

Chapter PSC 135

GAS SAFETY

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History: Chapter PSC 135 as it was in effect on May 31, 1972 was repealed and a new chapter PSC 135 was created, Register, May, 1972, No. 197, effective 6-1-72.

PSC 135.01 Character of construction, maintenance, and operation. All gas transmission, distribution, and utilization equipment and facilities shall be constructed, installed, operated, and maintained in a reasonably adequate and safe manner and as a minimum more specifically provided for herein.

History: Cr. Register, May, 1972, No. 197, eff. 6-1-72.

PSC 135.02 Facilities, inspection and repairs. All facilities shall be cleaned when necessary and inspected at such intervals as experience has shown to be necessary. Any facilities known to be defective so as to endanger life or property shall be promptly repaired, permanently disconnected, or isolated until repairs can be made. Construction, repairs, additions, and changes to gas transmission and distribution facilities shall be made by qualified persons only.

History: Cr. Register, May, 1972, No. 197, eff. 6-1-72.

PSC 135.03 Application of rules. Every gas utility that operates gas transmission or distribution facilities in the state shall comply with the rules in this chapter.

(1) **WAIVING RULES.** The rules may be modified or waived by the public service commission. They may be so modified or waived in particular cases wherever shown to be impracticable for special reasons or where the advantage of uniformity with existing construction is greater than the advantage of construction in compliance with the rules providing the existing construction is reasonably safe or if equivalent or safer construction is secured in other ways.

(2) **TEMPORARY INSTALLATIONS.** It will sometimes be necessary to modify or waive certain of the rules in case of temporary installations or installations which are shortly to be dismantled or reconstructed. Such temporary construction may be used for a reasonable length of time provided it is under competent supervision while it or adjoining equipment is under pressure or if it is protected by suitable barriers or warning signs when accessible to any person, without fully complying with this code; but all such construction shall be made reasonably safe.

(3) **EMERGENCY.** In case of emergency or pending decision of the public service commission, the person responsible for the installation may

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decide as to modification or waiver of any rule or order, subject to review by the public service commission.

History: Cr. Register, May, 1972, No. 197, eff. 6-1-72.

PSC 135.04 Protection of utility facilities. A public utility upon receiving notice as provided in s. 66.047, Stats., or s. 182.0175 (2) (e), Stats., of work which may affect its facilities used for serving the public shall:

(1) If the notice is of work covered by s. 66.047, Stats., investigate and decide what action, if any, must reasonably be taken to protect or alter utility facilities in order to protect service to the public and to avoid unnecessary damage. The utility shall take such action as is reasonably necessary to protect, remove, alter, or reconstruct its facilities, and shall perform such work with reasonable dispatch taking into account the conditions to be met. Nothing in this rule shall be deemed to affect any right which the utility may have to require advance payment or adequate assurance of payment of the reasonable cost thereof to the utility by the property owner or contractor.

(2) If the notice is of work covered by s. 182.0175 (2) (e), Stats., and is not covered by s. 66.047, Stats., the utility shall respond as required by s. 182.0175 (2) (e).

(3) The utility may, in order to protect its interests, require that the owner or contractor perform certain work upon that part of the service piping or wiring on or being removed from the property upon which the excavating, building, or wrecking operations are being performed.

(4) This rule is not intended to affect the responsibility of the contractor or owner, or the liability or legal rights of any party.

History: Cr. Register, May, 1972, No. 197, eff. 6-1-72; r. and recr. Register, May, 1978, No. 269, eff. 6-1-78.

PSC 135.05 Interference with public service structures. (1) A utility having any work upon, over, along, or under any public street, highway or private property near existing utility facilities shall give reasonable notice to the other utility and shall exercise care when working in close proximity to such existing facilities. Sections 66.047 and 182.0175, Stats., shall be observed where applicable. In all other cases such notice shall provide the other utility with a reasonable opportunity to protect or alter its facilities and such work shall not proceed without an agreement concerning the location and nature of the proposed work.

(2) Nothing in the above shall prevent a utility from proceeding as quickly as possible with any emergency construction work which might interfere with existing facilities. (Also see s. 182.0175 (2) (d), Stats.)

History: Cr. Register, May, 1972, No. 197, eff. 6-1-72; r. and recr. Register, May, 1978, No. 269, eff. 6-1-78.

PSC 135.06 Leak survey reports. The department of transportation in accordance with part 191 of title 49 of the Code of Federal Regulations "Transportation of Natural and Other Gas by Pipeline: Reports of Leaks" requires each operator of a distribution system and/or of a transmission system to submit an annual report for the preceding calendar year not later than February 15. The operators of such systems in Wisconsin shall submit a copy of these reports to this commission on or before the filing date as required by the federal regulations. In addition

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to this annual report and at the same time, the operators shall report the number of leaks which were found in customer owned facilities by either a survey or complaint during the preceding calendar year.

History: Cr. Register, May, 1972, No. 197, eff. 6-1-72.

PSC 135.07 Over-pressure protection. Over-pressure protection is required by subsection 192.197 of this chapter and shall apply to all installations. All present installations where such protection is not provided shall be changed so that 100% compliance will be attained by the end of the first testing cycle after January 1, 1968 as provided in section PSC 134.30.

History: Cr. Register, May, 1972, No. 197, eff. 6-1-72.

PSC 135.09 Adoption of federal minimum safety standards. (1) The federal department of transportation, office of pipeline safety, pursuant to the Natural Gas Pipeline Safety Act of 1968 (49 U.S.C. 1675, et seq.) has established minimum safety standards for pipeline facilities and the transportation of gas, as set forth in part 192 in title 49, Code of Federal Regulations. In accordance with the Natural Gas Pipeline Safety Act of 1968 and requirements of the federal department of transportation, such minimum safety standards are hereby adopted as state safety standards. (The numbering system and sequence used in said minimum safety standards are herein used for convenience and clarity.) Additions have been made to the minimum safety standards of the federal department of transportation as adopted herein and follow the section of the adopted federal standards to which the additions directly relate or if the additions do not directly relate to any particular adopted federal standard the additions are inserted in the numbering sequence within the appropriate subpart. In all cases the additions appear in italics preceded by *PSC 192* plus the appropriate section number. Copies of the publications referred to are available for inspection at the office of the public service commission, the secretary of state and the revisor of statutes or may be procured for personal use from the addresses listed in Appendix A—Incorporated by Reference, I. Lists of organizations and addresses, which follows section *PSC 192.753*.

(2) The inspection and maintenance plans required to be filed by intrastate gas utilities in accordance with section PSC 135.09—192.17 shall be filed with this commission not later than February 1, 1971. Each change in such plans shall be filed with this commission within 20 days after the change is made.

WISCONSIN CODE ADOPTION
OF
PART 192 IN TITLE 49
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*Sections of the Code of Federal Regulations to which additions have been made.

* (Italics) New sections that have been added.

Subpart A—General

192.1 Scope of part.

(a) This part prescribes minimum safety requirements for pipeline facilities and the transportation of gas, including pipeline facilities and the transportation of gas within the limits of the outer continental shelf as that term is defined in the Outer Continental Shelf Lands Act (43 U.S.C. 1331).

(b) This part does not apply to:

(1) Offshore gathering of gas upstream from the outlet flange of each facility on the outer continental shelf where hydrocarbons are produced or where produced hydrocarbons are first separated, dehydrated, or otherwise processed, whichever facility is farther downstream; and

(2) Onshore gathering of gas outside of the following areas:

(i) An area within the limits of any incorporated or unincorporated city, town, or village.

(ii) Any designated residential or commercial area such as a subdivision, business or shopping center, or community development.

