



HELLENIC GAS
TRANSMISSION SYSTEM
OPERATOR

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**TECHNICAL JOB
SPECIFICATION**

199/7

REVISION 0

DATE 05/04/2011

HIGH PRESSURE (HP) TRANSMISSION SYSTEMS

TIE-INS

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CHANGES LOG

REVISIONS LOG

0	05-04-2011	FIRST ISSUE	PQ DPT	VG
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[Welding]

Job Spec. No. 199/5

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1.0 SCOPE

This specification covers tie-ins for the construction of natural gas lines. For the construction of tie-in the requirements of the following, listed in order of precedence, shall be fulfilled.

- This Job specification
- **ELOT EN 1594**

2.0 EXTENT AND DEFINITION

A tie-in is a girth weld performed in order to connect pipeline sections.

The Contractor shall carry out all the works necessary to connect the pipe so that they form a continuous pipeline. This includes the preparations and associated works required for making tie-ins to existing pipelines, i.e. excavation, welding of connecting assemblies, etc.

3.0 CONSTRUCTION

All welding shall be carried out in accordance with **Job Spec. No. 199/4**. Adjacent sections shall be positioned together in such a way that they can be welded free of stresses.

Bell holes shall be constructed in accordance with **Job Spec. No. 499/2**.

To make the aligning of the pipe-end as easy as possible, the trench shall be kept open for a certain length to either side of the tie-in to allow for a good aligning of the pipes.

It is consequently recommended that tie-ins should be made as soon as possible after pipe has been lowered and not later than 10 calendar days after backfilling of adjacent pipeline segments unless otherwise agreed upon with the Owner's Representative. If the time limit cannot be met the Owner's Representative may order the bell hole to be backfilled and subsequently re-excavated at no extra costs to the owner when the tie-in is to be made. Re-excavation may only be made under the supervision of the Owner's Representative.

The coating of the tie-in joints shall be made in accordance with **Job Spec. No. 199/5**.

Tie-ins shall, where possible, be made with a single girth weld. If a pup is required, this shall be at least 2 x D in length.

All pipe stumps, which exceed a length of 1.5 m and which are cut off at tie-ins shall be welded into a subsequent section of the pipeline, preferably between two full length pipes. All cuts shall be made perpendicular to the pipe axis. Any mitre joint will be cut out and reconstructed properly at the Contractor's expense.

Any cut, which will produce a pipe stump which does not have an original pipe with stamps, may first be made after the stump has been re-marked by the person authorized for transfer of marking.

Pipe stump will be cut from a stamped pipe. If the stump is not marked, transfer of marking will be made by an authorized person.

When making tie-ins with sections which have already been pressure tested, only pups and connecting assemblies which have been tested to at least the same pressure as the pipeline section may be used. All tie-in welds which will not be subject to a pressure test will be 100% inspected both by radiography and ultrasonically.