

	<b>TECHNICAL SPECIFICATION</b>	Nº: I-ET-3010.2D-1251-560-P4X-001	
	CLIENT:	AGUP	SHEET: 1 of 24
	JOB:	HIGH CAPACITY FPSO - GAS EXPORTATION ALL ELECTRIC	
	AREA:	ATAPU 2 AND SÉPIA 2	
SRGE	TITLE:	<b>SULPHATE REMOVAL UNIT (UT-1251002)</b>	INTERNAL
			ESUP

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FORM OWNED TO PETROBRAS N-0381 REV. L



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## 1 OBJECTIVE

This Technical Specification covers the minimum requirements for design, engineering, materials, fabrication, inspection, testing, commissioning, and pre-commissioning of the SULPHATE REMOVAL UNIT (UT-1251002).

SULPHATE REMOVAL UNIT (UT-1251002) shall be provided with all necessary instruments to operate safely, adequately and without interruption in an offshore facility.

The requirements herein listed apply to all players which will perform any activity related to the scope of this unit, including manufacturers, packagers, main contractor, subcontractors, suppliers, sub-suppliers, integrators, constructors, and all technical personnel involved. Within the scope of this document, they are all referred to as being a SELLER.

In addition to the requirements of this technical specification, the SELLER shall follow all the requirements of Exhibit I (SCOPE OF SUPPLY), as well as Exhibit III (DIRECTIVES FOR ENGINEERING EXECUTION), Exhibit IV (DIRECTIVES FOR CONSTRUCTION AND ASSEMBLY), Exhibit V (DIRECTIVES FOR PROCUREMENT), Exhibit VI (DIRECTIVES FOR PLANNING AND CONTROL), Exhibit VII (DIRECTIVES FOR QUALITY MANAGEMENT SYSTEM) and Exhibit VIII (DIRECTIVES FOR COMMISSIONING PROCESS).

## 2 NORMATIVE REFERENCES AND DESIGN SPECIFICATIONS

### 2.1 CLASSIFICATION SOCIETY

2.1.1 SELLER shall perform the work in accordance with the requirements of the Classification Society.

2.1.2 SELLER is responsible to submit to Classification Society the documentation in compliance with stated Rules.

2.1.3 Classification Society rules may only be waived upon formal approval from the Classification Society itself and from BUYER.

### 2.2 CODES AND STANDARDS

2.2.1 The following codes and standards include provisions that, through reference in this text, constitute provisions of this specification. The latest issue of the references shall be used unless otherwise agreed.

2.2.2 Other recognized international standard may be used, whether they meet or exceed the requirements of the standards referenced below. Formal approval from BUYER and from the Classification Society is also required.

AISC ASD	- Steel Construction Manual
API RP 14C	- Analysis, Design, Installation and Testing of Safety Systems for Offshore Production Platforms
API RP 14E	- Recommended Practice for Design and Installation of Offshore Production Platform Piping Systems
API RP 14J	- Recommended practice for design and Hazard Analysis for Offshore Production Facilities
API RP 14FZ	- Recommended Practice for Design, Installation, and Maintenance of Electrical Systems for Fixed and Floating Offshore Petroleum Facilities for Unclassified and Class I, Zone 0, Zone 1, and Zone 2 Locations
API RP 505	- Classification of locations for Electrical Installations at Petroleum Facilities Classified as Class 1, Zone 0, Zone 1 and Zone 2
API STD 521	- Pressure-relieving and Depressuring
API STD 610	- Centrifugal Pumps for Petroleum, Petrochemical, and Natural Gas Industries
ASME B16.5	- Pipe Flanges and Flanged Fittings
ASME B16.47	- Large Diameter Steel Flanges: NPS 26 through NPS 60
ASME B31.3	- Process Piping
ASME BPVC VIII	- Div.1 and Div. 2. Boiler and Pressure Vessel Code. Rules for Construction of Pressure Vessels
ASME BPVC X	- Fiber-Reinforced Plastic Pressure Vessels
DOT-3A	- Specification for Seamless Steel Transportable Pressure Receptacles
DOT-3AA	- Specification for Seamless Steel Transportable Pressure Receptacles
IEC 60079 (all parts)	- Explosive Atmospheres
IEC 61892 (all parts)	- Mobile and fixed offshore units – Electrical installations
ISO 15156	- Petroleum and natural gas industries — Materials for use in H <sub>2</sub> S-containing environments in oil and gas production — Part 1: General principles for selection of cracking-resistant materials
ISO 21457	- Materials selection and corrosion control for oil and gas production systems
ISO 9809 (all parts)	- Gas cylinders — Design, construction and testing of refillable seamless steel gas cylinders and tubes