192.3 Definitions.

As used in this part—

“Distribution Line” means a pipeline other than a gathering or transmission line.

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"Gas" means natural gas, flammable gas, or gas which is toxic or corrosive.

"Gathering Line" means a pipeline that transports gas from a current production facility to a transmission line or main.

"High pressure distribution system" means a distribution system in which the gas pressure in the main is higher than the pressure provided to the customer.

"Listed specification" means a specification listed in section I of Appendix B of this part.

"Low-pressure distribution system" means a distribution system in which the gas pressure in the main is substantially the same as the pressure provided to the customer.

"Main" means a distribution line that serves as a common source of supply for more than one service line.

"Maximum actual operating pressure" means the maximum pressure that occurs during normal operations over a period of 1 year.

"Maximum allowable operating pressure" means the maximum pressure at which a pipeline or segment of a pipeline may be operated under this part.

"Municipality" means a city, county, or any other political subdivision of a state.

"Offshore" means beyond the line of ordinary low water along that portion of the coast of the United States that is in direct contact with the open seas and beyond the line marking the seaward limit of inland waters.

"Operator" means a person who engages in the transportation of gas.

"Person" means any individual, firm, joint venture, partnership, corporation, association, state, municipality, cooperative association, or joint stock association, and includes any trustee, receiver, assignee, or personal representative thereof.

"Pipe" means any pipe or tubing used in the transportation of gas, including pipe-type holders.

"Pipeline" means all parts of those physical facilities through which gas moves in transportation, including pipe, valves, and other appurtenance attached to pipe, compressor units, metering stations, regulator stations, delivery stations, holders, and fabricated assemblies.

"Pipeline facility" means new and existing pipelines, rights-of-way, and any equipment, facility, or building used in the transportation of gas or in the treatment of gas during the course of transportation.

"Secretary" means the secretary of transportation or any person to whom he has delegated authority in the matter concerned.

"Service line" means a distribution line that transports gas from a common source of supply to (1) a customer meter or the connection to a customer's piping, whichever is farther downstream, or (2) the connection to a customer's piping if there is no customer meter. A customer meter is the meter that measures the transfer of gas from an operator to a consumer.

"SMYS" means specified minimum yield strength is—

(1) For steel pipe manufactured in accordance with a listed specification, the yield strength specified as a minimum in that specification; or

(2) For steel pipe manufactured in accordance with an unknown or unlisted specification, the yield strength determined in accordance with 192.107 (b).

"State" means each of the several states, the District of Columbia, and the Commonwealth of Puerto Rico.

"Transmission line" means a pipeline, other than a gathering line, that—

(1) Transports gas from a gathering line or storage facility to a distribution center or storage facility;

(2) Operates at a hoop stress of 20 percent or more of SMYS; or

(3) Transports gas within a storage field.

"Transportation of gas" means the gathering, transmission, or distribution of gas by pipeline or the storage of gas, in or affecting interstate or foreign commerce.

192.5 Class locations.

(a) Offshore is Class 1 location. The Class location onshore is determined by applying the criteria set forth in this section: The class location unit is an area that extends 220 yards on either side of the centerline of any continuous 1-mile length of pipeline. Except as provided in paragraphs (d) (2) and (f) of this section, the class location is determined by the buildings in the class location unit. For the purposes of this section, each separate dwelling unit is counted as a separate building intended for human occupancy.

(b) A Class 1 location is any class location unit that has 10 or less buildings intended for human occupancy.

(c) A Class 2 location is any class location unit that has more than 10 but less than 46 buildings intended for human occupancy.

(d) A Class 3 location is—

(1) Any class location unit that has 46 or more buildings intended for human occupancy; or

(2) An area where the pipeline lies within 100 yards of any of the following:

(i) A building that is occupied by 20 or more persons during normal use.

(ii) A small, well-defined outside area that is occupied by 20 or more persons during normal use, such as a playground, recreation area, outdoor theater, or other place of public assembly.

(e) A Class 4 location is any class location unit where buildings with four or more stories above ground are prevalent.

(f) The boundaries of the class locations determined in accordance with paragraphs (a) through (e) of this section may be adjusted as follows:

(1) A Class 4 location ends 220 yards from the nearest building with four or more stories above ground.

(2) When a cluster of buildings intended for human occupancy requires a Class 3 location, the Class 3 location ends 220 yards from the nearest building in the cluster.

(3) When a cluster of buildings intended for human occupancy requires a Class 2 location, the Class 2 location ends 220 yards from the nearest building in the cluster.

192.7 Incorporation by reference.

(a) Any documents or parts thereof incorporated by reference in this part are a part of this regulation as though set out in full.

(b) All incorporated documents are available for inspection in the Office of Pipeline Safety, Room 107, 400 Sixth Street SW., Washington, D.C. In addition, the documents are available at the addresses provided in Appendix A to this part.

(c) The full titles for the publications incorporated by reference in this part are provided in Appendix A to this part.

192.9 Gathering lines.

Each gathering line must comply with the requirements of this part applicable to transmission lines.

192.11 Petroleum gas systems.

(a) No operator may transport petroleum gas in a system that serves 10 or more customers, or in a system, any portion of which is located in a public place (such as a highway), unless that system meets the requirements of this part and of NFPA Standards No. 58 and No. 59. In the event of a conflict, the requirements of this part prevail.

(b) Each petroleum gas system covered by paragraph (a) of this section must comply with the following:

(1) Aboveground structures must have open vents near the floor level.

(2) Belowground structures must have forced ventilation that will prevent any accumulation of gas.

(3) Relief valve discharge vents must be located so as to prevent any accumulation of gas at or below ground level.

(4) Special precautions must be taken to provide adequate ventilation where excavations are made to repair an underground system.

(c) For the purpose of this section, petroleum gas means propane, butane, or mixtures of these gases, other than a gas air mixture that is used to supplement supplies in a natural gas distribution system.

192.12 Liquefied natural gas facilities.

(a) Except for a pipeline facility in operation or under construction before January 1, 1973, no operator may store, treat or transfer liquefied

natural gas in a pipeline facility unless that pipeline facility meets the applicable requirements of this part and of NFPA Standard No. 59A.

(b) No operator may store, treat, or transfer liquefied natural gas in a pipeline facility in operation or under construction before January 1, 1973, unless—

(1) The facility is operated in accordance with the applicable operating requirements of this part and of NFPA Standard 59A; and

(2) Each modification or repair made to the facility after December 31, 1972, conforms to the applicable requirements of this part and NFPA Standard 59A, insofar as is practicable.

192.13 General

(a) No person may operate a segment of pipeline that is readied for service after March 12, 1971, or in the case of an offshore gathering line, after July 31, 1977, unless:

(1) The pipeline has been designed, installed, constructed, initially inspected, and initially tested in accordance with this part; or

(2) The pipeline qualifies for use under this part in accordance with section 192.14.

(b) No person may operate a segment of pipeline that is replaced, relocated, or otherwise changed after November 12, 1970, or in the case of an offshore gathering line, after July 31, 1977, unless that replacement, relocation, or change has been made in accordance with this part.

(c) Each operator shall maintain, modify as appropriate, and follow the plans, procedures, and programs that it is required to establish under this part.

192.14 Conversion to service subject to this part.

(a) A steel pipeline previously used in service not subject to this part qualifies for use under this part if the operator prepares and follows a written procedure to carry out the following requirements:

(1) The design, construction, operation, and maintenance history of the pipeline must be reviewed and, where sufficient historical records are not available, appropriate tests must be performed to determine if the pipeline is in a satisfactory condition for safe operation.

