§ 154.660 Pipe welding.

(a) Pipe welding must meet Part 57 of this chapter.

(b) Longitudinal butt welds, in piping that does not meet a standard or specification under § 56.60–1 of this chapter, and girth butt welds must meet the following:

(1) Butt welds of pipes made from carbon, carbon manganese, or low alloy steels must meet § 56.50–105 of this chapter, including the requirements for post-weld heat treatment.

(2) Except for piping inside an independent cargo tank type A, B, or C, butt welds must be 100% radiographically tested if the design temperature is lower than −10 °C (14 °F), and:

(i) The wall thickness is greater than 10 mm (0.394 in.); or

(ii) The wall thickness is greater than 10 mm (0.394 in.); or