that it is below 20% SMYS on the line.

25.05 Field Coating Application (Below Grade)

Each external protective coating, whether conductive or insulating, applied for the purpose of external corrosion control must:

A. Be applied on a properly prepared surface;

B. Have sufficient adhesion to the metal surface to effectively resist underfilm migration of moisture;

C. Be sufficiently ductile to resist cracking;

D. Have sufficient strength to resist damage due to handling and soil stress; and,

E. Have properties compatible with any supplemental cathodic protection.

Each external protective coating which is an electrically insulating type must also have low moisture absorption and high electrical resistance.

If coating pipe is installed by boring, driving, or other similar method, precautions must be taken to minimize damage to the coating during installation.

Coating materials specified in Section 14.06 shall be applied to all uncoated portions of pipe, fittings, valves, including bolts, couplings, damaged coatings, and other related steel components of the gas system. Casing pipes do not require coatings.

Field coating for underground pipeline shall be applied as follows:

TC Mastic or wax tape by Trenton, Denso, or approved equal shall be applied to mechanical bolt-type couplings, flanges and flanged fittings, no-blo tees, tapping saddles, and other irregular shaped fittings.

Scotchkote Liquid Epoxy 323, Liquid Epoxy 328, or Denso Protal 7125 may be applied to below grade steel pipe, valve, fittings, tees, etc. with surface preparation meeting SSPC-SP10 or NACE-2.

All valves shall be field coated regardless of existing factory applied coatings.

Cold tapes -- Weld joints, weld fittings, and coating repair

Optional hot-type applications shall be as follows:

Shrink Sleeves - weld joints and boltless compression couplings

Tapecoat 20 - weld joints, weld fittings, and coating repair

Directional bore pipe shrink sleeves, Dirax by Raychem

Coating shall be applied to dry, clean and primed surfaces.

Primer must be the companion to the manufacturer's coating.

Bitumastic type coatings shall not be backfilled for 16 hours after application to allow for cure time.

Tape shall be installed in accordance with the manufacturer’s recommendations and shall overlap 1/2 inch for spiral method of wrapping and 1 inch for the cigarette method.

Holidays over two square inches shall be repaired by wrapping tape completely around the pipe.

Holidays less than two square inches in the epoxy pipe coating may be repaired using hot melt patch sticks, Scotchkote 226P or equivalent. Hot melt patch sticks shall be applied as follows:

1. Roughen the surface of the parent fusion bonded epoxy (FBE) coating using 80-mesh to 120-mesh sandpaper. Clean the surface and wipe away the sanding residue with a non-contaminating cloth.

2. Preheat the parent-coating surface using a non-contaminating heat source, such as portable hand-held butane torch. Heat should be applied in a manner that avoids burning or charring of the epoxy coating. Slight browning of the parent coating is acceptable, but charring or blistering is not. Avoid heat application directly to the patch stick while pre-warming the coating surface.

3. While continuing to heat the FBE surface, occasionally draw the patch stick across the repair area until it leaves a residue. Then rub the stick in a circular motion and utilize the torch to help melt it and maintain the pipe coating temperature. Continue until the patch is smooth and has a thickness of at least 15 mils (380 microns) greater than the parent coating.

4. Allow the patch to cool before handling.

25.06 Field Coating Applications (Above Grade)

General Applications	System			
	Top Coat	Primer	Prep.	Applic.
A. New Meter Connections, New outdoor fuel pipe	None Required	Rust-oleum #678 or 769 14.06.05A	SSPC-SP1 & SSPC-SP2	Brush
B. Regulator Stations	Pitthane two-part Urethane Gray	Dupont Vari Prime-Green (acid base)	SSPC-SP1 & SSPC-SP2	Brush or Spray
C. Meter Set Piping Recoating Program	Polymide Epoxy 14.06.05B 5-8 Mills	None Required	SSPC-SP2	Brush
D. New Uncoated gas mains, fittings, on creek crossings, bridges, etc.	Acrylic-Urethane Enamel 14.06.05C	Inorganic zinc-rich primer 3 Mills	SSPC-SP10 Or NACE #2	Spray or Brush
E. Previously painted mains, fittings on creek crossings, bridges, etc.	Acrylic-Urethane Enamel 14.06.05C	Organic zinc-rich primer 3 Mills	SSPC-SP6 Or NACE #3	Spray or Brush
F. Previous coal tar, 3M or X-TRU, coated mains on creek crossings, bridges, soil to air interfaces, etc.	Tapecoat, wax tape, & Aluminized Mastic 14.06.05D	TC Omni Prime, Wax Tape None Required for Mastic	SSPC-PC7 Or NACE #4	Machine or hand, mastic is brushed

25.07 Surface Preparation

Painting or coating systems will require one of the following surface preparations. Specs referred to are Steel Structures Painting Manual.

SSPC-SP1 - Solvent cleaning. Oil to be removed with solvent and brush or wipe cloth.

SSPC-SP2 - Hand tool cleaning with wire brush as necessary to remove loose paint, loose rust, dirt, and pipe tape.

SSPC-SP5 or NACE-1 - White Metal Blast Cleaning
Completely remove all mill scale, rust, rust scale, previous coating, etc., leaving the surface a uniform gray-white color.

SSPC-SP10 or NACE-2 - Near White Blast Cleaning
Remove all blast scale, mill scale, previous coating, etc., leaving only light stains from rust, mill scale, and small specks of previous coating. At least 95% of each square inch of surface area is to be free of all visible residues, and the remainder shall be limited to slight coloration.

SSPC-SP6 or NACE-3 - Commercial Grade Blast Cleaning
Completely remove all dirt, rust scale, foreign matter, and previous coating, etc., leaving only shadows and/or streaks caused by rust stain and mill scale oxides. At least 66% of each square inch of surface area is to be free of all visible residues, except slight discoloration.