(2) The pipeline right-of-way, all aboveground segments of the pipeline, and appropriately selected underground segments must be visually inspected for physical defects and operating conditions which reasonably could be expected to impair the strength or tightness of the pipeline.

(3) All known unsafe defects and conditions must be corrected in accordance with this part.

(4) The pipeline must be tested in accordance with Subpart J of this part to substantiate the maximum allowable operating pressure permitted by Subpart L of this part.

(b) Each operator must keep for the life of the pipeline a record of the investigations, tests, repairs, replacements, and alterations made under the requirements of paragraph (a) of this section.

192.15 Rules of regulatory construction.

(a) As used in this part—

“Includes” means including but not limited to.

“May” means “is permitted to” or “is authorized to”.

“May not” means “is not permitted to” or “is not authorized to”.

“Shall” is used in the mandatory and imperative sense.

(b) In this part—

(1) Words importing the singular include the plural;

(2) Words importing the plural include the singular; and

(3) Words importing the masculine gender include the feminine.

192.17 Filing of inspection and maintenance plans.

(a) Except as provided in paragraph (b) of this section, each operator shall file with the secretary not later than February 1, 1971, a plan for inspection and maintenance of each pipeline facility which he owns or operates. In addition, each change to an inspection and maintenance plan must be filed with the secretary within 20 days after the change is made.

(b) The provisions of paragraph (a) of this section do not apply to pipeline facilities—

(1) That are subject to the jurisdiction of a state agency that has submitted a certification or agreement with respect to those facilities under section 5 of the Natural Gas Pipeline Safety Act (49 U.S.C. 1675); and

(2) For which an inspection and maintenance plan is required to be filed with that state agency.

(c) Plans filed with the secretary must be sent to the office of Pipeline Safety, Department of Transportation, Washington, D.C. 20590.

Subpart B—Materials**192.51 Scope.**

This subpart prescribes minimum requirements for the selection and qualification of pipe and components for use in pipelines.

192.53 General.

Materials for pipe and components must be—

(a) Able to maintain the structural integrity of the pipeline under temperature and other environmental conditions that may be anticipated.

PSC 192.53 (a) Some of the materials conforming to specifications approved for use under this code may not have properties suitable for the lower portion of the temperature band covered by this code. Engineers are cautioned to give attention to the low-temperature properties of the materials used for facilities to be exposed to unusually low ground temperatures or low atmospheric temperatures. Twenty (20) inch steel pipe and larger, with a specified minimum yield strength of

52,000 p.s.i. or higher, shall be tested for fracture toughness in accordance with the applicable section of respective API standard under which it was produced, except for small lot purchases of pipe where testing for fracture toughness is impractical.

(b) Chemically compatible with any gas that they transport and with any other material in the pipeline with which they are in contact; and

(c) Qualified in accordance with the applicable requirements of this subpart.

PSC 192.53 (d) When substantial quantities of pipe are acquired certified reports of chemical composition and physical properties shall be obtained; when the quantity of pipe involved is so limited that this requirement would be impractical, a certified statement shall be obtained setting forth the specification under which the pipe was manufactured.

192.55 Steel pipe.

(a) New steel pipe is qualified for use under this part if—

(1) It was manufactured in accordance with a listed specification;

(2) It meets the requirements of—

(i) Section II of Appendix B to this part; or

(ii) If it was manufactured before November 12, 1970, either section II or III of Appendix B to this part; or

(3) It is used in accordance with paragraph (c) or (d) of this section.

(b) Used steel pipe is qualified for use under this part if—

(1) It was manufactured in accordance with a listed specification and it meets the requirements of paragraph II-C of Appendix B to this part;

(2) It meets the requirements of—

(i) Section II of Appendix B to this part; or

(ii) If it was manufactured before November 12, 1970, either section II or III of Appendix B to this part;

(3) It has been used in an existing line of the same or higher pressure and meets the requirements of paragraph II-C of Appendix B to this part; or

(4) It is used in accordance with paragraph (c) of this section.

(c) New or used steel pipe may be used at a pressure resulting in a hoop stress of less than 6,000 p.s.i. where no close coiling or close bending is to be done, if visual examination indicates that the pipe is in good condition and that it is free of split seams and other defects that would cause leakage. If it is to be welded, steel pipe that has not been manufactured in a listed specification must also pass the weldability tests prescribed in paragraph II-B of Appendix B to this part.

(d) Steel pipe that has not been previously used may be used as replacement pipe in a segment of pipeline if it has been manufactured prior to November 12, 1970, in accordance with the same specification as the pipe used in constructing that segment of pipeline.

(e) New steel pipe that has been cold expanded must comply with the mandatory provisions of API Standard 5LX.

PSC 192.55 (f) Pipe manufactured from steel made by the Bessemer process shall not be used.

192.57 Cast iron or ductile iron pipe.

(a) New cast iron or new ductile iron pipe is qualified for use under this part if it has been manufactured in accordance with a listed specification.

(b) Used cast iron or used ductile iron pipe is qualified for use under this part if inspection shows that the pipe is sound and allows the makeup of tight joints and—

(1) It has been removed from an existing pipeline that operated at the same or higher pressure; or

(2) It was manufactured in accordance with a listed specification.

PSC 192.57 (c) Cast iron pipe shall not be used as a permanent part of any piping system constructed under this code except where it is used as a temporary installation or replacement of short sections of existing cast iron pipe because of maintenance or relocation. In those cases where cast iron pipe is used it shall be designed, installed, and operated in accordance with the applicable sections of this code.

192.59 Plastic pipe.

(a) New plastic pipe is qualified for use under this part if—

(1) When the pipe is manufactured, it is manufactured in accordance with the latest listed edition of a listed specification, except that before March 21, 1975, it may be manufactured in accordance with any listed edition of a listed specification; and

(2) It is resistant to chemicals with which contact may be anticipated.

(b) Used plastic pipe is qualified for use under this part if—

(1) When the pipe was manufactured, it was manufactured in accordance with the latest listed edition of a listed specification, except that pipe manufactured before March 21, 1975, need only have met the requirements of any listed edition of a listed specification;

(2) It is resistant to chemicals with which contact may be anticipated;

(3) It has been used only in natural gas service;

(4) Its dimensions are still within the tolerances of the specification to which it was manufactured; and

(5) It is free of visible defects.

(c) For the purpose of paragraphs (a) (1) and (b) (1) of this section, where pipe of a diameter included in a listed specification is impractical to use, pipe of a diameter between the sizes included in a listed specification may be used if it—

(1) Meets the strength and design criteria required of pipe included in that listed specification; and

(2) Is manufactured from plastic compounds which meet the criteria for material required of pipe included in that listed specification.

PSC 192.59 (c) *Plastic pipe and tubing shall be adequately supported during storage. Thermoplastic pipe, tubing and fittings shall be protected from long term exposure to direct sunlight.*

192.61 Copper pipe.

Copper pipe is qualified for use under this part if it has been manufactured in accordance with a listed specification.

192.63 Marking of materials.

(a) Except as provided in paragraph (e) of this section, each valve, fitting, length of pipe, and other component must be marked as prescribed in—

- (1) The specification or standard to which it was manufactured; or
- (2) MSS standard practice, SP-25.

(b) In addition to the requirements in paragraph (a), thermoplastic pipe manufactured in accordance with the 1974a or earlier listed edition of ASTM D2513 must be marked as required by section 9.2 of ASTM D2513 (1975b edition) unless the pipe was manufactured before May 18, 1978, and is installed where operating temperatures are not above 38°C (100°F).

(c) Surfaces of pipe and components that are subject to stress from internal pressure may not be field die stamped.

(d) If any item is marked by die stamping, the die must have blunt or rounded edges that will minimize stress concentrations.

