

3040 - Qualifying Persons to Join Plastic

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1. GENERAL

1. Each Company employee or contractor's employee who is engaged in joining plastic pipe by fusion or mechanical fittings must be qualified to join plastic pipe. The individuals must be able to make acceptable specimen joints following approved joining procedures for the kind of plastic pipe and type of joints being used. The specimen joints must be inspected and tested in accordance with procedures found in this section on plastic pipe. Appropriate training or experience in the use of these procedures is required.
2. Approved joining procedures must be qualified by the manufacturer of the pipe and fittings or qualified by Company tests in accordance with Pipeline Safety Regulations.

2. INSPECTION

1. The joining process must be observed by a qualified evaluator to assure that the individual followed the correct procedure and all completed joints must be visually inspected to assure that the joint appearance meets the manufacturer's requirements for an acceptable joint.

3. BASIC TEST FOR INITIAL QUALIFICATION

1. Persons being initially qualified shall pass a written exam and make specimen joints in the presence of a qualified instructor/evaluator for each of the following joining methods:

4. RE-QUALIFICATION

1. All persons being requalified shall successfully make specimen joints in the presence of a qualified instructor/evaluator for each joining method used.
2. All plastic pipe joiners must be requalified each 12 months.
3. The testing can be done in the field or in the shop by a qualified evaluator.
4. Written test is not required for requalification.

5. DISQUALIFICATION

1. If a joiner does not follow written procedures when making a joint, the joiner will be disqualified.
2. If a joiner leaves a joint that is found by an inspector to have an unacceptable appearance, the joiner will be disqualified.
3. If a joiner leaves a joint that subsequently fails during a pressure test, the joiner will be disqualified.
4. If a joiner leaves a joint that fails after the line is activated, the joiner will be disqualified.

Note: If necessary, a joiner may cut out bad joints if they are identified during the joining process.

5. A disqualified joiner must pass the initial qualification requirements before being allowed to join plastic pipe again.
6. If a joiner is disqualified more than once in any 12-month period, the joiner will not be allowed to join plastic for at least 6 months.
7. If an individual is disqualified, the Gas Training and Employee Development Department must be contacted in order to coordinate and/or schedule a re-evaluation.

6. HEAT FUSION & ELECTROFUSION SPECIMEN JOINTS

1. All heat fusion and electrofusion specimen joints must be visually examined by a qualified evaluator during and after joining to ensure that the proper procedures are followed and to ensure that the joints have an acceptable appearance.
2. During initial qualifications, or re-qualifications due to disqualification, specimen fusion joints will be destructively tested. Each specimen fusion joint should be cut into three longitudinal straps. Each strap should be cut so that at least 8" of pipe remains on each side of the joint. Each strap should be approximately 1" or less in width. Each strap must be:
 1. Visually examined and found not to contain voids or discontinuities on the cut surfaces of the joint area, and
 2. Deformed by bending to ensure that no separation occurs in the joint area. Specimens should be bent into a U-shape toward the inside of the pipe. Specimen joints should be allowed to cool for at least one hour before subjecting them to a bend test.

3. During annual re-qualifications, specimen fusion joints do not have to be destructively tested provide the correct joining procedures were followed and the completed joint is visually inspected to assure that the joint appearance meets the manufacturer's requirements for an acceptable joint.

7. MECHANICAL SPECIMEN JOINTS

1. All mechanical specimen joints must be visually examined by a qualified evaluator during and after joining to ensure that the proper procedures are followed and to ensure that the joint has an acceptable appearance.
2. Mechanical specimen joints can be made with specially manufactured practice fittings if available.
3. Mechanical specimen joints do not have to be destructively tested.

8. APPROVED JOINING PROCEDURES

1. A copy of each applicable joining procedure must be available to persons making and inspecting joints in plastic pipe.

9. RECORDS

1. Records will be maintained for each person qualified to join plastic pipe. Evaluators should complete a Qualification Record for Joining Plastic Pipelines each time an individual is qualified or requalified. These records should be forwarded to the Gas Training and Employee Development Department and entered in the Employee Training Database.

10. INSTRUCTOR / EVALUATOR QUALIFICATION

1. Each instructor/evaluator will be trained by the pipe or fitting manufacturer. Records of this training should be forwarded to the Gas Training and Employee Development Department and entered in the Employee Training Database. A change in the pipe and/or fitting manufacturer will necessitate re-training.

FORMS AND REFERENCES [PDF files]

- [DI 3040 - Qualification Record](#)

(UNCONTROLLED IF PRINTED)