

API Ballot Submission Template (Rev 2)

(All ballot submissions must be in electronic format – Microsoft Word or equivalent)

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Work Item Number	2457
Title of Work Item	Flattening Retest Clarification
Ballot Revision Level	0
Type of Ballot (Initial, Comment, Comment resolution (reference API ballot#), 1 st Re-ballot, 2 nd Re-ballot, etc.)	Initial
Submitter Name(s)	Joe Majkrzak
API Document Modified	API 5CT 11 th Edition
Impacted Documents	None
Revision Key	Current API text = black Deletions = red Additions = <u>red</u>

Work Item Charge: Review and update the requirements for retests of flattening test failures (section 10.5.7) to clarify when retesting from same length and testing of additional lengths is allowed or required.

Ballot Rationale: The current wording can be interpreted to allow testing two additional lengths for ERW as-welded products that fail the initial welding flattening test. Since this test is intended to verify the welding process at the start of production and when changes to welding parameters are made, testing two additional random lengths does not accomplish the intent.

Ballot Text: See below.

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9.5.7 Retests

If ~~either a~~ test specimen (0° or 90° weld position) ~~representing a single length of pipe~~ fails to meet the requirements specified, the manufacturer may elect to make additional tests on specimens as follows:

Specimens for retests shall be taken in the same manner as specified in 10.5.3 and in the same weld position as the failed specimen.

a) Tests on leading end of first pipe of each coil, trailing end of last pipe on each coil, or single length lot –

cut retest specimen from the same end of the same length of pipe, until the requirements are met, except that the finished pipe shall not be shorter than 80% of its length after the initial cropping. ~~If any test specimen from a length of pipe representing a lot fails to conform to the requirements specified, the manufacturer may elect to repeat the tests on specimens~~

b) Tests on intermediate pipe on each coil –

cut retest specimen from the same end of the same length of pipe and the matching end of the adjacent length of pipe, until the requirements are met, except that the finished pipes shall not be shorter than 80% of their length after the initial cropping.

c) Tests on random pipe representing a lot (full-body, full-length heat treated) –

cut retest specimen from two additional lengths of pipe from the same lot. If such specimens conform to the specified requirements, all the lengths in the lot shall be accepted except the length initially selected for the test. If any of the retest specimens fails to pass the specified requirements, the manufacturer may elect to test specimens cut from the individual lengths remaining in the lot or reject the entire lot.

At the option of the manufacturer, any lot ~~of pipe~~ may be reheat-treated and tested as a new lot.