SSPC-SP7 or NACE-4 - Brush-Off Blast Cleaning
Remove rust scale, loose mill scale, loose rust, and loose coatings, leaving tightly bonded mill scale, rust, and previous coatings. This is an ideal method for removing oxides and/or loose and peeling coatings from galvanized metal. Results are comparable to those achieved through chipping, scraping, and wire brushing. In all cases of surface preparation, the surface must be primed within 6-8 hours of abrasive blasting.

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26.01 Method of Measurement

All items will be measured separately according to design designation as indicated in the Pay Item name and as may be detailed and defined in the Plans or Special Provisions. Pipe will generally be designated by size and kind or type. Complete-in-Place items shall include all component parts thereof as described or required to complete the unit, but excluding any excesses covered by separate Pay Item.

26.01.01 Gas Pipe.
Gas main pipe of each kind and size will be measured separately by the overall length along the center of the pipeline from the beginning of each installation and without regard to intervening valves, casings, couplings, transitions of other material or sizes, or minor line deviations caused by slack in laying coiled pipe. Terminal points of measure will be to the physical ends of the pipeline, to the centerline of in-place connecting pipelines. Bend and ties shall be included and measured from intersecting centerlines. Reducers, where transition is not abrupt, shall be measured as the larger size pipe.

Gas service pipe will be measured as the ground distance from the center of tapping tee, (or gas main for large services) to the point where the riser comes out of the ground.

All costs of installing gas main placed by horizontal directional drilling between the locations shown on the plans or as directed by the Engineer; including gas main pipe, appurtenances, locating wire, and testing; shall be paid for at the contract unit price per linear foot for Install (diameter, PE or steel) Gas Main by Horizontal Directional Drill. If the Contractor chooses at his option to horizontally directional drill gas main not shown on the plans or designated by the Engineer for horizontally directional drilling, payment shall be made at the contract unit price per linear foot for Install (diameter, PE or steel) Gas Main.

26.01.02 Service Meter Connections.

Measurement shall be made on the basis of one (1) connection per meter, except when connection is to multiple meters which are not replaced or relocated, in which case measurement will be one connection regardless of the number of meters. Multiple meters, which are replaced or relocated, will be measured as one (1) connection per meter.

Multiple meters all less than 400, if replaced or relocated, and requiring a B-31 regulator or larger, shall be paid for as one connection, greater than or equal to 400 for the first meter and less than 400 for the rest.

Removed meters which are piped through or capped off shall be paid for at one-half (1/2) the respective meter connection bid price.

Meter Connections will be paid for by size accordance to the meter rated capacity as follows:

Meter Connections (less than 400 CFH)
Meter Connections (400 CFH and larger)

26.01.03 Excavation for Cutoffs, Regulator Station, Relief & Miscellaneous.

Excavations designated on the Plans and as a unit item in the proposal on a per each basis will be measured separately for each such excavation completed, including backfill and required surface restoration. This item shall be measured for payment only to the extent that the excavation does not lie in a location already requiring excavation for construction of other items for which excavation is included.

26.02 Basis of Payment

Payments for gas mains and related facilities will only be made under the items in the proposal. Cost of other work necessary to complete in place the improvements required on the Plans and in the Contract Documents will be considered incidental and the costs included in the unit items unless it qualifies as extra work and is properly authorized.

Payment for gas main and gas services shall be compensated in full for all costs of furnishing and installing the pipe complete in place as specified, with the exception of rock excavation, granular borrow material not specified as a Laying Condition, and casing pipes where separate payment is established, but including all costs of pipeline installation not exempt by a pay item or authorized extra. Incidental pipeline cost shall include, but not be limited to, furnishing and installing all required materials for the pipeline (unless specified to be furnished or installed by the Department) including valves, couplings, insulators, locating wires, continuity wires, test stations, anodes, field coatings, joining, fittings, testing, excavation, backfill, surface restoration as may be required. Cost of services shall include the connection to main, riser, meter stop, plug, beside the same applicable incidentals required for gas main.

Payment for service meter connections shall be on a unit price basis and shall include full compensation for all materials, labor, equipment necessary to install the regulator, meter, inside stop valve and interconnecting plumbing from the meter stop valve to the inside stop valve or existing plumbing where such plumbing exists. Meters requiring removal only will be paid for at one-half the bid price for meter connections.

Payment for excavations for cutoffs, regulator stations, system reliefs or miscellaneous shall include all labor and materials not specifically furnished or installed by the Department.

Payment for items which are eligible for compensation will generally be made on the basis of the following schedule. Consult the proposal for actual payment items for this project.

Item Name	Unit
Gas Main (Size and Type)	Linear Foot
Gas Service (Size and Type)	Linear Foot
Service Meter Connection (Size)	Each
Excavation for (Cutoffs, Regulator Station, Reliefs, Miscellaneous)	Each
Valve Boxes	Each
Reconnect Services	Each

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27.01 General

Welding of joints and connections for gas pipelines shall only be done by welders qualified in accordance with the requirements of this section.

Upon request by the inspector or at any time before beginning production welding, a contractor must submit documentation of welder's qualifications in accordance with API 1104 Nineteenth Edition, on a form similar to the API Welder Qualification Coupon Test Report as shown in Figure 27-1. Documentation may be submitted to Duluth Public Works and Utilities Department, Engineering Division, 411 West 1st Street, Duluth, MN, 55802.

Department welders must be qualified in the same manner as contract welders.

27.02 Qualification Procedure

A. The Department has established general specifications for single V butt welds (DPWU-1 and DPWU-6), single bevel branch connections (DPWU-2), and fillet welds (DPWU-3). These general specifications are implemented through specific Welding Procedure Specifications (WPSs) which meet the Essential Variable requirements of API 1104 Nineteenth Edition. Welder Qualification Tests must be set up and performed within the parameters of the specified WPSs which are provided in Welding Procedure Manual.

B. A welder must be qualified by an independent testing company, the name of which is to be indicated on the qualification document.

