

SECTION 15060

PIPE, MANUAL VALVES, AND FITTINGS, FUELING SYSTEM

(Omaha Spec 11/98)

**(Waiver to Use MilStds and MilSpecs in Air
Force Fuel Projects,
HQ AFCESA/CESM (01/29/96))**

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3.1 WELDING

3.1.1 General

All joints unless indicated otherwise, in carbon steel and stainless steel piping systems shall be welded. Unless otherwise approved, all girth welds shall be complete penetration groove welds made in accordance with qualified welding procedures. Welding operations, qualifications of welders and welding procedures shall comply with the provisions of \-ASME B31.3-\ and the requirements specified herein. The root pass on stainless steel and carbon steel pipe shall be by the GMAW or GTAW process. During the root pass welding procedure, the weld surface on the pipe interior shall be shielded with an inert shielding or backing gas supplied from an externally supplied gas or gas mixture (not from flux-coated or cored welding rod). The use of flux-coated or cored welding rod is prohibited in making the root pass.

a. Definitions shall be in accordance with \-
AWS..."

0.1.2 Qualifications of Welders

Welders and welding procedures shall be qualified in accordance

3.2 INSTALLATION

3.2.1 Precautions

"Special care shall be taken by the Contractor to insure that the protective coating on buried pipe is not damaged during installation and that the completed system is free of rocks, sand, dirt, water, welding slag, and foreign objects including construction debris."