



DETAIL A

MANGO (Missouri Association of Natural Gas Operations)			
TITLE In-Service Welder Qualification for MANGO Welding Procedure No.2			
SIZE A		DWG NO 12 inch in-service test MANGO Welder	REV 1
SCALE		SHEET 1 OF 2	

In-service test pipe to be mounted at 45° with groove weld in the overhead position. Test will be conducted with water flowing through pipe.

Two fillet /nick break test straps are to be cut from this weld

Water in
Out

Water in
Out

Rotated 1:30 & 7:30

Two fillet /nick break test straps are to be cut from this weld

Test straps to be cut from this weld:
1-Face Bend
1-Root Bend
1-Nick Break
1-Tensile Test*

* Can sub second Nick Break for Tensile Test.
API 1104 6.5.2

Mounting fixture bolted to secure stand.

A

Parts list		
Part	Material	Quantity
Carrier pipe	12 3/4" O.D. x .25" wall pipe 18" long	1
Sleeve	12 3/4" O.D. x .25" wall pipe 12" long	2
Backing Strip	1/16" x 1 1/2" steel 12" long	2
End caps	13 1/2" Dia. x 3/16" plate	2
Pipe nipples	As needed	2
Mounting assembly	As needed	1

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In-Service Welder Qualification for MANGO Welding Procedure No.2			
SIZE	Rev date:	DWG NO	REV
A	10/07/15	12 inch in-service test MANGO Welder	2
SCALE		Initial date: 10/22/2014	SHEET 2 OF 2

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