C. Qualification document must be the same or similar to the form shown in Figure 27-1, the API Welder Qualification Coupon Test Report.

D. Testing company shall evaluate test welds in accordance with API 1104 Nineteenth Edition, Section 6 or Section 9 (based upon if the test is for initial qualification [Section 6] or requalification [Section 9]) for butt welds, branch connections, or fillet welds as required by the specific project they are working on. Department welders will perform the Multiple Qualification test as outlined in API 1104 Nineteenth Edition Section 6.3. If contract welders need to qualify on fillet welds, they must be qualified in the same manner (API 1104 Section 6.3).

27.03 General Welding Specifications

27.03.01 Shielded Metal Arc Welding (SMAW) Butt Welding General Specification

A. Reference

API 1104, Nineteenth Edition

City of Duluth Procedure DPWU-1, DPWU-18, DPWU-19

B. Process

Welding shall utilize the Shielded Metal Arc Welding (SMAW) process.

C. Base Metals

Pipe welded according to this standard shall include ASTM A53, API 5L Grade B, and API 5L X42 through X-60. Pipe 2 NPS and smaller shall be limited to ASTM A53, API 5L Grade B or equivalent.

D. Diameter and Wall Thickness

This standard shall apply to pipe having a diameter equal to and larger than 2 NPS through 16 NPS. The wall thickness shall be equal to and larger than 0.154 inch up to and including 0.750 inch.

E. Joint Design

The joint ends shall be beveled to an angle of 30°, +5°, -0°, with a root face of 1\16", ± 1\32". Bevels shall form a “V“ groove with an included angle of 60°. The root opening shall be 1\16", ± 1\32". This applies to both circumferential butt joints and sleeve side seam joints. For sleeves, the end preparation shall be with as little space between the sleeve and pipe as possible.

F. Filler Metal

The filler material shall conform to AWS A5.1, E6010, Group F-3 (ASME) Weld Analysis A-1 for the first pass (root) and AWS A5.5, E8010-G, Group F-3 (ASME) Weld Analysis A-1 for subsequent passes (hot pass, filler and cap).

G. Size of Electrodes and Number of Beads

Wall Thickness (inches)	Stringer Bead E6010	Hot Pass E8010-G	Fill and Cap E8010-G
< 0.188	3/32"	3/32"	1/8"
0.188 - 0.750	1/8" - 5/32”	1/8" - 3/16"	1/8" - 3/16"

The minimum number of passes is dependent on wall thickness but shall not be less than 3 passes with no pass deposited thicker than 1/8".

H. Electrical Characteristics

The welding current shall be D.C. current, Reverse Polarity (electrode positive).

Electrode	Rod Diameter	Amperage	Voltage
E6010	3/32"	60 - 100	20 - 26
E6010	1/8"	75 - 130	20 - 27
E6010	5/32"	90 - 170	20 - 27
E8010-G	3/32”	60 - 100	20 - 26
E8010-G	1/8"	75 - 130	20 - 27
E8010-G	5/32"	90 - 170	24 - 27
E8010-G	3/16"	140 - 190	24 - 27

I. Direction of Welding

Welding shall progress downward from top or any point on the side of the pipe to bottom center.

J. Speed of Travel

The speed of travel should be within the range of 3 - 14 inches per minute.

K. Number of Welders

When the nominal pipe diameter is less than 16", one welder may be used to run the stringer bead (root bead). When the nominal pipe diameter is 16" or greater, two welders will be required to run the stringer bead and hot pass.

L. Time Lapse Between Passes

The second pass (hot pass) shall follow the stringer bead (root bead) within five minutes. Subsequent passes shall be initiated within five minutes of the completion of the previous pass. A minimum of 3 passes shall be completed before the end of the day. Any weld that is not finished the day it is started shall be finished the next workday.

M. Type of Line-up Clamp

Fabrication, Maintenance, and Tie-in welding: External line-up clamps should be used on all sizes of welds. Sleeves, chains, clamps, hydraulic jacks or other similar

mechanical holding devices shall be used to hold the sleeve in intimate contact with the pipe before welding starts.

N. Removal of Line-up Clamp

On 16" or larger diameter pipe, the line-up clamp shall remain in place until 100% of stringer bead (root bead) is completed. The department may reduce said percentage if, in its sole judgment, acceptable welds can be produced at that reduced percentage. However, the department retains the right to require the contractor to return to 100% if the welding quality is not acceptable. When the pipe diameter is less than 16", the line-up clamp may be removed upon completion of tack welds (minimum 50% of total joint) adequate to prevent the loss of joint spacing, the development of high-low, or the formation of cracks in the tack welds or stringer bead. Under no circumstances shall the line-up clamp be removed while welding is in progress or when the metal temperature is above 400°.

O. Cleaning

All rust, dirt, and foreign matter shall be removed from the bevel surface before welding is started. The bevel surface includes all areas in immediate proximity to the pipe end on both the I.D. and O.D. Slag shall be removed from the surface before the next bead is applied. Power tools may be used. The finished weld and immediately adjacent pipe must be cleaned of all flux, smoke debris and weld spatter. All welds will be visually inspected to ensure compliance with the qualified welding procedure.

P. Preheat

Preheat shall be required when the ambient or metal surface temperature is below 40° for all pipe grades. The minimum preheat temperature is 200° to be applied to an area no less than 3" either side of the joint. If moisture is present on the parent metal, it shall be driven off by preheating to temperature at which it will not reform during the welding operation.

27.03.02 Gas Metal Arc Welding and Flux Cored Arc Welding (GMAW / FCAW) Butt Welding General Specification

A. Reference

API 1104, Nineteenth Edition

City of Duluth Procedure DPWU-6, DPWU-14, DPWU-15

B. Process

Welding shall utilize the Gas Metal Arc Welding and Flux Cored Arc Welding (GMAW & FCAW) processes.

C. Base Metals

Pipe welded according to this standard shall include ASTM A53, API 5L Grade B, and API 5L X42 through X60.

