

Specification

# Weldment Fabrication

970112646

D	Re-issued for use	04.03.21	AT	PB	GMU
C	Re-issued for use	22.08.17	DB	BH	GMU
B	Issued for use	04.12.12	DB	RT	GMU
A	Issued for approval	30.11.12	DB	RT	GMU
<b>Rev.</b>	<b>Reason for Issue</b>	<b>Date</b>	<b>By</b>	<b>Check</b>	<b>Approval</b>

## Weldment Fabrication

970112646

## Table of Content

<b>1</b>	<b>INTRODUCTION</b>	<b>2</b>
<b>2</b>	<b>WELDMENT FABRICATION</b>	<b>3</b>
2.1	Structural Steel Fabrication	3
2.2	Structural Aluminium Fabrication	3
2.3	Weldment in other materials	3
<b>3</b>	<b>WELDMENT FABRICATION – UNITED KINGDOM CONTINENTAL SHELF</b>	<b>4</b>
3.1	Structural Steel Fabrication	4
3.2	Structural Aluminium Fabrication	4
3.3	Weldment in other materials	5

## 1 Introduction

This specification specifies requirements and references to standards to be used in fabrication of welded parts/assemblies.

This Specification has been divided into two parts: One part for general use, and one part for United Kingdom Continental Shelf if required.

## Weldment Fabrication

970112646

## 2 Weldment Fabrication

### 2.1 Structural Steel Fabrication

Norsok M-101 to be used with following comments/changes:

- For any specification references which has been withdrawn, the superseded specification shall be used
- Regardless of inspection category fully qualified welding procedures and welding certificates are required
- Inspection class and category shall be noted on drawing. If this information is missing, supplier shall ask company buyer to confirm class and category required for the delivery.
- NDT Prior to and after load test

**Note: Any specific requirements listed on the drawing applies and supersedes this specification**

### 2.2 Structural Aluminium Fabrication

Norsok M-102 to be used with following comments/changes:

- For any specification references which has been withdrawn, the superseded specification shall be used
- Regardless of inspection category fully qualified welding procedures and welding certificates are required
- Inspection class and category shall be noted on drawing. If this information is missing, supplier shall ask company buyer to confirm class and category required for the delivery.
- NDT Prior to and after load test

**Note: Any specific requirements listed on the drawing applies and supersedes this specification**

### 2.3 Weldment in other materials

- Regardless of inspection category fully qualified welding procedures and welding certificates are required
- Inspection class and category shall be noted on drawing. If this information is missing, supplier shall ask company buyer to confirm class and category required for the delivery.
- NDT Prior to and after load test

**Note: Any specific requirements listed on the drawing applies and supersedes this specification**

## Weldment Fabrication

970112646

### 3 Weldment Fabrication – United Kingdom Continental Shelf

#### 3.1 Structural Steel Fabrication

BS EN ISO 15609 to be used with following comments/changes:

- Quality requirement according to EN ISO 3834
- NDT extent to be project defined and noted on drawing. Applicable standards are Norsok M101, DNVGLST-E273 or other relevant standard.
- NDT acceptance criteria according:

Visual	EN ISO 5717 Level B
Magnetic Particle	EN ISO 23278 Level 1
Dye Penetrant	EN ISO 23277 Level 1
Ultrasonic	EN ISO 11666 Level 2
Radiography	EN ISO 10675-1 Level 1
- For any specification references which has been withdrawn, the superseded specification shall be used
- Regardless of inspection category fully qualified welding procedures and welding certificates are required
- Inspection class and category shall be noted on drawing. If this information is missing, supplier shall ask company buyer to confirm class and category required for the delivery.
- NDT Prior to and after load test

**Note: Any specific requirements listed on the drawing applies and supersedes this specification**


#### 3.2 Structural Aluminium Fabrication

BS EN ISO 15609 to be used with following comments/changes:

- Quality requirement according to EN ISO 3834
- NDT extent to be project defined and noted on drawing. Applicable standards are Norsok M102, DNVGLST-E273 or other relevant standard.
- NDT acceptance criteria according:

Visual	EN ISO 10042
Magnetic Particle	EN ISO 23278 Level 1
Dye Penetrant	EN ISO 23277 Level 1
Ultrasonic	EN ISO 11666 Level 2
Radiography	EN ISO 10675-2
- For any specification references which has been withdrawn, the superseded specification shall be used
- Regardless of inspection category fully qualified welding procedures and welding certificates are required
- Inspection class and category shall be noted on drawing. If this information is missing, supplier shall ask company buyer to confirm class and category required for the delivery.
- NDT Prior to and after load test

**Note: Any specific requirements listed on the drawing applies and supersedes this specification**

	Specification	Rev. D	Page 5 of 5
	Weldment Fabrication	970112646	

### 3.3 Weldment in other materials

- Regardless of inspection category fully qualified welding procedures and welding certificates are required
- Inspection class and category shall be noted on drawing. If this information is missing, supplier shall ask company buyer to confirm class and category required for the delivery.
- NDT Prior to and after load test

**Note: Any specific requirements listed on the drawing applies and supersedes this specification**