

NAVSEA  
STANDARD ITEM

FY-11

ITEM NO: 009-71  
DATE: 24 JUL 2009  
CATEGORY: II

1. SCOPE:

1.1 Title: Testing Requirements for Piping Systems; accomplish

2. REFERENCES:

2.1 S9086-RK-STM-010/CH-505, Piping Systems

2.2 S9086-RJ-STM-010/CH-504, Pressure, Temperature and Other Mechanical and Electromechanical Measuring Instruments

2.3 S9074-AR-GIB-010/278, Requirements for Fabrication Welding and Inspection, and Casting Inspection and Repair for Machinery, Piping, and Pressure Vessels

2.4 T9074-AS-GIB-010/271, Requirements for Nondestructive Testing Methods

2.5 MIL-STD-2035, Nondestructive Testing Acceptance Criteria

3. REQUIREMENTS:

3.1 Accomplish testing of new and disturbed piping systems in accordance with 2.1.

(V) "GAGE CHECK"

3.1.1 Each master and backup test gage shall conform to gage range and graduation shown on Table 504-6-1 of 2.2. The backup gage shall be cross-checked to the master hydrostatic test gage up to the maximum test pressure just prior to start of testing. Master and backup gages shall track within 2 percent of each other.

3.1.1.1 Each master and backup test gage used for vacuum testing shall consist of 2 compound gages with a 30 inch-0-30 PSI range.

(I)(G) "LIQUID PENETRANT INSPECTION" or "MAGNETIC PARTICLE INSPECTION"

3.1.2 Accomplish liquid penetrant or magnetic particle test on root layer of all P-1 and/or P-LT welded joints in accordance with Paragraph

505-11.1.2.6.a(1) of 2.1, and the requirements of 2.3 and 2.4. The accept or reject criteria shall be in accordance with Class One of 2.5.

(I)(G) "LIQUID PENETRANT INSPECTION"

3.1.3 Accomplish liquid penetrant tests on final layer of all P-1 and/or P-LT welded joints in accordance with Paragraph 505-11.1.2.6.a(1) of 2.1, and P-2 welded joints in accordance with Paragraph 505-11.1.2.6.a(2) of 2.1 for operating conditions greater than 200 degrees Fahrenheit or 200 PSIG, and the requirements of 2.3 and 2.4. The accept or reject criteria shall be in accordance with Class One of 2.5 for P-1 and/or P-LT, and Class 2 of 2.5 for P-2.

(V)(G) or (I)(G) "VISUAL INSPECTION - SHOP TEST" (See 4.2)

3.1.4 Accomplish a shop hydrostatic test of replacement piping, fittings, and components for evidence of external leakage and/or deformation. Allowable external leakage and/or deformation: None.

(V)(G) or (I)(G) "VISUAL INSPECTION - HYDROSTATIC, LOW PRESSURE AIR, VACUUM, OR OPERATING PRESSURE TEST" (See 4.2)

3.1.5 Visually inspect the pressurized system or system under vacuum for evidence of external leakage and/or deformation. Allowable external leakage and/or deformation: None.

3.1.5.1 Joints requiring inspection shall remain uninsulated and unpainted until completion of successful inspection.

3.1.5.2 Provide a sketch of that portion of the system to be tested, showing the location of blanks, isolation valves, test connection, and the location of air vents to vent air. Sketch shall be on the test site during the accomplishment of the test.

(I) "STATIC TEST"

3.2 Accomplish a static head pressure test of new and disturbed gravity drain piping (unpressurized piping), using clean, fresh water for a minimum of 30 minutes. Allowable leakage: None.

(V)(G) "OPERATIONAL TEST"

3.3 Accomplish an operational test of new and disturbed gravity drain piping for proper operation and unobstructed flow.

(V)(G) "OPERATIONAL TEST"

3.4 Accomplish an operational test of new and disturbed sounding tube piping by inserting a 16-inch theft sampler into sounding tube until it bottoms. Accomplish the test a minimum of 4 times for each sounding tube. There shall be no binding or sticking of sampler during this test.

4. NOTES:

4.1 Boiler pressure vessel piping is defined as, "The piping from the pressure vessel drum or header up to the first valve off the pressure vessel drum or header."

4.2 The paragraph referencing this note is considered an (I)(G) if the system is P-1, P-LT, or P-3a. If the system is P-2 or P-3b, then the paragraph is considered (V)(G).

4.3 Test pressure and test medium will be specified in invoking Work Item.