D. Diameter and Wall Thickness

This standard shall apply to pipe having a diameter equal to and larger than 2-1/2 NPS through 16 NPS. The wall thickness shall be equal to and larger than 0.188 inch up to and including 0.750 inch.

E. Joint Design

The joint ends shall be beveled to an angle of 30°, +5°, -0°, with a root face of 1\16", ± 1\32". Bevels shall form a “V“ groove with an included angle of 60°. The root opening shall be 1\16", ± 1\32".

F. Filler Metal

The filler metal shall conform to AWS A5.18, ER70S-6, Group F-6 (ASME) Weld Analysis A-1 for the first pass (root) and AWS A5.29, E81T1-Ni1M, Group F-6 (ASME) Weld Analysis A-1 for subsequent passes (hot pass, fill and cap).

G. Size of Electrodes and Number of Beads

Wall Thickness (inches)	Stringer Bead ER70S-6	Hot Pass E81T1-Ni1M	Fill and Cap E81T1-Ni1M
0.188-0.750	0.035"	0.045"	0.045"

The minimum number of passes is dependent on wall thickness but shall not be less than 3 passes with no pass deposited thicker than 1/8".

H. Electrical Characteristics

The welding current shall be D.C. current, Reverse Polarity (electrode positive).

Electrode	Rod Diameter	Amperage	Voltage
ER70S-6	0.035"	110 - 150	18 - 24
E81T1-Ni1M	0.045"	190 - 220	20 - 29

I. Direction of Welding

Welding shall be horizontal, rolled (down-hand with the pipe rolled).

J. Speed of Travel

The speed of travel should be within the range of 10 - 15 inches per minute for GMAW and 10 - 19 inches per minute for FCAW.

K. Number of Welders

When the nominal pipe diameter is less than 16", one welder may be used to run the stringer bead (root bead). When the nominal pipe diameter is 16" or greater, two welders will be required to run the stringer bead and hot pass.

L. Time Lapse Between Passes

The second pass (hot pass) shall follow the stringer bead (root bead) within five minutes. Subsequent passes shall be initiated within five minutes of the completion of the previous pass. A minimum of 3 passes shall be completed before the end of the day. Any weld that is not finished the day it is started shall be finished the next workday.

M. Type of Line-up Clamp

Fabrication, Maintenance, and Tie-in welding: External line-up clamps should be used on all sizes of welds.

N. Removal of Line-up Clamp

On 16" or larger pipe, the line-up clamp shall remain in place until 100% of the stringer bead (root bead) is completed. The department may reduce said percentage if, in its sole judgment, acceptable welds can be produced at that reduced percentage. However, the department retains the right to require the contractor to return to 100% if the welding quality is not acceptable. When the pipe diameter is less than 16", the line-up clamp may be removed upon completion of tack welds (minimum of 50% of total joint) adequate to prevent the loss of joint spacing, the development of high-low, or the formation of cracks in the tack welds or stringer bead. Under no circumstances shall the line-up clamp be removed while welding is in progress or when the metal temperature is above 400°.

O. Cleaning

All rust, dirt, and foreign matter shall be removed from the bevel surface before welding

is started. The bevel surface includes all areas in immediate proximity to the pipe end on both the I.D. and O.D. Slag shall be removed from the surface before the next bead is applied. Power tools may be used. The finished weld and immediately adjacent pipe must be cleaned of all flux, smoke debris and weld spatter. All welds will be visually inspected to ensure compliance with the qualified welding procedure.

P. Preheat

Preheat shall be required when the ambient or metal surface temperature is below 40° for all pipe grades. The minimum preheat temperature is 200° to be applied to an area no less than 3" either side of the joint. If moisture is present on the parent metal, it shall be driven off by preheating to a temperature at which it will not reform during the welding operation.

27.03.03 Shielded Metal Arc Welding (SMAW) Single Bevel Branch Connection General Specification

A. Reference

API 1104, Nineteenth Edition

City of Duluth Procedure DPWU-2, DPWU-16, DPWU-17

B. Process

Welding shall utilize the Shielded Metal Arc Welding (SMAW) process.

C. Base Metals

Pipe welded according to this standard shall include ASTM A53, API 5L Grade B, and API 5L X42 through X60. Pipe 2 NPS and smaller shall be limited to ASTM A53, API 5L Grade B or equivalent.

D. Diameter and Wall Thickness

This standard shall apply to pipe having a diameter on the branch equal to or greater than 1/2 inch up to 12.75 inches. The main may be 2-inch NPS through 16-inch NPS. The wall thickness shall be equal to and larger than 0.154 inch up to and including 0.750 inch.

E. Joint Design

Branch ends shall be beveled to an angle of 45°, +5°, -0°, with a root face of 1\16", ± 1\32". The root opening shall be 1\16", ± 1\32".

F. Filler Metal

The filler metal shall conform to AWS A5.1, E6010, Group F-3 (ASME) Weld Analysis A-1 for the first pass (root) and AWS A5.5, E8010-G, Group F-3 (ASME) Weld Analysis A-1 for subsequent passes (hot pass, fill and cap).

G. Size of Electrodes and Number of Beads

Wall Thickness (inches)	Stringer Bead E6010	Hot Pass E8010-G	Fill and Cap E8010-G
< 0.188	3/32"	3/32"	1/8"
0.188 - 0.750	1/8" - 5/32”	1/8" - 3/16"	1/8" - 3/16"

The minimum number of passes is dependent on wall thickness but shall not be less than 3 passes with no pass deposited thicker than 1/8". If welding on pressurized pipelines, the maximum electrode size shall be 1/8”.

H. Electrical Characteristics

The welding current shall be D.C. current, Reverse Polarity (electrode positive).

