



Exploration & Production

GENERAL SPECIFICATION

PIPING VALVES VESSELS

GS EP PVV 616

Welding of titanium pipe and fittings

02	10/05	Addition of "EP" root to GS identification
01	10/03	Change of Group name and logo
00	03/01	First issue
Rev.	Date	Notes

Contents

1. Scope	3
2. Reference documents.....	3
3. General characteristics of titanium that dictate prescribed welding techniques	4
4. Process	4
5. Welding equipment	4
6. Welding materials.....	4
7. Preparation of base material and weld surfaces	5
8. Welding procedure.....	5
9. Mechanical testing	6
10. Welder qualification	6
11. Welding	6
12. Cleaning and removal of defects	6
13. Repair welding.....	7
14. Non-destructive examination	7

1. Scope

This specification covers the welding of socket and/or butt weld unalloyed titanium pipes and fittings.

2. Reference documents

The reference documents listed below form an integral part of this General Specification. Unless otherwise stipulated, the applicable version of these documents, including relevant appendices and supplements, is the latest revision published at the EFFECTIVE DATE of the CONTRACT.

Design shall be to **ASME B 31.3** Petroleum Refinery Piping, and welding procedure and welder performance qualification tests to **ASME** Boiler and Pressure Vessel Code, **section IX**.

The present document comes in addition to the general specification **GS EP PVV 611** of which the applicable issue is the latest revision at the date of call for tender.

Any divergence between both documents, or between this specification and any other contractual document should be reported to the COMPANY for decision. Should any discrepancy arise in using the present specification with any other contractual document, it is assumed that the more stringent requirement shall apply, unless otherwise agreed or decided by the COMPANY.

Standards

Reference	Title
Not applicable	

Professional Documents

Reference	Title
Not applicable	

Regulations

Reference	Title
Not applicable	

Codes

Reference	Title
ASME B 31.3	Process piping
ASME Section VIII	Boiler and Pressure Vessel Code
ASME Section IX	Qualification Standard for welding and Brazing, Welders, Brazers, and Welding and Brazing Operators