

PREFABRICATION OF LARGE BORE BOP PIPING

Client/End User : METKA s.a. (Greece) / RWE & TURCAS GUNEY
ELEKTRIK URETIM a.s. (Turkey)
Year : 2012

Work Description :

1. Materials receipt, provided by the Client,
2. Prefabrication of following piping :

Piping material grade	Total Q'ty (pcs)	Pipe dia. (")	Pipe thickness (mm)		Total Welded Inches		Total Welds (pcs)	
			B.W.	B.R.	B.W.	B.R.	B.W.	B.R.
C.S. SA 106 Gr B / Gr C	4.318	½ ÷ 30	3,9 ÷ 36	3,7 ÷ 12,7	27.106	938	3.569	745
S.S. SA 312 Gr Tp 304 / Tp 316L	683	½ ÷ 10	3,9 ÷ 15	2,8 ÷ 5,5	3.027	70	613	68
Alloy SA 335 Gr P11	246	½ ÷ 36	5,5 ÷ 24	3,7 ÷ 10,0	2.010	130	193	54
Alloy SA 335 Gr P22	199	½ ÷ 28	5,2 ÷ 25,4	3,7 ÷ 25,4	983	110	139	59
Alloy SA 335 Gr P91	443	½ ÷ 32	5,2 ÷ 50	3,7 ÷ 30,0	3.462	163	344	101

3. Non Destructive Testing

Piping Grade	Radiography Testing	Ultrasonic Testing	Magnetic Testing	P.M.I.
Carbon Steel	10% (<19mm), 100% (>19mm)			
Stainless Steel	10%			10%
Alloy Piping (P11)	100%			
Alloy Piping (P22)	100%			
Alloy Piping (P91)	100%	100%	100%	

4. Coating

- a. Application of sandblasting SA 2 ½ & Painting with 75µm Inorganic Zinc Rich Ethyl Silicate on the external surfaces of piping and piping fittings.
- b. Application of sandblasting SA 1 on the internal surface of all piping of diam. > 3".

5. Bevelling

- a. Pipe thickness < 10mm : 9.150 inches
- b. Pipe thickness >10/<19mm : 7.690 inches
- c. Pipe thickness > 19mm : 6.000 inches

6. Cutting & beveling of 90° elbows : Total : 1.550 inches.

Applicable code : B31.1 Edition 2007 Addenda 2008

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