Electrode	Rod Diameter	Amperage	Voltage
E6010	3/32"	60 - 100	20 - 26
E6010	1/8"	75 - 130	20 - 27
E6010	5/32"	90 - 170	20 - 27
E8010-G	3/32”	60 - 100	20 - 26
E8010-G	1/8"	75 - 130	20 - 27
E8010-G	5/32"	90 - 170	24 - 27
E8010-G	3/16"	140 - 190	24 - 27

I. Direction of Welding

Welding shall progress downward from top or any point on the side of the pipe to bottom center.

J. Speed of Travel

The speed of travel should be within the range of 3 - 14 inches per minute.

K. Number of Welders

When the nominal pipe diameter is less than 16", one welder may be used to run the stringer bead (root bead). When the nominal pipe diameter is 16" or greater, two welders will be required to run the stringer bead and hot pass.

L. Time Lapse Between Passes

The second pass (hot pass) shall follow the stringer bead (root bead) within five minutes. Subsequent passes shall be initiated within five minutes of the completion of the previous pass. A minimum of 3 passes shall be completed before the end of the day. Any weld that is not finished the day it is started shall be finished the next workday.

M. Type of Line-up Clamp

Spacing tools and manual holding during tacking off is acceptable if correct stringer bead space and proper alignment is maintained. If this is not possible, then mechanical holding devices shall be required.

N. Removal of Line-up Clamp

On 16" or larger pipe, the line-up clamp shall remain in place until 100% of the stringer bead (root bead) is completed. The department may reduce said percentage if, in its sole judgment, acceptable welds can be produced at that reduced percentage. However, the department retains the right to require the contractor to return to 100% if the welding quality is not acceptable. When the pipe diameter is less than 16", the line-up clamp may be removed upon completion of tack welds (minimum of 50% of total joint) adequate to prevent the loss of joint spacing, the development of high-low, or the formation of cracks in the tack welds or stringer bead. Under no circumstances shall the line-up clamp be removed while welding is in progress or when the metal temperature is above 400°.

O. Cleaning

All rust, dirt, and foreign matter shall be removed from the bevel surface before welding is started. The bevel surface includes all areas in immediate proximity to the pipe end on both the I.D. and O.D. Slag shall be removed from the surface before the next bead is applied. Power tools may be used. The finished weld and immediately adjacent pipe must be cleaned of all flux, smoke debris and weld spatter. All welds will be visually inspected to ensure compliance with the qualified welding procedure.

P. Preheat

Preheat shall be required when the ambient or metal surface temperature is below 40° for all pipe grades. The minimum preheat temperature is 200° to be applied to an area no less than 3" either side of the joint. If moisture is present on the parent metal, it shall be driven off by preheating to a temperature at which it will not reform during the welding operation.

27.03.04 Shielded Metal Arc Welding (SMAW) Fillet Weld General Specification

A. Reference

API 1104, Nineteenth Edition

City of Duluth Procedure DPWU-3, DPWU-11

B. Process

Welding shall utilize the Shielded Metal Arc Welding (SMAW) process.

C. Base Metals

Pipe welded according to this standard shall include ASTM A53, API 5L Grade B, and API 5L X42 through X60. Pipe 2 NPS and smaller shall be limited to ASTM A53, API 5L Grade B or equivalent.

D. Diameter and Wall Thickness

This standard shall apply to pipe having a diameter equal to and larger than 2 NPS through 16 NPS. The wall thickness shall be equal to and larger than 0.154 inch up to and including 0.750 inch.

E. Joint Design

The joint shall nominally be a 90° angle between the adjacent faces of the base metals. The maximum root opening shall not exceed 1\16". The face of the fillet weld shall be flat to slightly convex. The toes of the fillet weld shall fair smoothly into the adjacent base metal.

F. Filler Metal

The filler metal shall conform to AWS A5.1, E6010, Group F-3 (ASME) Weld Analysis A-1 for the first pass (root) and AWS A5.5, E8010-G, Group F-3 (ASME) Weld Analysis A-1 for subsequent passes (hot pass, fill and cap).

G. Size of Electrodes and Number of Beads

Wall Thickness (inches)	Stringer Bead E6010	Hot Pass E8010-G	Fill and Cap E8010-G
< 0.188	3/32"	3/32"	1/8"
0.188 - 0.750	1/8" - 5/32”	1/8" - 3/16"	1/8" - 3/16"

The minimum number of passes is dependent on fillet weld size but shall not be less than 3 passes with no pass deposited thicker than 1/8".

H. Electrical Characteristics

The welding current shall be D.C. current, Reverse Polarity (electrode positive).

Electrode	Rod Diameter	Amperage	Voltage
E6010	3/32"	60 - 100	20 - 26
E6010	1/8"	75 - 130	20 - 27
E6010	5/32"	90 - 170	20 - 27
E8010-G	3/32”	60 - 100	20 - 26
E8010-G	1/8"	75 - 130	20 - 27
E8010-G	5/32"	90 - 170	24 - 27
E8010-G	3/16"	140 - 190	24 - 27

I. Direction of Welding

Welding shall progress downward from top or any point on the side of the pipe to bottom center.

J. Speed of Travel

The speed of travel should be within the range of 3 - 14 inches per minute.

K. Number of Welders

When the nominal pipe diameter is less than 16", one welder may be used to run the stringer bead (root bead). When the nominal pipe diameter is 16" or greater, two welders will be required to run the stringer bead and hot pass.

L. Time Lapse Between Passes

The second pass (hot pass) shall follow the stringer bead (root bead) within five minutes. Subsequent passes shall be initiated within five minutes of the completion of the previous pass. A minimum of 3 passes shall be completed before the end of the day. Any weld that is not finished the day it is started shall be finished the next workday.

M. Type of Line-up Clamp

Fabrication, Maintenance, and Tie-in Welding: External line-up clamps should be used on all sizes of welds.