### 2.3 GOVERNMENT REGULATION

Brazilian Government regulations are mandatory and shall prevail, if more stringent, over the requirements of this specification and other references herein.

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NR-10	Brazilian Regulatory Standard - Safety in Electrical Facilities and Services
NR-12	Brazilian Regulatory Standard – Safety Working with Machineries and Equipment.
NR-13	Brazilian Regulatory Standard - Boilers, Pressure Vessels, Pipes and Metallic Storage Tanks
NR-17	Brazilian Regulatory Standard - Ergonomics
NR-26	Brazilian Regulatory Standard - Safety Signaling
NR-37	Brazilian Regulatory Standard - Safety and Health in Petroleum Platforms
IBAMA	Brazilian IBAMA environmental regulations concerning the discharge of all types of effluents
INMETRO	INMETRO Resolution nº 115, March 21 <sup>st</sup> 2022, and its annexes

**2.4 DESIGN SPECIFICATIONS**

I-ET-3010.00-1200-940-P4X-002 – GENERAL TECHNICAL TERMS

I-ET-3A26.00-1000-941-PPC-001\_F – METOCEAN DATA – UNITS AND PRODUCTION SYSTEMS – SANTOS BASIN CENTRAL CLUSTER REGION

I-ET-3A36.00-1000-941-PPC-001\_F – METOCEAN DATA – PRODUCTION SYSTEM AND UNITS – NOTHERN SANTOS BASIN PRE-SALT FIELDS

I-RL-3010.2D-1350-960-P4X-002 – MOTION ANALYSIS

I-DE-3010.2D-1200-942-P4X-002 – GENERAL ARRANGEMENT

I-DE-3010.2D-1422-942-P4X-001 – M-11 – WATER INJECTION AND SULPHATE REMOVAL UNIT – EQUIPMENT LAYOUT PLAN

I-DE-3010.2D-1200-94A-P4X-001 – AREA CLASSIFICATION - GENERAL

I-ET-3000.00-5400-98G-P4X-001 – EXPLOSION STUDY

I-ET-3010.00-1200-300-P4X-001 – NOISE AND VIBRATION CONTROL REQUIREMENTS

I-FD-3010.2D-1251-560-P4X-002 – SULPHATE REMOVAL UNIT (UT-1251002)

I-DE-3010.2D-1251-944-P4X-004 – SULPHATE REMOVAL UNIT

I-DE-3010.2D-5111-943-P4X-001 – UTILITY FLOW DIAGRAM SEA WATER SYSTEM

I-ET-3010.00-1200-310-P4X-001 - API 610 CENTRIFUGAL PUMPS SPECIFICATION

I-ET-3010.00-1200-940-P4X-005 - CHEMICAL INJECTION POINTS

I-ET-3010.2D-1200-200-P4X-001 – PIPING SPECIFICATION FOR TOPSIDE

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I-ET-3010.2D-1200-200-P4X-005 – MINIMUM REQUIREMENTS FOR PIPING MECHANICAL DESIGN AND LAYOUT

