



PROCESS
INDUSTRY
PRACTICES

August 2016

Pipeline Systems

**PIP PLSC0001
Fabrication and Examination
of ASME B31.8 Metallic Piping**

PURPOSE AND USE OF PROCESS INDUSTRY PRACTICES

In an effort to minimize the cost of process industry facilities, this Practice has been prepared from the technical requirements in the existing standards of major industrial users, contractors, or standards organizations. By harmonizing these technical requirements into a single set of Practices, administrative, application, and engineering costs to both the purchaser and the manufacturer should be reduced. While this Practice is expected to incorporate the majority of requirements of most users, individual applications may involve requirements that will be appended to and take precedence over this Practice. Determinations concerning fitness for purpose and particular matters or application of the Practice to particular project or engineering situations should not be made solely on information contained in these materials. The use of trade names from time to time should not be viewed as an expression of preference but rather recognized as normal usage in the trade. Other brands having the same specifications are equally correct and may be substituted for those named. All Practices or guidelines are intended to be consistent with applicable laws and regulations including OSHA requirements. To the extent these Practices or guidelines should conflict with OSHA or other applicable laws or regulations, such laws or regulations must be followed. Consult an appropriate professional before applying or acting on any material contained in or suggested by the Practice.

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1. Introduction

1.1 Purpose

This Practice provides requirements for fabricating and examining piping systems in accordance with *ASME B31.8 Gas Transmission and Distribution Piping Systems*, (hereinafter referred to as the *Code*).

1.2 Scope

This Practice describes the requirements for both shop and field fabricated piping and pipelines constructed in accordance with *ASME B31.8*. Piping fabrication requirements are provided for materials, welding, forming, and heat treatment.

Examination requirements are provided for piping materials, components, fabrication, assembly, and erection. Requirements for examination documentation are provided. Examination methods, acceptance criteria, and requirements for correction of defective work are also provided.

2. References

Applicable parts of the following Practices and industry codes and standards shall be considered an integral part of this Practice. The edition in effect on the date of contract award shall be used, except as otherwise noted. Short titles are used herein where appropriate. Code section references below are specific to the code editions in effect at the issuance of this Practice.

2.1 Process Industry Practices (PIP)

- PIP PLSC0011 - *Installation of ASME B31.8 Metallic Piping*
- PIP PLC00005 - *Design of ASME B31.8 Metallic Piping*
- PIP PLSC0021 - *Pressure Testing of ASME B31.8 Metallic Piping*
- PIP CTSU1000 - *Application of Underground Coatings*

2.2 Industry Codes and Standards

- American Petroleum Institute (API)
 - API Std 1104 - *Welding of Pipelines and Related Facilities*
- American Society of Mechanical Engineers (ASME)
 - *ASME Boiler and Pressure Vessel Code* (hereafter referred to as the BPV Code)
Section IX - “Welding, Brazing and Fusing Qualifications”
Section V - “Nondestructive Examination”
 - ASME B16.25 - *Buttwelding Ends*
 - ASME B31.8 - *Gas Transmission and Distribution Piping Systems*