N. Removal of Line-up Clamp

On 16" or larger pipe, the line-up clamp shall remain in place until 100% of the stringer bead (root bead) is completed. The department may reduce said percentage if, in its sole judgment, acceptable welds can be produced at that reduced percentage. However, the department retains the right to require the contractor to return to 100% if the welding quality is not acceptable. When the pipe diameter is less than 16", the line-up clamp may be removed upon completion of tack welds (minimum of 50% of total joint) adequate to prevent the loss of joint spacing or the formation of cracks in the tack welds or stringer bead. Under no circumstances shall the line-up clamp be removed while welding is in progress or when the metal temperature is above 400°.

O. Cleaning

All rust, dirt, and foreign matter shall be removed from the fillet weld surface before welding is started. The fillet weld surface includes all areas in immediate proximity to the fillet weld joint. Slag shall be removed from the surface before the next bead is applied. Power tools may be used. The finished weld and immediately adjacent pipe must be cleaned of all flux, smoke debris and weld spatter. All welds will be visually inspected to ensure compliance with the qualified welding procedure.

P. Preheat

Preheat shall be required when the ambient or metal surface temperature is below 40° for all pipe grades. The minimum preheat temperature is 200° to be applied to an area no less than 3" either side of the joint. If moisture is present on the parent metal, it shall be driven off by preheating to a temperature at which it will not reform during the welding operation.

27.04 Maintaining Welding Qualification

A welder can maintain qualification for butt welds if during the previous 6 months at

least one weld has been tested and found acceptable under API Standard 1104, Nineteenth Edition, Section 6 or Section 9.

A welder can maintain qualification for fillet welds if during the previous 6 months at least one weld has been tested and found acceptable under API Standard 1104, Nineteenth Edition, Section 6 or Section 9.

27.05 Records

The Engineering Division will keep qualification documents for Department Welders and a copy of requalification records.

Qualification documents submitted for contract welders will be filed in job file for that particular contract and kept for the life of the pipeline.

27.06 Nondestructive Testing

27.06.01 City of Duluth Inspection and Testing of Welds Requirements

A. Visual inspection of welding must be conducted by an individual qualified by appropriate training and experience to ensure that:

    1. The welding is performed in accordance with the welding procedure; and

    2. The weld is acceptable under Paragraph (C) of this section.

B. The welds on a pipeline to be operated at a pressure that produces a hoop stress of 20% or more of SMYS must be nondestructively tested in accordance with sections 27.06.02, 27.06.03, and 27.06.04, except that welds that are visually inspected and approved by a qualified welding inspector need not be nondestructively tested if:

    1. The pipe has a nominal diameter of less than 6 inches; or

    2. The pipeline is to be operated at a pressure that produces a hoop stress of less than 40% SMYS and the welds are so limited in number that nondestructive testing is impractical.

C. The acceptability of a weld that is nondestructively tested or visually inspected is determined according to the standards in Section 9 of API 1104 Nineteenth Edition. However, if a girth weld is unacceptable under those standards for a reason other than a crack, and if Appendix A to API 1104 applies to the weld, the acceptability of the weld may be further determined under that appendix.

27.06.02 City of Duluth Selection of Welds for Nondestructive Testing

A. When nondestructive testing is required under 27.06.01(B), the following percentages of each day's field butt welds, selected at random by the City of Duluth, must be nondestructively tested over their entire circumference.

    1. In Class 1 locations, at least 10%

    2. In Class 2 locations, at least 15%

    3. In Class 3 and Class 4 locations, at crossings of major or navigable rivers, offshore, and within railroad or public highway rights-of-way, including tunnels, bridges, and overhead road crossings, 100% unless impracticable, in which case at least 90%. Nondestructive testing must be impracticable for each girth weld not tested.

    4. At pipeline tie-ins, including tie-ins of replacement sections, 100%

B. Except for a welder whose work is isolated from the principal welding activity, a sample of each welder's work for each day must be nondestructively tested when nondestructive testing is required under 27.06.01(B).

C. When nondestructive testing is required under 27.06.01(B), the City of Duluth must retain, for the life of the pipeline, a record showing by milepost, engineering station, or by geographic feature, the number of girth welds made, the number nondestructively tested, the number rejected, and the disposition of the rejects.

27.06.03 Vendor NDT Method Requirements

Nondestructive testing of welds must be performed by any process, other than trepanning, that will clearly indicate defects that may affect the integrity of the weld. These methods include Magnetic Particle, Liquid Penetrant, Radiographic and Ultrasonic methods.

27.06.04 Vendor Documentation Requirements

A. The vendor shall submit written procedures for each NDT method that is proposed for use in the inspection of pipeline girth welds or other welds.

B. The written procedures shall include methods for establishing the proper interpretation of each nondestructive test of a weld to ensure the acceptability of the weld under section 27.06.01(C).

C. The vendor shall submit the NDT Certification/Qualification records of the individuals who will perform and/or interpret the nondestructive tests.

Figure 27-1 Coupon Test Report

COUPON TEST REPORT

Date _____ Test No. _____
Location _____
State _____ Weld Position: Roll ❑ Fixed ❑
Welder _____ Mark _____
Welding time _____ Time of day _____
Mean temperature _____ Wind break used _____
Weather conditions _____
Voltage _____ Amperage _____
Welding machine type _____ Welding machine size _____
Filler metal _____
Reinforcement size _____
Pipe type and grade _____
Wall thickness _____ Outside diameter _____

	1	2	3	4	5	6	7
Coupon stenciled							
Original specimen dimensions							
Original specimen area							
Maximum load							
Tensile strength							
Fracture location							

❑ Procedure ❑ Qualifying test ❑ Qualified
❑ Welder ❑ Line test ❑ Disqualified

Maximum tensile _____ Minimum tensile _____ Average tensile _____
Remarks on tensile-strength tests _____
1. _____
2. _____
3. _____
4. _____
Remarks on bend tests _____
1. _____
2. _____
3. _____
4. _____
Remarks on nick-break tests _____
1. _____
2. _____
3. _____
4. _____

Test made at _____ Date _____
Tested by _____ Supervised by _____

Note: Use back for additional remarks. This form can be used to report either a procedure qualification test or a welder qualification test.

