

## PROCEDURES

### THREADED JOINTS ON STEEL PIPE

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#### 8.0 PURPOSE

This section presents the procedure for fabricating gas tight threaded connections that will sustain the longitudinal pullout or thrust forces caused by contraction or expansion of the piping or by anticipated external or internal loading.

Each threaded joint shall be made in accordance with this procedure.

#### 8.1 GENERAL

Threaded joints are intended for above ground installations and **shall not** be buried.

#### 8.2 PROCEDURE

All threaded pipe and fittings purchased or fabricated for utilization on the Operator's pipeline facilities shall use the American National Standard Thread (NPT).

- A. Maximum size for pipe and associated fittings to be joined using the threaded procedure shall be 4".
- B. Pipe and fitting threads shall be inspected prior to assembly for gouges, nicks, missing or malformed threads, or any other defect that would affect the integrity of the joint.
- C. Pipe thread sealant shall be of an approved type. It shall be applied to the male threads only on pipe sizes up to and including 1½" and to both the male and female threads for pipe sizes larger than 1½". Care must be taken to avoid getting excess sealant inside the pipeline at all times.
- D. After inspecting and applying sealant to the pipe threads, the joint shall be made up wrench tight to produce a gas tight seal.
- E. Prefabricated facilities should incorporate at least one flanged fitting, or union to accommodate future work on the facility. (Only above ground facilities)
- F. Test the completed joint in accordance with **Section H-3**.