(e) Paragraph (a) of this section does not apply to items manufactured before November 12, 1970, that meet all of the following:

- (1) The item is identifiable as to type, manufacturer, and model.
- (2) Specifications or standards giving pressure, temperature, and other appropriate criteria for the use of items are readily available.

192.65 Transportation of pipe.

In a pipeline to be operated at a hoop stress of 20 percent or more of SMYS, an operator may not use pipe having an outer diameter to wall thickness ratio of 70 to 1, or more, that is transported by railroad unless—

(a) The transportation is performed in accordance with the 1972 edition of API RP5LL, except that before February 25, 1975, the transportation may be performed in accordance with the 1967 edition of API RP5LL.

(b) In the case of pipe transported before November 12, 1970, the pipe is tested in accordance with Subpart J of this part to at least 1.25 times the maximum allowable operating pressure if it is to be installed in a class 1 location and to at least 1.5 times the maximum allowable operating pressure if it is to be installed in a class 2, 3, or 4 location.

Notwithstanding any shorter time period permitted under Subpart J of this part, the test pressure must be maintained for at least 8 hours.

Subpart C—Pipe Design**192.101 Scope.**

This subpart prescribes the minimum requirements for the design of pipe.

192.103 General.

Pipe must be designed with sufficient wall thickness, or must be installed with adequate protection, to withstand anticipated external pressures and loads that will be imposed on the pipe after installation.

192.105 Design formula for steel pipe.

(a) The design pressure for steel pipe is determined in accordance with the following formula:

$$P = \frac{2 St}{D} \times F \times E \times T$$

P = Design pressure in pounds per square inch gage.

S = Yield strength in pounds per square inch determined in accordance with 192.107.

D = Nominal outside diameter of the pipe in inches.

t = Nominal wall thickness of the pipe in inches. If this is unknown, it is determined in accordance with 192.109. Additional wall thickness required for concurrent external loads in accordance with 192.103 may not be included in computing design pressure.

F = Design factor determined in accordance with 192.111.

E = Longitudinal joint factor determined in accordance with 192.113.

T = Temperature derating factor determined in accordance with 192.115.

(b) If steel pipe that has been cold worked to meet the SMYS is heated, other than by welding, to 600° F. or more, the design pressure is limited to 75 percent of the pressure determined under paragraph (a) of this section.

192.107 Yield strength (S) for steel pipe.

(a) For pipe that is manufactured in accordance with a specification listed in section I of Appendix B of this part, the yield strength to be used in the design formula in 192.105 is the SMYS stated in the listed specification, if that value is known.

(b) For pipe that is manufactured in accordance with a specification not listed in section I of Appendix B to this part or whose specification or tensile properties are unknown, the yield strength to be used in the design formula in 192.105 is one of the following:

(1) If the pipe is tensile tested in accordance with section 11-D of Appendix B to this part, the lower of the following:

(i) 80 percent of the average yield strength determined by the tensile tests.

(ii) The lowest yield strength determined by the tensile tests, but not more than 52,000 p.s.i.

(2) If the pipe is not tensile tested as provided in subparagraph (1) of this paragraph 24,000 p.s.i.

192.109 Nominal wall thickness (*t*) for steel pipe.

(a) If the nominal wall thickness for steel pipe is not known, it is determined by measuring the thickness of each piece of pipe at quarter points on one end.

(b) However, if the pipe is of uniform grade, size, and thickness and there are more than 10 lengths, only 10 percent of the individual lengths, but not less than 10 lengths, need be measured. The thickness of the lengths that are not measured must be verified by applying a gage set to the minimum thickness found by the measurement. The nominal wall thickness to be used in the design formula in 192.105 is the next wall thickness found in commercial specifications that is below the average of all the measurements taken. However, the nominal wall thickness used may not be more than 1.14 times the smallest measurement taken on pipe less than 20 inches in outside diameter, nor more than 1.11 times the smallest measurement taken on pipe 20 inches or more in outside diameter.

192.111 Design factor (*F*) for steel pipe.

(a) Except as otherwise provided in paragraphs (b), (c), and (d) of this section, the design factor to be used in the design formula in 192.105 is determined in accordance with the following table:

<i>Class location</i>	<i>Design factor (F)</i>
1.....	0.72
2.....	0.60
3.....	0.50
4.....	0.40

(b) A design factor of 0.60 or less must be used in the design formula in 192.105 for steel pipe in Class 1 locations that:

(1) Crosses the right-of-way of an unimproved public road, without a casing;

(2) Crosses without a casing, or makes a parallel encroachment on, the right-of-way of either a hard surfaced road, a highway, a public street, or a railroad;

(3) Is supported by a vehicular, pedestrian, railroad, or pipeline bridge; or

(4) Is used in a fabricated assembly, (including separators, mainline valve assemblies, cross-connections, and river crossing headers) or is used within five pipe diameters in any direction from the last fitting of a fabricated assembly, other than a transition piece or an elbow used in place of a pipe bend which is not associated with a fabricated assembly.

(c) For Class 2 locations, a design factor of 0.50, or less, must be used in the design formula in 192.105 for uncased steel pipe that crosses the right-of-way of a hard surfaced road, a highway, a public street, or a railroad.

(d) For Class 1 and Class 2 locations, a design factor of 0.50, or less, must be used in the design formula in § 192.105 for—

(1) Steel pipe in a compressor station, regulating station, or measuring station; and

(2) Steel pipe, including a pipe riser, on a platform located offshore or in inland navigable waters.

192.113 Longitudinal joint factor (E) for steel pipe.

The longitudinal joint factor to be used in the design formula in 192.105 is determined in accordance with the following table:

Specification	Pipe class	Longitudinal joint factor (E)
ASTM A 53	Seamless.....	1.00
	Electric resistance welded.....	1.00
	Furnace butt welded.....	.60
ASTM A 106	Seamless.....	1.00
ASTM A 134	Electric fusion arc welded.....	.80
ASTM A 136	Electric resistance welded.....	1.00
ASTM A 139	Electric fusion welded.....	.80
ASTM A 155	Electric fusion arc welded.....	1.00
ASTM A 211	Spiral welded steel pipe.....	.80
ASTM A 333	Seamless.....	1.00
	Electric resistance welded.....	1.00
	Double submerged arc welded.....	1.00
ASTM A 381	Double submerged arc welded.....	1.00
API 5 L	Seamless.....	1.00
	Electric resistance welded.....	1.00
	Electric flash welded.....	1.00
	Submerged arc welded.....	1.00
	Furnace butt welded.....	.60
	Furnace lap-welded.....	.80
API 6 LX	Seamless.....	1.00
	Electric resistance welded.....	1.00
	Electric flash welded.....	1.00
	Submerged arc welded.....	1.00
API 5 LS	Electric resistance welded.....	1.00
	Submerged arc welded.....	1.00
Other	Pipe over 4 inches.....	.80
Other	Pipe 4 inches or less.....	.60

If the type of longitudinal joint cannot be determined, the joint factor to be used must not exceed that designated for "Other".

192.115 Temperature derating factor (T) for steel pipe.

The temperature derating factor to be used in the design formula in 192.105 is determined as follows:

<i>Gas temperature in degrees Fahrenheit</i>	<i>Temperature derating factor (T)</i>
250 or less.....	1.000
300.....	0.967
350.....	0.933
400.....	0.900
450.....	0.867

For intermediate gas temperatures, the derating factor is determined by interpolation.