Welding Procedure Matrix

Procedure Number	Process	Wall Thickness
DPWU-1	SMAW	0.188” ≤ t ≤ 0.750”
DPWU-2	SMAW	t < 0.188”
DPWU-3	SMAW	0.188” ≤ t ≤ 0.750”
DPWU-4	SMAW	0.188” ≤ t ≤ 0.750”
DPWU-6	GMAW/FCAW	t < 0.188”
DPWU-7	GMAW/FCAW	t < 0.188”
DPWU-10	SMAW	0.188” ≤ t ≤ 0.750”
DPWU-11	SMAW	0.188” ≤ t ≤ 0.750”
DPWU-14	GMAW/FCAW	t < 0.188”
DPWU-15	GMAW/FCAW	0.188” ≤ t ≤ 0.750”
DPWU-16	SMAW	t < 0.188”
DPWU-17	SMAW	0.188” ≤ t ≤ 0.750”
DPWU-18	SMAW	t < 0.188”
DPWU-19	SMAW	0.188” ≤ t ≤ 0.750”

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28.01 Qualification Tests

A. Qualification tests are used to determine the ability of those tested to produce sound joints with the equipment, materials, and procedures that are used in the field. It should be realized that the test is conducted under controlled conditions.

   Successful passage of the test does not guarantee that a person will make sound joints under all field conditions.

B. The qualification test shall be successfully completed by each joiner employed by the Department or by an employee of a contractor before being permitted to make joints on the Department's gas plastic P.E. system.

C. Joiners may be qualified in one or more of the following categories:

Fusion	Socket
	Saddle
	Butt
	Electrofusion
Mechanical (Dept. only)	Lyco-Fit
	Chicago Fitting
	Continental Con-stab

28.02 Identification Cards

Qualified contractor fusors must carry on their person a Department-issued certification card which will be issued by the Department upon passage of the qualification test. This card must be presented on request. The card will indicate if fusor is qualified for socket, saddle, butt fusion or electrofusion. The inspector shall verify by office records that the fusor's qualifications are current. In addition each fusor will have available the standard specification for fusion.

28.03 Qualification Records

The Chief Engineer or his/her designee shall maintain a record of each test and shall maintain a list of currently qualified persons in each category. Persons who do not requalify during the required interval shall be deleted from the current list. The list shall contain both Department and Contractor joiners.

Old lists and test records shall be kept for seven years.

28.04 Qualification of Inspectors (192.287)

Each person responsible for inspecting fusion joining must be qualified by training or experience in evaluating whether joints made according to the procedure in this manual are acceptable.

Each inspector will be qualified, in addition to experience or other training, by passage of Part I of the qualification test which is the written portion. Part II is the Joint Fabrication portion of the test. Persons who qualify on both Part I and Part II are also considered qualified to inspect provided that their certificate has not expired.

28.05 Fusion Qualification Procedure

28.05.01 General

Qualification testing is conducted in two parts. Part I must be passed before proceeding to Part II.

28.05.02 Part I – Written Test

This test may or may not be preceded by classroom training. The test shall consist of questions pertinent and critical to making satisfactory joints. Questions may be derived from information provided in Section 16.07 of the Standard Specifications titled “Joining Pipe and Fittings”. Reference material will not be permitted to be used during test and measures will be taken by the test monitor to assure same.

An overall score of 75% is required to pass the written test.

28.05.03 Part II – Joint Fabrication Test

Fabrication of various fusion joints will be done by the applicant, in the presence of a Department-qualified fuser at the Department Utility Operations Division, 520 Garfield Avenue.

Plastic pipe and fittings for socket, saddle and butt will be furnished by Department.

Tools and irons for socket, saddle and butt fusion joining must be provided by the applicant.

Tools, equipment, piping, and fittings for electrofusion must be provided by the applicant.

A fee shall be charged to recover costs of the testing.

Applicant may not refer to manual or written notes during Joint Fabrication Test.

Completed Assembly must be as it appears in the detail shown in Figure 28-1.

28.06 Heat Fusion Qualification Requirements

A. The fabricated assembly completed by the applicant shall be subjected to visual inspection for comparison with standard pipe manufacturer photos for acceptable and not acceptable joints.

B. The following defects will result in a failed test:

1. Failure to follow procedures
2. Visual defect
3. Failure during destructive test

C. Tests

1. Socket (2" and 1/2") Visual and Destructive

   The applicant must complete a socket type joint for testing by the Department. The test will include cutting three strips, 1" wide and 6" along the pipe through the joint. The test will include bending the strips 180º over and checking for disbondment.

2. Service Punch Tee (2" x 1/2") Visual and Destructive

   The applicant must complete a service punch tee type joint, including tapping the service tee prior to testing by the Department. The test will include slipping a 1-1/2" steel pipe over the top of the service punch tee (cap must be removed) and bending the tee to 45º in all directions to attempt to disbond service tee from main.

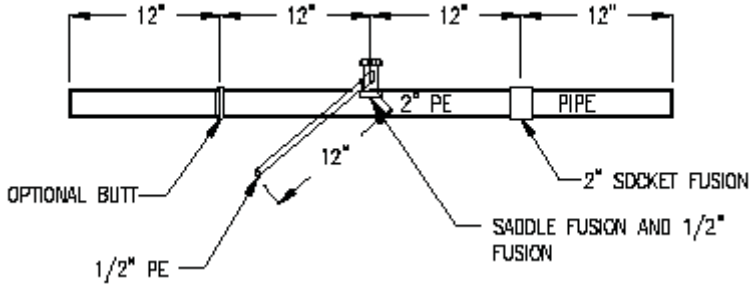
   The punch tee will also be sawed in half at 90º to the main line to check for overmelt at the 1/2" pipe connection to the service punch tee which may cause orificing at the connection.