I-ET-3010.2D-1200-200-P4X-006 – REQUIREMENTS FOR PIPING STRESS ANALYSIS

I-ET-3010.2D-1200-200-P4X-004 – REQUIREMENTS FOR PIPING SUPPORT

I-ET-3010.00-1200-200-P4X-115 – REQUIREMENTS FOR PIPING FABRICATION AND COMMISSIONING

I-ET-3010.00-1200-431-P4X-001 – THERMAL INSULATION FOR MARITIME INSTALLATIONS

I-ET-3010.00-1200-251-P4X-001 – REQUIREMENTS FOR BOLTING MATERIALS

I-ET-3010.00-1200-200-P4X-116 – REQUIREMENTS FOR BOLTED JOINTS ASSEMBLY AND MANAGEMENT

I-DE-3010.00-1400-140-P4X-004 – GENERAL NOTES FOR TOPSIDES STRUCTURES

I-ET-3010.2D-1200-940-P4X-001 - MATERIAL SELECTION PHILOSOPHY FOR DETAILED DESIGN

I-ET-3010.00-1200-310-P4X-002 – POSITIVE DISPLACEMENT PUMPS SPECIFICATION

I-ET-3010.00-1200-310-P4X-003 – NON-API 610 CENTRIFUGAL PUMPS SPECIFICATION

I-ET-3010.00-1200-540-P4X-001 – REQUIREMENTS FOR PRESSURE VESSELS DESIGN AND FABRICATION

I-ET-3010.00-1200-451-P4X-001 – REQUIREMENTS FOR SHELL AND TUBE HEAT EXCHANGER DESIGN AND FABRICATION

I-ET-3010.00-1200-456-P4X-001 – REQUIREMENTS FOR PLATE HEAT EXCHANGER DESIGN AND FABRICATION

I-ET-3010.00-1200-510-P4X-001 – METALLIC TANKS DESIGN FOR TOPSIDE

I-ET-3010.00-1200-500-P4X-001 – NON-METALLIC TANKS AND PRESSURE VESSELS DESIGN

I-ET-3010.2D-1350-196-P4X-001 - ERGONOMICS REQUIREMENTS FOR TOPSIDES

DR-ENGP-M-I-1.3 – SAFETY ENGINEERING GUIDELINE

I-MD-3010.2D-1200-947-P4X-003 - DESCRIPTIVE MEMORANDUM – SAFETY

I-FD-3010.2D-5400-947-P4X-001 - SAFETY DATA SHEET - TOPSIDE

I-ET-3010.00-5400-947-P4X-002 – SAFETY SIGNALLING

I-ET-3010.00-1200-800-P4X-002 – AUTOMATION, CONTROL AND INSTRUMENTATION ON PACKAGE UNITS

I-ET-3010.2D-1200-800-P4X-014 – AUTOMATION INTERFACE OF PACKAGED UNITS

I-ET-3010.00-5520-888-P4X-001 - AUTOMATION PANELS

I-ET-3010.00-5140-712-P4X-001 – LOW-VOLTAGE INDUCTION MOTORS FOR OFFSHORE UNITS

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I-ET-3010.00-5140-712-P4X-002 – MEDIUM-VOLTAGE INDUCTION MOTORS FOR OFFSHORE UNITS

I-ET-3010.00-5140-700-P4X-002 – SPECIFICATION FOR ELECTRICAL MATERIAL FOR OFFSHORE UNITS

I-ET-3010.00-5140-700-P4X-007 – SPECIFICATION FOR GENERIC ELECTRICAL EQUIPMENT FOR OFFSHORE UNITS

I-ET-3010.00-5140-700-P4X-009 – GENERAL REQUIREMENTS FOR ELECTRICAL MATERIAL AND EQUIPMENT FOR OFFSHORE UNITS

I-ET-3010.00-5140-741-P4X-004 – SPECIFICATION FOR LOW-VOLTAGE GENERIC ELECTRICAL PANELS FOR OFFSHORE UNITS

I-ET-3010.00-5140-741-P4X-003 – POWER PANEL FOR THYRISTORIZED HEATER FOR OFFSHORE UNITS

I-ET-3010.00-5140-700-P4X-001 – SPECIFICATION FOR ELECTRICAL DESIGN FOR OFFSHORE UNITS

I-ET-3010.00-5140-700-P4X-003 – ELECTRICAL REQUIREMENTS FOR PACKAGES FOR OFFSHORE UNITS

I-DE-3010.00-5140-700-P4X-003 – GROUNDING INSTALLATION TYPICAL DETAILS.

