

High Pressure Piping (HPP) Jobsite Pre-Inspection Checklist

- Contractor shall maintain a list of all personnel fabricating and/or installing HPP under the HPP permit.
The list must include the names and current HPP license/registration numbers for all:

1. Journeyman and contracting high pressure pipefitters.
2. Registered unlicensed pipefitters.
3. Pipefitter apprentices registered with the DLI Apprenticeship unit.

****** Licensed high pressure pipefitters must directly supervise apprentices and registered unlicensed pipefitters. A licensed pipefitter may directly supervise no more than 2 apprentice or registered unlicensed pipefitters.***

- For welded piping, the following documents must be available for review by the HPP inspector at the jobsite. All procedures and qualification tests must be in accordance with 2007 ASME Section IX.

1. A copy of all welding procedure specifications (WPS) and corresponding procedure qualification records (PQR) for the welding processes performed on HPP for the permitted project.
2. A copy of all welder performance qualifications (WPQ) and any necessary welder continuity logs for individuals welding on HPP for the permitted project. Continuity logs must be maintained for any welder whose WPQ is over 6 months old.
3. Qualified welders shall be assigned an identifying number, letter, or symbol by the contractor that shall be used to identify the work of that welder.

******Any welding performed on HPP systems without the above documentation is subject to removal.***

- HPP work may be added to the original permit, depending upon size and scope. Be sure to contact the HPP inspector for your project to request this.
- Requests for permit inspections should be made at least 5 days in advance to allow time for inspector scheduling.
- The cities of Minneapolis and St Paul have municipal agreements with the Department of Labor & Industry to issue permits and conduct inspections of HPP systems within those cities. This excludes facilities that are state owned or operated such as the University of Minnesota campuses.
- Registration of unlicensed individuals and HPP exam applications are available online at:
<http://www.doli.state.mn.us/CCLD/HPPForms.asp>
- HPP permits are available online at:
http://www.doli.state.mn.us/CCLD/etrakit_hpp.asp
- Verify current business and personal HPP licenses in DLI's searchable online database at: <https://secure.doli.state.mn.us/lookup/licensing.aspx>
- Review the current MN High Pressure Piping statutes and rules online at:
<http://www.doli.state.mn.us/CCLD/HPP.asp>
- Purchase a copy of the MN High Pressure Piping Laws & Rules (keyword search: Piping):
<http://www.comm.media.state.mn.us/bookstore/mnbookstore.asp>
- Inspector contact info:

Inspector	Territory	Phone number	Email address
Earl Gruis	West and southwest MN	(612) 590-5160	earl.gruis@state.mn.us
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