

**2011 South Dakota Pipeline Safety Inspection**

**Summary of Deficiencies**

**Operator: NorthWestern Energy**

**Inspection Types: Pipeline Construction Inspection – Aberdeen Peaking Plant and Beef Processing Plan Pipeline**

**Inspection Dates: October 31 – November 1, 2011**

**Notices of Probable Violation**

Code Section	Code Description	Deficiency Noted	Proposed Correction Due Date	Penalty Proposed	Maximum Allowable Penalty	Compliance Order Proposed
§192.225 a	(a) Welding must be performed by a qualified welder in accordance with welding procedures qualified under section 5 of API 1104 (incorporated by reference, see §192.7) or section IX of the ASME Boiler and Pressure Vessel Code "Welding and Brazing Qualifications" (incorporated by reference, see §192.7) to produce welds meeting the requirements of this subpart. The quality of the test welds used to qualify welding procedures shall be determined by destructive testing in accordance with the applicable welding standard(s).	When inspector arrived to observe welders in the early pm of October 31, the inspector observed that the hot pass welder did not complete his pass within 5 minutes of the root pass per welding procedure GTS-WPS-BW3 in use. Concerned that this may have been due to crew stopping to introduce themselves to the inspector, the inspector inquired and learned this may have happening regularly. Welding temperatures were taken to ensure that the weld was still warm (temp was 236, above the preheat level of 200). Although the weld was fine, welders must follow procedure regardless of potential interruptions. This contractor was observed violating this same procedure in 2007 although it was a different welder. Operator must develop a method to ensure contractor welders follow welding procedures.	2-29-12	\$2,000.00	\$10,000/\$500,000	No

**Warnings**

Code Section	Code Description	Deficiency Noted	Warning	Proposed Correction Due Date
		None		

**Notices of Concern**

Code Section	Code Description	Comment
		None

DATE: Oct 31 - Nov 1, 2011 STATE INSPECTOR Nathan Solem

**Surveillance Program - Pipeline Construction**

Company NorthWestern Energy Location/Project Aberdeen peaking plant and beef processing plant gas pipeline. This 6.25 mile pipeline on the south side of Aberdeen runs from a NorthWestern town border station northwest to an electricity generating facility under construction and to a new beef processing plant.

Construction Done By: Company \_\_\_\_\_ Contractor Name Distribution Construction Company

Company Contact Mark Hallenbeck Telephone No. 605-228-6206

Contractor Contact Brian Alderings Telephone No. 605-354-5244

Transmission  Distribution  Steel  Plastic

NorthWestern is planning to classify this line as distribution but the SDPUC believes this is a transmission line. SDPUC Staff filed a petition for a declaratory ruling on the classification of this pipeline.

Class Location 1.  2.  3.  4.

Location of Section Inspected (Survey Station, etc.) Miles 5 & 6 closest to the TBS were inspected. Remaining sections had been completed.

Proposed Min. Test Pressure 4,395 Expected Operating Pressure 879 MAOP

Test Medium Water Duration of Pressure Test TBD

Pipe: Dia. 6" Wall .280" Grade X52 MAOP 879, < 20 % SMYS

Pipe Data: fusion bonded epoxy coating. Field wall thickness checks using UTG showed readings from: Weld 123 - .282, Weld 124 - .284, Weld 125 - .286, Weld 120 - .282

Soil Conditions damp Ditch Depth (Top of Pipe) 42"

Installation Method: Trenched: X; Plowed: \_\_\_\_\_; Directional Drill: X (under all crossings);

Was Rock Shield Used No, few rocks present Type of Padding Used \_\_\_\_\_

Condition of Coating good, few holidays found Type of Coating FBE, 14-16 mil

Was Holiday Detector Used  Yes  No

Gouges, Grooves, Dents None observed

Type of Bend \_\_\_\_\_ Wrinkle \_\_\_\_\_ Miter \_\_\_\_\_

Were Welds X-Rayed Yes Percent X-Rayed Mile 2 and half of Mile 3 not x-rayed, then a percentage of bores were x-rayed , then upgraded to 100 % x-ray.

Proposed Cathodic Protection Galvanic protection – no stations were reviewed during the inspection

Issues: When inspector arrived to observe welders in the early pm of October 31, the inspector observed that the hot pass welder did not complete his pass within 5 minutes of the root pass per welding procedure GTS-WPS-BW3 in use. Concerned that this may have been due to crew stopping to introduce themselves to the inspector, the inspector inquired and learned this may have happening regularly. Welding temperatures were taken to ensure that the weld was still warm (temp was 236, above the preheat level of 200). Although the weld was fine, welders must follow procedure regardless of potential interruptions. This contractor was observed violating this same procedure in 2007 although it was a different welder. Operator must develop a method to ensure contractor welders follow welding procedures.

NAME OF INDIVIDUALS ON CREW	TASK DESCRIPTION	DATE QUALIFIED (Fusers and Welders)
Lonnie Mundt	Welder	API 1104 8/31/11
Neil Heit	Welder	API 1104 8/31/11
Fred Alvarez	Field coating	

James Campbell	Field coating	
Brian Alderings	Foreman	

**Sketch of Construction Location**

**Weather Conditions Oct 31 1:30 pm**

Temperature: 63

Wind: 11.7 mph

Precipitation: none

Other Notable Conditions: \_\_\_\_\_

**Weather Conditions Nov 1 8 am**

Temperature: 46.3

Wind: 3.5 mph

Precipitation: none

Other Notable Conditions: \_\_\_\_\_