I-ET-3010.00-5140-797-P4X-001 – ELECTRICAL SYSTEM AUTOMATION ARCHITECTURE

I-DE-3010.00-5140-797-P4X-002 – ELECTRICAL SYSTEM AUTOMATION TYPICAL ACTUATION DIAGRAMS

I-LI-3010.00-5140-797-P4X-001 – ELECTRICAL SYSTEM AUTOMATION INTERFACE SIGNALS LIST

I-ET-3010.00-5518-767-PPT-002 - TOPSIDES PUBLIC ADDRESS SYSTEM

I-MD-3010.00-5510-760-PPT-001 - GENERAL CRITERIA FOR TELECOMMUNICATIONS DESIGN

I-ET-3010.00-1200-956-P4X-002 – GENERAL PAINTING

DR-ENGP-I-1.15 – COLOR CODING

I-ET-3000.00-1200-940-P4X-001 – TAGGING PROCEDURE FOR PRODUCTION UNITS DESIGN

I-ET-3010.00-1200-970-P4X-003 - REQUIREMENTS FOR PERSONNEL QUALIFICATION AND CERTIFICATION

I-ET-3010.00-1200-972-P4X-006 - REQUIREMENTS FOR MANUFACTURING SURVEY INSPECTION

I-ET-3010.00-1200-978-P4X-005 - REQUIREMENTS FOR MATERIALS TRACEABILITY

I-ET-3010.00-1200-970-P4X-013 - COMPLIANCE WITH NR-13 AND SPIE REQUIREMENTS

I-ET-3010.00-1200-955-P4X-001 – WELDING

I-ET-3010.00-1200-970-P4X-004 - NON-DESTRUCTIVE TESTING REQUIREMENTS FOR METALLIC AND NON-METALLIC MATERIALS



I-ET-3010.2D-1251-560-P4X-003 – ULTRAFILTRATION UNIT (UT-1251001)

## 2.5 CONFLICTING REQUIREMENTS

2.5.1 In case of conflicting requirements between this technical specification and other cited references, the most stringent shall prevail. If necessary, the SELLER may revert to BUYER for clarification.

## 3 DEFINITIONS AND ABBREVIATIONS

### 3.1 DEFINITIONS

3.1.1 All Terms and definitions are established in the latest revision I-ET-3010.00-1200-940-P4X-002 – GENERAL TECHNICAL TERMS

### 3.2 ABBREVIATIONS

CIP	-	Clean in place
CLASS	-	Classification Society
FAT	-	Factory Acceptance Test
FPSO	-	Floating Production Storage and Offloading
GRP	-	Glass- Reinforced Plastic
HAZOP	-	Hazard and Operability Study
ITP	-	Inspection and Test Plans
NPS	-	Nominal Pipe Size
NDT	-	Non-Destructive Test
PHA	-	Process Hazards Analyses
PAGA	-	Public Address and General Alarm
SDI	-	Silt Density Index

## 4 GENERAL REQUIREMENTS

### 4.1 OPERATION ENVIRONMENT

4.1.1 The equipment supplied shall be suitable for the environment and range of ambient condition defined in the following documents: for SEPIA field see I-ET-3A26.00-1000-941-PPC-001\_F – METOCEAN DATA – UNITS AND PRODUCTION SYSTEMS – SANTOS BASIN CENTRAL CLUSTER REGION; for ATAPU field see I-ET-3A36.00-1000-941-PPC-001\_F – METOCEAN DATA – PRODUCTION SYSTEM AND UNITS – NOTHERN SANTOS BASIN PRE-SALT FIELDS.



## 4.2 MOTION REQUIREMENTS

4.2.1 The necessary design data and information on motion requirements are given in I-RL-3010.2D-1350-960-P4X-002 – MOTION ANALYSIS.

## 4.3 PACKAGE LOCATION AND AREA CLASSIFICATION

4.3.1 The Sulphate Removal Unit (UT-1251002) shall be installed on module M-11 as informed in I-DE-3010.2D-1200-942-P4X-002 – GENERAL ARRANGEMENT . For available space, also see I-DE-3010.2D-1422-942-P4X-001 – M-11 – WATER INJECTION AND SULPHATE REMOVAL UNIT – EQUIPMENT LAYOUT PLAN.

