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TECHNICAL SPECIFICATION

Doc No: DSF-SPC-CPR-004

Rev. 1

Page 1 of 7

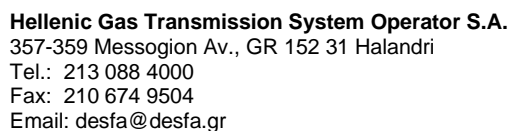
HIGH PRESSURE (HP) TRANSMISSION SYSTEMS

ELECTRICAL RESISTANCE WELDING “PIN-BRAZING”

JUNE 2021

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Doc No: DSF-SPC-CPR-004

Rev. 1

Page 2 of 7

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Page 3 of 7

Table Of Contents

1	SCOPE AND OBJECTIVES.....	4
2	REFERENCES	4
3	ACRONYMS	4
4	GENERAL.....	4
5	DRYING.....	5
6	WELDING TOOLS AND MATERIALS.....	5
7	CLEANING OF WELDING AREA	5
8	WELDING PERFORMANCE	6
9	INSULATION AND CORROSION PROTECTION	6

	Hellenic Gas Transmission System Operator S.A. 357-359 Messogion Av., GR 152 31 Halandri Tel.: 213 088 4000 Fax: 210 674 9504 Email: desfa@desfa.gr	TECHNICAL SPECIFICATION
Doc No: DSF-SPC-CPR-004	Rev. 1	Page 4 of 7

1. SCOPE AND OBJECTIVES

This Specification covers the minimum requirements to be considered for the Electrical Resistance Welding "Pin-Brazing".

2. REFERENCES

2.1 Reference Documents

- DSF-SPC-PIP-013: Corrosion Protection of Field Joints and Uncoated Pipeline Components.
- DSF-SPC-CPR-005: Installation of Cathodic Protection System.

2.2 Reference Codes and Standards

- EN 12954: General principles of cathodic protection of buried or immersed onshore metallic structures.
- ISO 15589-1: Petroleum, petrochemical and natural gas industries — Cathodic protection of pipeline systems — Part 1: On-land pipelines.
- EN 12068: Cathodic protection - External organic coatings for the corrosion protection of buried or immersed steel pipelines used in conjunction with cathodic protection, tapes and shrinkable materials.

3. ACRONYMS

CP	Cathodic Protection.
EN	European Norms.
ELOT	Hellenic Organization for Standardization.
T/R	Transformer Rectifier.

4. GENERAL

Connections shall be performed by "Pin-Brazing" or similar methods, approved by Supervision. "CAD WELD" welding will not be accepted.

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Doc No: DSF-SPC-CPR-004	Rev. 1	Page 5 of 7	

"Pin-Brazing" shall only be carried out by personnel skilled and experienced in such welding methods.

The Contractor shall submit a detailed procedure specification complying with this specification, for approval by Supervision, before any Pin-Brazing is carried out.

The welding procedure shall be qualified by visual examination and mechanically tested on two brazing with 2 hard blows on the side of the brazing by hammer and chisel. Detailed testing for the qualification of pin brazing is described in DNVGL-ST-F101.

If defects are found on finished welds, Contractor shall repair the defect and pay all resulting expenses, including re-insulation, excavation work, etc. Pin-Brazing can be performed even after the hydraulic test as the temperature during the Pin-Brazing is lower than 700°C.

5. DRYING

The area where the Pin-Brazing shall be carried out shall be dry. Heating to remove humidity shall be carried out in certain cases.

After construction, "Pin-Brazing" may, under any circumstance, not be exposed to heat influences above 100°C e.g. during a subsequent application of hot-applied insulating coating.

6. WELDING TOOLS AND MATERIALS

Contractor shall ensure that only equipment and material, correctly sized for the work, are used.

7. CLEANING OF WELDING AREA

"Pin-Brazing" shall be placed at least 100 mm from other welds.

Removal of 150 mm x 50 mm coating area from the top of the pipe, radius of all corners being not less than 5 mm.

Removal of all polyethylene and polymer coatings should be carried out by a rasp, ensuring that the surrounding insulating coating is not lifted or damaged.

Removal of the pipeline primer epoxy coating is achieved by a light grinding, using a grinder included in the Pin-Brazing equipment kit.

The cleaned area shall have a smooth ellipsoid shape.

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Doc No: DSF-SPC-CPR-004	Rev. 1	Page 6 of 7	

Great care should be taken so as not to produce any cuts or grooves on the surrounding insulation.

The edges of the surrounding insulation shall be beveled with a half round rasp.

In case of a cable conductor having 2,5 or 4,0 or 6,0 mm² cores, a copper sleeve will be required over the cable cores.

Each conductor end together with the special adaptable copper sleeve, shall be inserted to the "Pin-Brazing" lug.

The "Pin-Brazing" lug shall be crimped in two places with special compression tool. A single 2.5 mm² conductor shall be crimped:

- in one place only by using one copper sleeve.
- or in two places by using two copper sleeves.

For cable connections with the pipe for the various types of cables see the relevant standard drawing.

8. WELDING PERFORMANCE

The instructions, from the Supplier of welding materials and tools, shall be strictly followed.

The size of the brazing pins and the ferrules shall be in accordance with the Supplier's instructions, taking into consideration the size of the sleeves.


After termination of the brazing, the top shall be removed and the strength of the brazing shall be tested by hammering lightly on the side of the brazing. The electrical continuity shall be checked with the use of an Ohmmeter.

9. INSULATION AND CORROSION PROTECTION

The welding area shall be insulated as described in Technical Specification DSF-SPC-PIP-013, for cold applied use.

Cable lugs, welding area of the pipeline cable connection and open spaces of the pipeline should be coated with an initial insulating layer, in this case primer is used.

Then a layer of mastic is applied over the area of welds. The layer of mastic applied should be heated by a gas torch at low ambient temperature.

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Doc No: DSF-SPC-CPR-004	Rev. 1	Page 7 of 7

Finally, the welding areas of the pipeline cable connection should be insulated and protected against corrosion by adhesion of an e.g. Kebutyl Duplex Binde.

Cable outlets should be sized by a special Reparature Tape.

Stripes of Reparature Tape are used in fastenings of the cables to the pipe.

The coating shall also cover the first section of the insulated cable. It is of the utmost importance that an absolute adhesion is achieved between the reincapsulation material and the pipe coating.

The completed insulation shall be controlled with a detector as described in Technical Specification DSF-SPC-PIP-013.

Note: The insulating material shall be compatible with the specified 3 Layer PE coating.