192.117 Design of cast iron pipe.

Cast iron pipe must be designed in accordance with ANSI A 21.1 using the following values for *S* (bursting tensile strength) and *R* (modulus of rupture) in the design equations:

Specification	Type of pipe	S	R
		psi	psi
ANSI A 21.3	Pit cast.....	11,000	31,000
ANSI A 21.7	Centrifugal (metal mold)	18,000	40,000
ANSI A 21.9	Centrifugal (sand-lined mold)	18,000	40,000

192.119 Design of ductile iron pipe.

(a) Ductile iron pipe must be designed in accordance with ANSI A21.50 using the following values in the design equations:

- s* (design hoop stress) = 16,800 p.s.i.
- f* (design bending stress) = 36,000 p.s.i.

(b) Ductile iron pipe must be grade (60-42-10) and must conform to the requirements of ANSI A21.52.

192.121 Design of plastic pipe.

(a) The design pressure for plastic pipe is determined in accordance with the following formula, subject to the limitations of s. 192.123:

$$P = 2S \frac{t}{(D-t)} \times 0.32$$

- P* = Design pressure, gage, RPa (psi).
- S* = For thermoplastic pipe the long-term hydrostatic strength determined in accordance with the listed specification at a temperature equal to 23° C (73° F), 38° C (100° F), 49° C (120° F), or 60° C (140° F); for reinforced thermosetting plastic pipe, 75,800 kPa (11,000 psi).
- t* = Specified wall thickness, mm (in.).
- D* = Specified outside diameter, mm (in.).

(b) The design factor for plastic pipe is determined as follows:

Class location	Design factor
1.....	0.32
2.....	0.25
3.....	0.25
4.....	0.20

192.123 Design limitation for plastic pipe.

(a) The design pressure may not exceed 689 kPa (100 p.s.i.g.) for plastic pipe used in—

- (1) Distribution systems; or
- (2) Classes 3 and 4 locations.

(b) Plastic pipe may not be used where operating temperatures of the pipe will be—

- (1) Below minus 29° C (-20° F); or

(2) In the case of thermoplastic pipe, above the temperature at which the long-term hydrostatic strength used in the design formula under s. 192.121 is determined, except that pipe manufactured before May 18, 1978, may be used at temperatures up to 30° C (100° F); or in the case of reinforced thermosetting plastic pipe, above 66° C (150° F).

(c) The wall thickness for thermoplastic pipe may not be less than 1.57 millimeters (0.062 in.).

(d) The wall thickness for reinforced thermosetting plastic pipe may not be less than that listed in the following table:

<i>Nominal size in inches</i>	<i>Minimum wall thickness in millimeters (inches)</i>
2 -----	1.52 (0.060)
3 -----	1.52 (0.060)
4 -----	1.78 (0.070)
6 -----	2.54 (0.100)

192.125 Design of copper pipe.

(a) Copper pipe used in mains must have minimum wall thickness of 0.065 inches and must be hard drawn.

(b) Copper pipe used in service lines must have a minimum wall thickness as specified for type "L" pipe in ASTM B 88.

(c) Copper pipe used in mains and service lines may not be used at pressures in excess of 100 p.s.i.g.

(d) Copper pipe that does not have an internal corrosion resistant lining may not be used to carry gas that has an average hydrogen sulfide content of more than 0.3 grains per 100 standard cubic feet of gas.

PSC 192.125 (e) Fittings in copper piping. It is recommended that fittings in copper piping and exposed to the soil, such as service tees, pressure control fittings, etc., be made of bronze, copper or brass.

Subpart D—Design of Pipeline Components

192.141 Scope .

This subpart prescribes minimum requirements for the design and installation of pipeline components and facilities. In addition, it prescribes requirements relating to protection against accidental overpressuring.

192.143 General Requirements.

Each component of a pipeline must be able to withstand operating pressures and other anticipated loadings with unit stresses equivalent to those allowed for comparable material in pipe in the same location and kind of service.

192.145 Valves.

(a) Each valve must meet the minimum requirements, or the equivalent, of API 6A, API 6D, MSS SP-70, MSS SP-71, or MSS SP-78, except that a valve designed before July 1, 1976, may meet the minimum

requirements of MSS SP-52. A valve may not be used under operating conditions that exceed the applicable pressure-temperature ratings contained in those standards.

(b) Each valve must be able to meet the anticipated operating conditions.

(c) No valve having shell components made of ductile iron may be used at pressures exceeding 80% of the pressure ratings for comparable steel valves at their listed temperature. However, a valve having shell components made of ductile iron may be used at pressures up to 80% of the pressure ratings for comparable steel valves at their listed temperature, if—

(1) The temperature-adjusted service pressure does not exceed 1,000 p.s.i.g.; and

(2) Welding is not used on any ductile iron component in the fabrication of the valve shells or their assembly.

(d) No valve having pressure containing parts made of ductile iron may be used in the gas pipe components of compressor stations.

192.147 Flanges and flange accessories.

(a) *General requirements.* Each flange or flange accessory must meet the minimum requirements of ANSI B16.5, MSS SP-44, or ANSI B16.24, or the equivalent.

(ii) Where a program for preventing interference with underground pipelines is established by law; or

(3) In the case of navigable waterway crossings, within 100 feet of a line marker placed and maintained at that waterway in accordance with this section.

(c) *Pipelines aboveground.* Line markers must be placed and maintained along each section of a main and transmission line that is located aboveground in an area accessible to the public.

(d) *Markers other than at navigable waterways.* The following must be written legibly on a background of sharply contrasting color on each line marker not placed at a navigable waterway.

(1) The word "Warning," "Caution," or "Danger" followed by the words "Gas (or name of gas transported) Pipeline" all of which, except for markers in heavily developed urban areas, must be in letters at least one inch high with one-quarter inch stroke.

(2) The name of the operator and the telephone number (including area code) where the operator can be reached at all times.

(e) *Markers at navigable waterways.* Each line marker at a navigable waterway must have the following characteristics:

(1) A sign, rectangular in shape, with a narrow strip along each edge colored international orange and the area between lettering on the sign and boundary strips colored white.

(2) Written on the sign in block style, black letters—

(i) The word "Warning," "Caution," or "Danger" followed by the words "Do Not Anchor or Dredge" and the words "Gas (or name of gas transported) Pipeline Crossing"; and

(ii) The name of the operator and the telephone number (including area code) where the operator can be reached at all times.

(3) In overcast daylight, the sign is visible and the writing required by paragraph (e) (2) (i) of this section is legible, from approaching or passing vessels that may damage or interfere with the pipeline.

(f) *Existing markers.* Line markers installed before April 21, 1975, which do not comply with paragraph (d) or (e) of this section may be used until January 1, 1980.

PSC 192.707

When transmission lines are located outside urban areas, their location shall be marked (recognizable to the public) at each fence line, road crossing, railroad crossing, river, lake, stream, or drainage ditch crossing and wherever it is considered necessary to identify the location of a pipeline to reduce the possibility of damage or interference.

192.709 Transmission lines: record-keeping.

Each operator shall keep records covering each leak discovered, repair made, transmission line break, leakage survey, line patrol, and inspection, for as long as the segment of transmission line involved remains in service.

192.711 Transmission lines: general requirements for repair procedures.

(a) Each operator shall take immediate temporary measures to protect the public whenever—

(1) A leak, imperfection, or damage that impairs its serviceability is found in a segment of steel transmission line operating at or above 40% of the SMYS; and

(2) It is not feasible to make a permanent repair at the time of discovery. As soon as feasible, the operator shall make permanent repairs.

(b) Except as provided in 192.717 (c), no operator may use a welded patch as a means of repair.

192.713 Transmission lines: permanent field repair of imperfections and damages.

(a) Except as provided in paragraph (b) of this section each imperfection or damage that impairs the serviceability of a segment of steel transmission line operating at or above 40% of SMYS must be repaired as follows:

(1) If it is feasible, to take the segment out of service, the imperfection or damage must be removed by cutting out a cylindrical piece of pipe and replacing it with pipe of similar or greater design strength.