4.3.2 For area classification see I-DE-3010.2D-1200-94A-P4X-001 – AREA CLASSIFICATION - GENERAL.

## 4.4 DESIGN LOADS

4.4.1 In addition to the loads required by the International Standards and loads due to FPSO motion described in I-RL-3010.2D-1350-960-P4X-002 – MOTION ANALYSIS, the following design loads shall be considered whenever applicable:

- Equipment transportation and erection loads;
- Nozzle loads;
- Thermal loads;
- Wind loads (see METOCEAN DATA);
- Weight loads.
- Blast loads (according to I-ET-3000.00-5400-98G-P4X-001 – EXPLOSION STUDY)

## 4.5 DESIGN LIFETIME

4.5.1 SELLER shall design and fabricate the complete package and each equipment belonging to the scope of supply considering a minimum lifetime of 30 years.

## 4.6 NOISE AND VIBRATION

4.6.1 Noise and vibration control concerning human exposure shall be performed according to I-ET-3010.00-1200-300-P4X-001 – NOISE AND VIBRATION CONTROL REQUIREMENTS.

# 5 PACKAGE SPECIFICATION

## 5.1 SCOPE OF SUPPLY

5.1.1 SELLER shall select manufacturers considering a proven experience supplying this type of equipment/technology. SELLER shall submit manufacturers names to BUYER approval.

5.1.2 The Sulphate Removal Unit (UT-1251002) shall be complete in all respect and the scope of supply shall include but not be limited to the major equipment described in

the document I-FD-3010.2D-1251-560-P4X-002 – SULPHATE REMOVAL UNIT (UT-1251002) and I-DE-3010.2D-1251-944-P4X-004 – SULPHATE REMOVAL UNIT.

- 5.1.3 Alternatively, for optimization purposes, the sulfate removal unit (UT-1251002) may be supplied together with the ultrafiltration unit (UT-1251001) whose requirements are described in I-ET-3010.2D-1251-560-P4X-003 – ULTRAFILTRATION UNIT (UT-1251001).

## 5.2 PROCESS DESIGN

- 5.2.1 SELLER shall design and size the package and all equipment related to the scope of supply for the full range of process conditions as specified in the following documents:

- A. Process Data Sheet I-FD-3010.2D-1251-560-P4X-002 – SULPHATE REMOVAL UNIT (UT-1251002);
- B. Piping and Instrument Diagram: I-DE-3010.2D-1251-944-P4X-004 – SULPHATE REMOVAL UNIT
- C. Flow Diagram: I-DE-3010.2D-5111-943-P4X-001 – UTILITY FLOW DIAGRAM SEA WATER SYSTEM.

- 5.2.2 Design shall also include the definition of number, size and location of all nozzles related to the process and instruments in the battery limits of the package (refer to the I-DE-3010.2D-1251-944-P4X-004 – SULPHATE REMOVAL UNIT).

### 5.2.3 Feed Booster Pumps

- A. The Feed Booster Pumps (B-UT-1251002A/C) shall comply with the requirements of I-ET-3010.00-1200-310-P4X-001 - API 610 CENTRIFUGAL PUMPS SPECIFICATION.
- B. Pumps materials shall be in Super Duplex according to API STD 610 Annex H class D2.
- C. The pumps shall feed and pressurize the membrane banks at safe flowrates and pressures, compatible with the membranes.
- D. Each pump shall be provided with discharge check-valve and suction and discharge stop valves, plus all necessary controls, drainage piping and valve facilities. For pressures above 20 bar g, block valves shall have double block and bleed configuration.

### 5.2.4 Membrane Banks

- A. SELLER is free to propose the most cost-effective arrangement of the membrane banks able to meet the allocated module space and specified desulphated seawater quality and flowrate. Consideration shall also be given to provide a high availability for the unit.
- B. Each bank shall be provided with a differential pressure indicator-transmitter with differential pressure alarm.
- C. Each train of banks shall be protected against backflow with a discharge check valve. Vacuum protection shall be accomplished with a vacuum relief valve or bursting disc between the check valve and membrane banks.
- D. Final banks quantity and arrangement shall be agreed upon prior to order placement. Membrane elements shall be selected for long life performance.
- E. The membrane banks shall be provided with sampling facilities to monitor the membranes performance during operation.

F. Membrane vessels shall be made of GRP or Super Duplex, depending on the pressure limits. They shall be designed and manufactured according to ASME BPVC X or ASME BPVC VIII respectively and comply with NR-13 requirements.

