

Qualified and approved procedures shall be adhered to during construction. If CONTRACTOR proposes a change in essential variables requiring a new procedure, the new procedure must be qualified and approved. In the event COMPANY rejects a procedure during the course of the work, CONTRACTOR shall immediately cease production welding per that procedure until the rejected procedure is remedied and replaced by a new qualified and approved procedure.

#### 8.1.6 Costs of Procedure

Costs of procedure qualifications and testing shall be at CONTRACTOR'S expense, except COMPANY will provide line pipe for test qualifications.

### 8.2 WELDER QUALIFICATION

#### 8.2.1 ~~Welder Qualification~~

Welder qualification shall be in accordance with API Standard 1104 and the following. All welders employed or engaged by CONTRACTOR for pipeline welding must successfully complete either the single or multiple qualification test for each of the previously qualified welding procedures.

Welder qualification for butt welds by radiography per API Standard 1104 is not permissible except by COMPANY'S written direction for exceptional circumstances.

Testing shall be done by an independent testing laboratory approved by COMPANY. Results shall be reported on forms similar to Figures shown in API Standard 1104.

COMPANY Inspector will witness test welding, review test results, and will promptly notify CONTRACTOR as to the qualification or failure to qualify of each welder. CONTRACTOR shall notify COMPANY of time and location of qualification test welding at least 2 days in advance.

<b>Bear Tracker Energy, LLC</b>	Rev: IFB	Date: 1/26/11
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Costs of welding tests and testing shall be at CONTRACTOR'S expense, except COMPANY will provide line pipe for test qualifications.

### 8.2.2 Qualified Welders

Each welder must be qualified for the type and method of welding he will perform. Multiple qualification is required for welders performing branch connection or doing manifold fabrication welding.

A welder making a successful Procedure Qualification test weld is automatically qualified for that procedure.

### 8.2.3 Additional Tests

Welders must be re-qualified if there is any change in the essential variables for welder qualification.

COMPANY reserves the right to require and witness additional tests at any time if there is doubt about the competence of a welder. COMPANY will reimburse CONTRACTOR for the cost of such additional tests only if the test is passed.

Welders who do not pass retests shall not be permitted to weld on the remainder of the project.

## 8.3 WELDER IDENTIFICATION

CONTRACTOR shall issue an identification number to each qualified welder. Each weld made by that welder shall be so identified. Any weld worked on by more than one welder shall be identified by the number of each welder participating in the weld.

All welds shall be marked by each welder with an ink or "Paint Stick" pipe marker on the top quarter of the pipe using the identification number assigned to