(2) If it is not feasible to take the segment out of service, a full encirclement welded split sleeve of appropriate design must be applied over the imperfection or damage.

(3) If the segment is not taken out of service, the operating pressure must be reduced to a safe level during the repair operations.

(b) Submerged offshore pipelines and submerged pipelines in inland navigable waters may be repaired by mechanically applying a full encirclement split sleeve of appropriate design over the imperfection or damage.

PSC 192.713 (4) Gouges and grooves of lesser depth than 10% of the nominal wall thickness of the pipe may be removed by grinding out to a smooth contour provided the grinding does not reduce the remaining wall thickness to less than the minimum prescribed by this code for the conditions of use.

192.715 Transmission lines: permanent field repair of welds. Each weld that is unacceptable under 192.241 (c) must be repaired as follows:

(a) If it is feasible to take the segment of transmission line out of service, the weld must be repaired in accordance with the applicable requirements of 192.245.

(b) A weld may be repaired in accordance with 192.245 while the segment of transmission line is in service if—

(1) The weld is not leaking;

(2) The pressure in the segment is reduced so that it does not produce a stress that is more than 20% of the SMYS of the pipe; and

B. American Petroleum Institute (API), 1801 K Street NW, Washington, D.C. 20006, or 300 Corrigan Tower Building, Dallas, Texas, 75201.

C. The American Society of Mechanical Engineers (ASME) United Engineering Center, 345 East 47th Street, New York, N. Y. 10017.

D. American Society for Testing and Materials (ASTM), 1916 Race Street, Philadelphia, Pa. 19103.

E. Manufacturers Standardization Society of the Valve and Fittings Industry (MSS), 1815 North Fort Myer Drive, Room 913, Arlington, Va. 22209.

F. National Fire Protection Association (NFPA), 470 Atlantic Avenue, Boston, Mass. 02110.

II. Documents incorporated by reference. Numbers in parentheses indicate applicable editions. Only the latest listed edition applies, except that an earlier listed edition may be followed with respect to pipe or components which were manufactured, designed, or installed before the latest edition is adopted, unless otherwise provided in this part.

A. American Petroleum Institute:

(1) API Standard 5A "API Specifications for Casing, Tubing, and Drill Pipe" (1968, 1971, 1973 plus Supp. 1).

(2) API Standard 6A "API Specification for Wellhead Equipment" (1968, 1974).

(3) API Standard 6D "API Specification for Pipeline Valves" (1968, 1974).

(4) API Standard 5L "API Specification for Line Pipe" (1967, 1970, 1971 plus Supp. 1, 1973 plus Supp. 1, 1975).

(5) API Standard 5LS "API Specification for Spiral-Weld Line Pipe" (1967, 1970, 1971 plus Supp. 1, 1973 plus Supp. 1, 1975 plus Supp. 1).

(6) API Standard 5LX "API Specification for High-Test Line Pipe" (1967, 1970, 1971 plus Supp. 1, 1973 plus Supp. 1, 1975 and 1977).

(7) API Recommended Practice 5LI "API Recommended Practice for Railroad Transportation of Line Pipe" (1967, 1972).

(8) API Standard 1104 "Standard for Welding Pipe Lines and Related Facilities" (1968, 1973).

B. The American Society for Testing and Materials:

(1) ASTM Specification A53 "Standard Specification for Welded and Seamless Steel Pipe" (A53-65, A53-68, A53-73).

(2) ASTM Specification A72 "Standard Specification for Welded Wrought-Iron Pipe" (A72-64T, A72-68).

(3) ASTM Specification A106 "Standard Specification for Seamless Carbon Steel Pipe for High-Temperature Service" (A106-66, A106-68, A106-72a).

(4) ASTM Specification A134 "Standard Specification for Electric-Fusion (Arc)-Welded Steel Plate Pipe, Sizes 16 in. and over" (A134-64, A134-68, A134-73).

(5) ASTM Specification A135 "Standard Specification for Electric-Resistance-Welded Steel Pipe" (A135-63T, A135-68, A135-73a).

(6) ASTM Specification A139 "Standard Specification for Electric-Fusion (Arc)-Welded Steel Pipe (Sizes 4 in. and over)" (A139-64, A139-68, A139-73).

(7) ASTM Specification A155 "Standard Specification for Electric-Fusion-Welded Steel Pipe for High-Pressure Service" (A155-65, A155-68, A155-72a).

(8) ASTM Specification A211 "Standard Specification for Spiral-Welded Steel or Iron Pipe" (A211-63, A211-68, A211-73).

(9) ASTM Specification A333 "Standard Specification for Seamless and Welded Steel Pipe for Low Temperature Service" (A333-64, A333-67, A333-73).

(10) ASTM Specification A372 "Standard Specification for Carbon and Alloy Steel Forgings for Thin-Walled Pressure Vessel" (A372-67, A372-71).

(11) ASTM Specification A377 "Standard Specifications for Cast Iron and Ductile Iron Pressure Pipe" (A377-66, A377-73).

(12) ASTM Specification A381 "Standard Specification for Metal-Arc-Welded Steel Pipe for High-Pressure Transmission Systems" (A381-66, A381-68, A381-73).

(13) ASTM Specification A539 "Standard Specification for Electric Resistance-Welded Coiled Steel Tubing for Gas and Fuel Oil Lines" (A539-65, A539-73).

(14) ASTM Specification B42 "Standard Specification for Seamless Copper Pipe, Standard Sizes" (B42-62, B42-66, B42-72).

(15) ASTM Specification B68 "Standard Specification for Seamless Copper Tube, Bright Annealed" (B68-65, B68-68, B68-74).

(16) ASTM Specification B75 "Standard Specification for Seamless Copper Tube" (B75-65, B75-68, B75-74).

(17) ASTM Specification B88 "Standard Specification for Seamless Copper Water Tube" (B88-66, B88-72).

(18) ASTM Specification B251 "Standard Specification for General Requirements for Wrought Seamless Copper and Copper-Alloy Tube" (B251-66, B251-68, B251-72).

(19) ASTM Specification D2513 "Standard Specification for Thermoplastic Gas Pressure Pipe, Tubing, and Fittings" (D2513-66T, D2513-68, D2513-70, D2513-71, D2513-73, D2513-74a).

(20) ASTM Specification D2517 "Standard Specification for Reinforced Epoxy Resin Gas Pressure Pipe and Fittings" (D2517-66T, D2517-67, D2517-73).

C. The American National Standards Institute, Inc.:

(1) ANSI A21.1 "Thickness Design of Cast-Iron Pipe" (A21.1-1967, A21.1-1972).

(2) ANSI A21.3 "Specifications for Cast Iron Pit Cast Pipe for Gas" (A21.3-1953).

(3) ANSI A21.7 "Cast-Iron Pipe Centrifugally Cast in Metal Molds for Gas" (A21.7-1962).

(4) ANSI A21.9 "Cast-Iron Pipe Centrifugally Cast in Sand-Lined Molds for Gas" (A21.9-1962).

(5) ANSI A21.11 "Rubber-Gasket Joints for Cast-Iron and Ductile-Iron Pressure Pipe and Fittings" (A21.11-1964, A21.11-1972).

(6) ANSI A21.50 "Thickness Design of Ductile-Iron Pipe" (A21.50-1965, A21.50-1971).

(7) ANSI A21.52 "Ductile-Iron Pipe, Centrifugally Cast, in Metal Molds or Sand-Lined Molds for Gas" (A21.52-1965, A21.52-1971).