#### 5.2.5 Membrane Cleaning System

- A. A complete membrane cleaning system located adjacent to the membrane units shall be provided, with rigid piping (or hoses, if not practicable) for cleaning each membrane bank after isolation.
- B. The package will consist of GRP tank, electric heater(s), filter(s), pump(s) and all required accessories.
- C. SELLER shall define the expected cleaning frequency, water flowrate, and type and flowrate of chemicals required for each cleaning cycle.

#### 5.2.6 Cartridge Filters

- A. Replaceable cartridge filters shall be supplied complete, each vessel with pressure differential indicator transmitter, NR-13 certification and NR-13 nameplates.
- B. The final quantity of filters shall be determined prior to order placement, and their performance shall meet the minimum membrane inlet conditions as per membrane manufacturer's recommendations.
- C. Arrangement and size of cartridge filters shall be determined by SELLER based on the seawater supply quality and the treated seawater specification.
- D. Cartridge housing shall be preferably designed to accept both conventional and spear end filter types.
- E. Sampling points shall be fitted upstream and downstream the filters for SDI analysis. Local pressure gauge(s) shall be provided on the filters to ensure safety prior to opening the filter covers.

#### 5.2.7 Chemical Injection Package

- A. SELLER shall define the concentrations, volumes and types of chemicals to be used and shall comment on the suitability of BUYER proposed arrangement.
- B. The package shall include all required injection pumps with motors, tanks, instrumentation, piping to the skid edge, valves and controls, drip trays with drain piping.
- C. The location/ elevation of the chemical injection package shall be preferably to allow the refueling of chemical products by gravity force. Otherwise, the SELLER shall provide auxiliaries pumps individually for each chemical product.
- D. SELLER shall comply with the requirements I-ET-3010.00-1200-940-P4X-005 - CHEMICAL INJECTION POINTS.
- E. The lines of CIP tanks shall be equipped with check valves, suitable for saltwater service, to avoid the reverse flux from the Sulphate Removal Unit to CIP tanks.

### 5.3 MECHANICAL AND PIPING

- 5.3.1 All piping shall have valves (on/off valves) and/or flanges and blind flanges (ASME B16.5 or ASME B16.47) at the end of unit limits.
- 5.3.2 SELLER shall follow the technical specification I-ET-3010.2D-1200-200-P4X-001 – PIPING SPECIFICATION FOR TOPSIDE. Alternative piping specifications shall be submitted to BUYER for approval.
- 5.3.3 Piping layout shall observe the requirements presented in I-ET-3010.2D-1200-200-

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**P4X-005 – MINIMUM REQUIREMENTS FOR PIPING MECHANICAL DESIGN AND LAYOUT**

- 5.3.4 Piping stress analysis shall be performed according to I-ET-3010.2D-1200-200-P4X-006 – REQUIREMENTS FOR PIPING STRESS ANALYSIS.
- 5.3.5 All piping shall be properly supported considering the service loads, shipment and transportation loads. Piping supports shall be in accordance with I-ET-3010.2D-1200-200-P4X-004 – REQUIREMENTS FOR PIPING SUPPORT. The supporting and installation shall enable piping removal without disturbing structural members.
- 5.3.6 Socket welds are only permitted for piping sizes up to NPS 1½. All piping above NPS 1½ shall be butt-welded.
- 5.3.7 Valves shall be selected in conformance with I-ET-3010.2D-1200-200-P4X-001 – PIPING SPECIFICATION FOR TOPSIDE. Alternative valves specifications shall be submitted to BUYER for approval.
- 5.3.8 The use of concentric type butterfly valves and straight-through diaphragm valves with open body (open body tubular diaphragm valves) is not permitted.
- 5.3.9 The use of elastomeric throttle valves exposed to ultraviolet (UV) radiation is not allowed.
- 5.3.10 Sampling point / facilities shall be provided complete with necessary fittings and valves, and the design should reflect nature of the fluids being sampled.
- 5.3.11 Utility hose stations shall be installed throughout the package on strategic places for maintenance and cleaning purposes.
- 5.3.12 The design, assembly and commissioning of all process piping shall be according to ASME B31.3 code, I-ET-3010.00-1200-200-P4X-115 – REQUIREMENTS FOR PIPING FABRICATION AND COMMISSIONING, and I-ET-3010.2D-1200-200-P4X-005 – MINIMUM REQUIREMENTS FOR PIPING MECHANICAL DESIGN AND LAYOUT.
- 5.3.13 All structural supports including main structural skid, support frames, supports for equipment, ladders, walkways, platforms, grating and drip trays shall be provided.
- 5.3.14 All other miscellaneous items and equipment which are required for the service and proper operation of the Sulphate Removal Unit shall be included.
- 5.3.15 Equipment and piping subjected to a temperature of 60°C and above shall receive a personal protection system by means of stainless steel 316 wire mesh / perforated plates. Alternatively, a thermal insulation may be applied. Equipment and piping in which heat conservation is necessary shall be thermal insulated. The thermal insulation shall be according to the latest revision of I-ET-3010.00-1200-431-P4X-001 – THERMAL INSULATION FOR MARITIME INSTALLATIONS.
- 5.3.16 All fasteners (studs, bolts, tightening bolts, and nuts) shall be according to I-ET-3010.00-1200-251-P4X-001 – REQUIREMENTS FOR BOLTING MATERIALS.
- 5.3.17 Bolted joints within the package shall be assembled and managed as established in I-ET-3010.00-1200-200-P4X-116 – REQUIREMENTS FOR BOLTED JOINTS ASSEMBLY AND MANAGEMENT.

