

In-Service Data Sheet for Installation Hot Tap Fitting, Branch Connection or Repair Sleeve

Feeder Line #: _____ Project Name: _____

Location: _____ WBS #: _____

Pipeline Material Information	
Pipe OD	
Pipe Grade	
Nominal Wall Thickness	
All Appurtenances Welding to Carrier Pipe	
Pipe CE - MTR/OES Report Provided*	Yes No
Branch/Sleeve CE - MTR Provided*	Yes No
<i>*If No, justification is required. Otherwise, provide pipe MTR if available or arrange to have field OES performed and provide report.</i>	

Pipeline Operational Information	
Est. Line Pressure During Welding Operation	
Est. Gas Temperature During Welding Operation	
Est. Low Flow Rate in Pipeline in Mmcfd	
Est. Average Flow Rate in Pipeline in Mmcfd	

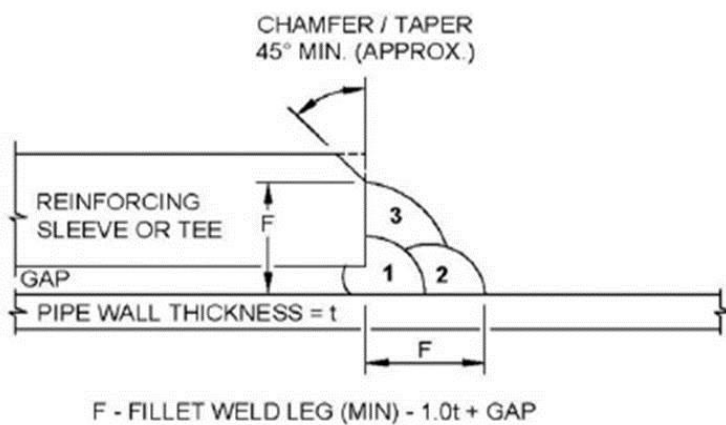
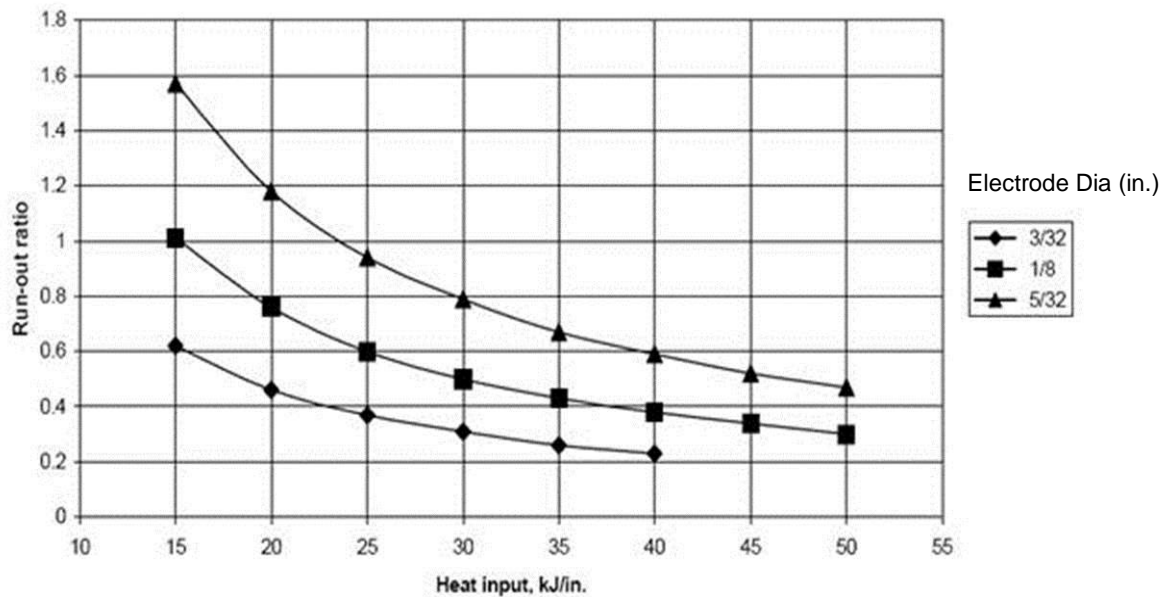
Pipeline In-Service Model Results	
Which WPS should be used based on the pipe and sleeve/branch CE?	
Confirm with field and indicate which Thermal Severity Category I or Category II	
Evaluate for burn-through risk - if the pipe wall thickness is less than 0.250" and/or if using induction heaters. Is there burn-through risk?*	Yes No
<i>*If yes, perform and attach results of PRCI In-Service model. During modelling, consideration of preheat to the pipe and sleeve needs to be evaluated. Utilize the low flow rate for the most conservative estimate, as well as average flow rate.</i>	
Provide recommended range of heat input and run-out-ratio, as well as any other requirements such as pre-heat.	

Recommended wait time for NDE of in-service welds is 12 hours minimum.

Attachments generally include weld procedures, OES or MTRs, PRCI Burn-through Analysis.

Reference Material

Electrode Diameter in. (mm)	Heat Input, kJ/in.							
	15	20	25	30	35	40	45	50
3/32 (2.4)	0.62	0.46	0.37	0.31	0.26	0.23	--	--
1/8 (3.2)	1.01	0.76	0.60	0.50	0.43	0.38	0.34	0.30
5/32 (4.0)	1.57	1.18	0.94	0.79	0.67	0.59	0.52	0.47



Typical Fillet Weld Joint Design should be followed unless otherwise approved by HP Supervisor.