(8) ANSI B16.1 "Cast Iron Pipe Flanges and Flanged Fittings" (B16.1-1967).

(9) ANSI B16.5 "Steel Pipe Flanges, Flanged Valves and Fittings" (B16.5-1968, B16.5-1973).

(10) ANSI B16.24 "Bronze Flanges and Flanged Fittings" (B16.24-1962, B16.10-1971).

(11) ANSI B36.10 "Wrought Steel and Wrought Iron Pipe" (B36.10-1959, B36.10-1970).

(12) ANSI C1 "National Electrical Code" (C1-1968, C1-1975).

D. The American Society of Mechanical Engineers:

(1) ASME Boiler and Pressure Vessel Code Section VIII "Pressure Vessels, Division 1" (1968, 1974).

(2) ASME Boiler and Pressure Vessel Code, Section IX "Welding Qualifications" (1968, 1974).

E. Manufacturer's Standardization Society of the Valve and Fittings Industry:

(1) MSP-25 "Standard Marking System for Valves, Fittings, Flanges, and Union" (1964).

(2) MSS SP-44 "Steel Pipe Line Flanges" (1955, 1972, 1975).

(3) MSS SP-52 "Cast Iron Pipe Line Valves" (1957).

(4) MSS SP-70 "Cast Iron Gate Valves, Flanged and Threaded Ends" (1970).

(5) MSS Sp-71 "Cast Iron Swing Check Valves, Flanged and Threaded Ends" (1970).

(6) MSS Sp-78 "Cast Iron Plug Valves" (1972).

F. National Fire Protection Association:

(1) NFPA Standard 30 "Flammable and Combustible Liquids Code" (1969, 1973).

(2) NFPA Standard 58 "Standard for the Storage and Handling of Liquefied Petroleum Gases" (1969, 1972).

(3) NFPA Standard 59 "Standard for the Storage and Handling of Liquefied Petroleum Gases at Utility Gas Plants" (1968).

(4) NFPA Standard 59A "Storage and Handling Liquefied Natural Gas" (1971, 1972).

Appendix B—Qualification of Pipe

I. Listed Pipe Specifications. Numbers in parentheses indicate applicable editions. Only the latest listed edition applies, except that an earlier listed edition may be followed with respect to pipe or components which were manufactured, designed, or installed before the latest edition is adopted unless otherwise provided in this part.

API 5L—Steel and iron pipe (1967, 1970, 1971 plus Supp. 1, 1973 plus Supp. 1, 1975).

API 5LS—Steel pipe (1967, 1970, 1971 plus Supp. 1, 1973 plus Supp. 1, 1975 plus Supp. 1).

API 5LX—Steel pipe (1967, 1970, 1971 plus Supp. 1, 1973 plus Supp. 1, 1975 and 1977).

ASTM A53—Steel pipe (1965, 1968, 1973).

ASTM A72—Wrought Iron Pipe (1964T, 1968).

ASTM A106—Steel pipe (1966, 1968, 1972a).

ASTM A134—Steel pipe (1964, 1968, 1973).

ASTM A135—Steel pipe (1963T, 1968, 1973a).

ASTM A139—Steel pipe (1964, 1968, 1973).

ASTM A155—Steel pipe (1965, 1968, 1972a).

ASTM A211—Steel and iron pipe (1963, 1968, 1973).

ASTM A333—Steel pipe (1964, 1967, 1973).

ASTM A377—Cast iron pipe (1966, 1973).

ASTM A381—Steel pipe (1966, 1968, 1973).

ASTM A539—Steel tubing (1965, 1973).

ASTM B42—Copper pipe (1962, 1966, 1972).

ASTM B68—Copper tubing (1965, 1968, 1974).

ASTM B75—Copper tubing (1965, 1968, 1974).

ASTM B88—Copper tubing (1966, 1972).

ASTM B251—Copper pipe and tubing (1966, 1968, 1972).

ASTM D2513—Thermoplastic pipe and tubing (1966T, 1968, 1970, 1971, 1973, 1974a).

ASTM D2517—Thermosetting plastic pipe and tubing (1966T, 1967, 1973).

ANSI A21.3—Cast iron pipe (1953).

ANSI A21.7—Cast iron pipe (1962).

ANSI A21.9—Cast iron pipe (1962).

ANSI A21.52—Ductile iron pipe (1965, 1971).

II. Steel pipe of unknown or unlisted specification.

A. Bending Properties. For pipe 2 inches or less in diameter, a length of pipe must be cold bent through at least 90 degrees around a cylindrical mandrel that has a diameter 12 times the diameter of the pipe, without developing cracks at any portion and without opening the longitudinal weld.

For pipe more than 2 inches in diameter, the pipe must meet the requirements of the flattening test set forth in ASTM A53, except that the number of tests must be at least equal to the minimum required in paragraph II-D of this appendix to determine yield strength.

B. Weldability. A girth weld must be made in the pipe by a welder who is qualified under Subpart E of this part. The weld must be made under the most severe conditions which welding will be allowed in the field and by means of the same procedure that will be used in the field. On pipe more than 4 inches in diameter, at least one test weld must be made for each 100 lengths of pipe. On pipe 4 inches or less in diameter, at least one test weld must be made for each 400 lengths of pipe. The weld must be tested in accordance with API Standard 1104. If the requirements of API Standard 1104 cannot be met, weldability may be established by making chemical tests for carbon and manganese, and proceeding in accordance with section IX of the ASME Boiler and Pressure Vessel Code. The same number of chemical tests must be made as are required for testing a girth weld.

C. Inspection. The pipe must be clean enough to permit adequate inspection. It must be visually inspected to ensure that it is reasonably round and straight and there are no defects which might impair the strength or tightness of the pipe.

D. Tensile Properties. If the tensile properties of the pipe are not known, the minimum yield strength may be taken as 24,000 p.s.i.g. or less, or the tensile properties may be established by performing tensile tests as set forth in API Standard 5LX. All test specimens shall be selected at random and the following number of tests must be performed:

Number of Tensile Tests—All Sizes

10 lengths or less—1 set of tests for each length.

11 to 100 lengths—1 set of tests for each 5 lengths, but not less than 10 tests.

Over 100 lengths—1 set of tests for each 10 lengths, but not less than 20 tests.

If the yield-tensile ratio, based on the properties determined by those tests, exceeds 0.85, the pipe may be used only as provided in 192.55 (c).

III. *Steel pipe manufactured before November 12, 1970, to earlier editions of listed specifications.* Steel pipe manufactured before November 12, 1970, in accordance with a specification of which a later edition is listed in section I of this appendix, is qualified for use under this part if the following requirements are met:

A. *Inspection.* The pipe must be clean enough to permit adequate inspection. It must be visually inspected to ensure that it is reasonably round and straight and that there are no defects which might impair the strength or tightness of the pipe.

B. *Similarity of specification requirements.* The edition of the listed specification under which the pipe was manufactured must have substantially the same requirements with respect to the following properties as a later edition of that specification listed in section I of this appendix:

(1) Physical (mechanical) properties of pipe, including yield and tensile strength, elongation, and yield to tensile ratio, and testing requirements to verify those properties.

(2) Chemical properties of pipe and testing requirements to verify those properties.

C. *Inspection or test of welded pipe.* On pipe with welded seams, one of the following requirements must be met:

(1) The edition of the listed specification to which the pipe was manufactured must have substantially the same requirements with respect to nondestructive inspection of welded seams and the standards for acceptance or rejection and repair as a later edition of the specification listed in section I of this appendix.