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5.3.18 SELLER shall provide a design book with all piping detailed design documentation, which must include, but not be limited, to the following documents: isometrics, piping plan, support detail drawings, stress analysis report (with native program file), list of supports, valve list, special item list, document list, stress analysis list, tie-in list, welding procedures, strainers datasheet, and piping elements datasheet.

**5.4 STRUCTURES**

5.4.1 SELLER shall follow the requirements of I-DE-3010.00-1400-140-P4X-004 – GENERAL NOTES FOR TOPSIDES STRUCTURES.

**5.5 MATERIAL SELECTION AND CERTIFICATION**

5.5.1 The SELLER is responsible for the materials selection considering the philosophy detailed at I-ET-3010.2D-1200-940-P4X-001 - MATERIAL SELECTION PHILOSOPHY FOR DETAILED DESIGN, suitable to the operational condition shown in the process data sheet I-FD-3010.2D-1251-560-P4X-002 – SULPHATE REMOVAL UNIT (UT-1251002).

5.5.2 In all cases, SELLER shall submit the detailed material selection report, including all piping, equipment and their components, for BUYER approval prior to manufacturing activities.

5.5.3 SELLER shall be responsible for obtaining all necessary certification of the equipment, work, and materials.

5.5.4 SELLER through the independent certifying authority shall supply all certificates related to the materials, inspections, tests, and qualification activities detailed in the approved Quality Plan.

5.5.5 The flow meters mentioned in I-FD-3010.2D-1251-560-P4X-002 – SULPHATE REMOVAL UNIT (UT-1251002) shall be in super duplex material.

**5.6 DESIGN AND FABRICATION****5.6.1 Clean in Place System**

- A. The CIP system shall be suitable for filling with ultra-filtered water (aerated seawater).
- B. For the minimum requirements of the CIP system see item: 5.2.5 Membrane Cleaning System.

**5.6.2 Pump**

- A. For Feed Booster Pumps (B-UT-1251002A/C) see the requirements in item 5.2.3 Feed Booster Pumps.
- B. Pumps requirements and pumps selection material shall comply with I-ET-3010.00-1200-310-P4X-001 - API 610 CENTRIFUGAL PUMPS SPECIFICATION, I-ET-3010.00-1200-310-P4X-002 – POSITIVE DISPLACEMENT PUMPS SPECIFICATION, or I-ET-3010.00-1200-310-P4X-003 – NON-API 610 CENTRIFUGAL PUMPS SPECIFICATION.
- C. For pumps up to 7.5 kW, working with non-flammable and non-hazardous service, SELLER may use its own specification, i.e., no specific design code may be

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applicable. In this case, additional requirements shall be submitted for BUYER'S approval which include field-proven acceptance and material selection performed per ISO 21457.