3. Butt (2") Visual and Destructive

   The applicant must complete a butt type joint for testing by the Department. The test will include cutting three strips, 1" wide and 6" along the pipe through the joint. The test will include bending the strips 180º over and checking for disbondment.

   The butt joint test, if done alone, may be done on 2", 3", 4”, 6"or 8" pipe.

Figure 28-1
Fabricated Assembly for P.E. Fusion Qualification Test Part III



28.07 Electrofusion Qualification Requirements (192.285)

Applicants qualifying for electrofusion shall be certified according to Section 28.05. In addition, the applicant shall make an electrofuse coupling joint and/or a sidewall/saddle including tapping a fusion service tee. The applicant must be tested for each type of work that they will be performing for the utility.

The test will include a visual inspection and cutting three test strips, 1” wide and 6” along the pipe through the joint. The test will include bending the strips 180º over and checking for disbondment.

Prior to any testing by the Department, the applicant must tap the fusion service tee in the proper manner in order to be qualified to fuse and tap service tees.

28.08 Mechanical Qualification Requirements (Department Only)

Applicants qualifying to connect plastic pipe using mechanical type fittings shall assemble one connection of each type being qualified for in the presence of a tester. Assembly must follow the procedure for the fitting as shown in Section 16.07 "Joining Pipe & Fittings."

Tester shall monitor the assembly for procedural correctness and examine the finished assembly for comparison to a proper assembled fitting. Destructive or pressure testing is not required.

28.09 Requalification Requirements

Requalification shall be accomplished by making at least one joint on the job site each year for each joint type. If no jobs are in progress, then at least one joint shall be made in the shop and tested before the due date of the fuser’s annual requalification.

A person must be requalified annually or any time they have any joints found unacceptable by pressure testing or visual inspection for that type of joint.

All fusing certificates expire March 31st of each year unless the fuser was certified after January 1st of that year.

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29.01 New Service Lines- Location (192.353)

New services should be installed at right angles from the main to the riser location where terrain or obstructions are not a problem. Riser location is determined by meter location criteria and will generally be located on the front, facing the main or on the side within six feet of the front which faces the main.

29.02 Excess Flow Valve (EFV) (192.383)

An excess flow valve will be installed on all services where the meter(s) is rated for 1,000 ccf or less. The only exception is where contaminants could be expected to cause the excess flow valve to malfunction.

The Public Works and Utilities Department will furnish excess flow valves for installation by the Contractor on all new or replaced gas services of the applicable size.

The presence of an excess flow valve shall be identified on the service card records and the service riser tagged with a sticker or similar identifier provided from the excess flow valve manufacturer.

The excess flow valve shall be located as near as practical to the fitting connecting the service line to its source of gas supply as shown on the standard details.

29.03 Inactive Service (Shut off but not disconnected) (192.379)

Whenever a service is inactive (shut off, but not disconnected), the meter stop valve at the meter(s) shall be shut off and locked to prevent the opening of the valve by unauthorized personnel. When a curb valve is present, it should also be shut off. Open ends of piping shall be capped or plugged on both the service side and fuel line side.

29.04 Abandoning Service (192.727)

Service to be abandoned shall be physically cut off from the main according to Section 21. If the service line is larger than ½" it shall be purged of gas before being abandoned. If service valve is closed and blind-flanged or capped downstream, the record should remain as active service with cutoff and cap so noted. The Engineering Division shall maintain record of abandonment in the Abandoned Service Card File and in EAM.

29.05 Reactivation of Service (192.725)

Any service line to be reactivated which was temporarily disconnected from the mains, including repair of 3rd party hits, must be tested from the point of disconnection to the meter stop valve in the same way as a new service line. The service must be tested at

a minimum of 100 PSIG for one half (1/2) hour. All plastic services are to be tested at 100 PSIG. Final connection fittings that were not air tested will be soap tested.

Records of the test must be kept for the life of the service. The records must include the following:

A. The employee's name and date of test
B. Test pressure
C. Test duration
D. Leak and failures noted and corrective action taken

Any time the reconnection occurs next to the main, an excess flow valve must be installed if the service meter(s) is 1,000 ccf or less.

29.06 Reconnection of Active Service to New Main

Any service line that is disconnected from an existing main and immediately reconnected to a new main shall not require testing. The new portion of the service including the service tee, valve (if required) and EFV (if required) shall be tested per the same requirements as a new service per Section 19.

29.07 Temporary Overland Service Lines

29.07.01 Limits on Use of Temporary Overland Service Lines

Temporary service lines may be installed all or partially overland (above ground) if necessary to maintain gas supply while a service is being maintained or modified or to supply gas to a new customer whose existing furnace has failed during the winter season. This does not apply to new construction or non-emergency conversions. All materials shall meet the requirements of Section 14.

29.07.02 Short Term (less than 48 hours)

For bypass or temporary purposes, temporary gas line may be polyethylene, steel, PTFE Hose or other approved material.

29.07.03 Extended Term (greater than 48 hours but less than 4 months)

Low pressure service (maximum 2 PSI) running above grade shall be limited to steel, copper, PTFE Hose or double reinforced neoprene fuel air hose. Pipe or hose used shall be tested at 50 psi for 10 minutes and a label attached showing test pressure, duration, date, and name of tester. Field connectors shall be soap tested or tested with gas scope.

High pressure services (greater than 2 PSI) running above grade shall be polyethylene

or steel. Pipe shall be tested in accordance with Section 19, Gas Main Testing. All connectors must be soap-tested or leak-tested with gas scope.

Where polyethylene pipe is used, it shall be new pipe that has previously been stored indoors and not subjected to UV light.

29.07.04 Source

Temporary service may extend from: high pressure gas main fronting on property; or the low or high pressure side of an adjoining customer meter set, with permission of customer.

29.07.05 Special Protection

Temporary service line must be protected when laid over driveways with a steel casing fixed to the surface and ramped with asphalt or other means.

Only Department personnel shall install overland temporary services. Owners' plumber must install temporary or permanent meter connection.