(2) The pipe must be tested in accordance with Subpart J of this part to at least 1.25 times the maximum allowable operating pressure if it is to be installed in a class 1 location and to at least 1.5 times the maximum allowable operating pressure if it is to be installed in a class 2, 3, or 4 location. Notwithstanding any shorter time period permitted under Subpart J of this part, the test pressure must be maintained for at least 8 hours.

APPENDIX C—QUALIFICATION FOR WELDERS OF LOW STRESS LEVEL PIPE

I. *Basic test.* The test is made on pipe 12 inches or less in diameter. The test weld must be made with the pipe in a horizontal fixed position so that the test weld includes at least one section of overhead position welding. The beveling, root opening, and other details must conform to the specifications of the procedure under which the welder is being qualified. Upon completion, the test weld is cut into four coupons and subjected to a root bend test. If, as a result of this test, two or more of the four coupons develop a crack in the weld material, or between the weld material and base metal, that is more than 1/8-inch long in any direction, the weld is unacceptable. Cracks that occur on the corner of the specimen during testing are not considered.

II. *Additional tests for welders of service line connections to mains.* A service line connection fitting is welded to a pipe section with the same diameter as a typical main. The weld is made in the same position as it is

made in the field. The weld is unacceptable if it shows a serious undercutting or if it has rolled edges. The weld is tested by attempting to break the fitting off the run pipe. The weld is unacceptable if it breaks and shows incomplete fusion, overlap, or poor penetration at the junction of the fittings and run pipe.

III. *Periodic tests for welders of small service lines.* Two samples of the welder's work each about 8 inches long with the weld located approximately in the center, are cut from steel service line and tested as follows:

(1) One sample is centered in a guided bend testing machine and bent to the contour of the die for a distance of 2 inches on each side of the weld. If the sample shows any breaks or cracks after removal from the bending machine, it is unacceptable.

(2) The ends of the second sample are flattened and the entire joint subjected to a tensile strength test. If failure occurs adjacent to or in the weld metal, the weld is unacceptable. If a tensile strength testing machine is not available, this sample must also pass the bending test prescribed in subparagraph (1) of this paragraph.

APPENDIX D—CRITERIA FOR CATHODIC PROTECTION AND DETERMINATION OF MEASUREMENTS

I. *Criteria for cathodic protection—A. Steel, cast iron, and ductile iron structures.*

(1) A negative (cathodic) voltage of at least 0.85 volt, with reference to a saturated copper-copper sulfate half cell. Determination of this voltage must be made with the protective current applied, and in accordance with sections II and IV of this appendix.

(2) A negative (cathodic) voltage shift of at least 300 millivolts. Determination of this voltage shift must be made with the protective current applied, and in accordance with sections II and IV of this appendix. This criterion of voltage shift applies to structures not in contact with metals of different anodic potentials.

(3) A minimum negative (cathodic) polarization voltage shift of 100 millivolts. This polarization voltage shift must be determined in accordance with sections III and IV of this appendix.

(4) A voltage at least as negative (cathodic) as that originally established at the beginning of the Tafel segment of the E-log-I curve. This voltage must be measured in accordance with section IV of this appendix.

(5) A net protective current from the electrolyte into the structure surface as measured by an earth current technique applied at predetermined current discharge (anodic) points of the structure.

B. *Aluminum structures.* (1) Except as provided in subparagraph (3) and (4) of this paragraph, a minimum negative (cathodic) voltage shift of 150 millivolts, produced by the application of protective current. The voltage shift must be determined in accordance with sections II and IV of this appendix.

(2) Except as provided in subparagraphs (3) and (4) of this paragraph, a minimum negative (cathodic) polarization voltage shift of 100

millivolts. This polarization voltage shift must be determined in accordance with sections III and IV of this appendix.

(3) Notwithstanding the alternative minimum criteria in subparagraphs (1) and (2) of this paragraph, aluminum, if cathodically protected at voltages in excess of 1.20 volts as measured with reference to a copper-copper sulfate half cell, in accordance with section IV of this appendix, and compensated for the voltage (IR) drops other than those across the structure-electrolyte boundary, may suffer corrosion resulting from the buildup of alkali on the metal surface. A voltage in excess of 1.20 volts may not be used unless previous test results indicate no appreciable corrosion will occur in the particular environment.

(4) Since aluminum may suffer from corrosion under high pH conditions, and since application of the cathodic protection tends to increase the pH at the metal surface, careful investigation or testing must be made before applying cathodic protection to stop pitting attack on aluminum structures in environments with a natural pH in excess of 8.

C. Copper structures. A minimum negative (cathodic) polarization voltage shift of 100 millivolts. This polarization voltage shift must be determined in accordance with sections III and IV of this appendix.

D. Metals of different anodic potentials. A negative (cathodic) voltage, measured in accordance with section IV of this appendix, equal to that required for the most anodic metal in the system must be maintained. If amphoteric structures are involved that could be damaged by high alkalinity covered by subparagraphs (3) and (4) of paragraph B of this section, they must be electrically isolated with insulating flanges, or the equivalent.

II. Interpretation of voltage measurement. Voltage (IR) drops other than those across the structure-electrolyte boundary must be considered for valid interpretation of the voltage measurement in paragraph A (1) and (2) and paragraph B (1) of section I of this appendix.

III. Determination of polarization voltage shift. The polarization voltage shift must be determined by interrupting the protective current and measuring the polarization decay. When the current is initially interrupted, an immediate voltage shift occurs. The voltage reading after the immediate shift must be used as the base reading from which to measure polarization decay in paragraphs A (3), B (2), and C of section I of this appendix.

IV. Reference half cells. A. Except as provided in paragraphs B and C of this section, negative (cathodic) voltage must be measured between the structure surface and a saturated copper-copper sulfate half cell contacting the electrolyte.

B. Other standard reference half cells may be substituted for the saturated copper-copper sulfate half cell. Two commonly used reference half cells are listed below along with their voltage equivalent to -0.85 volt as referred to a saturated copper-copper sulfate half cell:

- (1) Saturated KCl calomel half cell: -0.78 volt.
- (2) Silver-silver chloride half cell used in sea water: -0.80 volt.

C. In addition to the standard reference half cells, an alternate metallic material or structure may be used in place of the saturated copper-

copper sulfate half cell if its potential stability is assured and if its voltage equivalent referred to a saturated copper-copper sulfate half cell is established.

History: Cr. Register, May, 1972, No. 197, eff. 6-1-72; cr. 192.12, 192.379, appendix A-II F 4; am. 192.201 (a), 192.625 (g) (1), 192.717 (b), 192.727, Register, February, 1973, No. 206, eff. 3-1-73; am. PSC 192.457 (d), PSC 192.613 (c) (1), Register, June, 1974, No. 222, eff. 7-1-74; am. 192.3, 192.55 (a) (2) and (b) (2), 192.65, 192.197 (a), 192.625 (g) (1), appendix A-I, B, and II A, 1., 2., 3., and 5., appendix B, I, cr. appendix B, III, Register, December, 1974, No. 228, eff. 1-1-76; am. 192.59 (a) (1), (b) (1) and cr. (c), am. 192.65 (a), 192.225 (a), 192.227 (a) (2), 192.229 (c), 192.241 (c), 192.625 (a) and (b), 192.625 (g) (1), 192.705 (a) and (b), r. 192.705 (c), cr. 192.706, am. 192.707, appendix A II and appendix B I, Register, March, 1976, No. 243, eff. 4-1-76; am. 192.13 (2), 192.313 (a) (4), 192.455 (f), 192.619 (a) (2) (ii), 192.707 (d) (1) and (e) (2) (i), cr. 192.14, 192.452 and 192.455 (f), Register, May, 1978, No. 269, eff. 6-1-78.