### 5.6.3 Pressure Vessel

All pressure vessels, columns and filters shall comply with the requirements of NR-13 (Brazilian Regulatory Standard) and I-ET-3010.00-1200-540-P4X-001 – REQUIREMENTS FOR PRESSURE VESSELS DESIGN AND FABRICATION.

Note: If the scope of supply includes any transportable pressure vessel connected with process plant or platform installations, these items shall be within the scope of NR-13 regulation. Furthermore, transportable containers shall be designed, constructed, inspected and installed in accordance with the requirements addressed by a specific rules of transportable equipment, such as ISO 9809, DOT-3A, or DOT-3AA.

### 5.6.4 Heat Exchanger

Heat exchangers shall comply with the requirements of I-ET-3010.00-1200-451-P4X-001 – REQUIREMENTS FOR SHELL AND TUBE HEAT EXCHANGER DESIGN AND FABRICATION or I-ET-3010.00-1200-456-P4X-001 – REQUIREMENTS FOR PLATE HEAT EXCHANGER DESIGN AND FABRICATION.

### 5.6.5 Electric Heater

The material selection for CIP heater shall be suitable to operate with ultra-filtered water (aerated seawater), and shall follow the requirements of I-ET-3010.2D-1200-940-P4X-001 - MATERIAL SELECTION PHILOSOPHY FOR DETAILED DESIGN. Materials shall be resistant to all chemicals to be used in the CIP unit. The equipment shall be an immersion tank flanged heater, with a maintenance area which allows its entire extraction for replacement. The terminal box shall be suitable for the marine atmosphere.

### 5.6.6 Metallic Tank

Metallic tanks shall comply with the requirements of I-ET-3010.00-1200-510-P4X-001 – METALLIC TANKS DESIGN FOR TOPSIDE.

### 5.6.7 Non-Metallic Tank and Non-Metallic Pressure Vessel

Non-metallic tanks and non-metallic pressure vessels shall comply with the requirements of I-ET-3010.00-1200-500-P4X-001 – NON-METALLIC TANKS AND PRESSURE VESSELS DESIGN.

## 5.7 ERGONOMIC REQUIREMENTS

5.7.1 The package shall be arranged such to allow safe and good personnel access for all operation and maintenance activities and in accordance with I-ET-3010.2D-1350-196-P4X-001 - ERGONOMICS REQUIREMENTS FOR TOPSIDES.

5.7.2 SELLER shall prepare detailed assembly, disassembly, and maintenance procedures, describing the use of all involved handling devices and including all required preventive and corrective maintenance tasks. SELLER shall inform the need for disassembling any component or equipment to facilitate access for maintenance. Suitable maintenance routes shall be provided to remove the main components and

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auxiliaries, avoiding interference with structures, piping, cabling, electric conduits and supports, equipment etc. This plan shall be submitted to BUYER for approval.

- 5.7.3 All valves shall be positioned with the stem pointing upwards. They shall be located in such a way that the hand wheel or actuator will not obstruct walkways and be easily accessible for operation and maintenance, according to I-ET-3010.2D-1350-196-P4X-001 - ERGONOMICS REQUIREMENTS FOR TOPSIDES. Where hand operated valves are not easily operable, gear operated valves shall be used.
- 5.7.4 Ladders and platform shall be provided to access operational devices, e.g., valves, instruments, manways, etc., whether located in an elevation greater than 1.75 m over the module base plate.
- 5.7.5 The level gauges shall be installed in such position that the level indicated in receiver will be easily seen. All level gauges shall have flanged connections, which can be isolated, and be complete with vent and drain, valves and connection, to facilitate the maintenance tasks.

**5.8 SAFETY REQUIREMENTS**

- 5.8.1 Pressure relief system and devices shall comply with the requirements of API STD 521.
- 5.8.2 For area classification see I-DE-3010.2D-1200-94A-P4X-001 – AREA CLASSIFICATION - GENERAL.
- 5.8.3 Mandatory safety items, as established in DR-ENGP-M-I-1.3 – SAFETY ENGINEERING GUIDELINE are to be considered complementary requirements, to the pertinent extent. In case of items in conflict with this document, BUYER shall be consulted.
- 5.8.4 Safety design additional requirements see: I-MD-3010.2D-1200-947-P4X-003 - DESCRIPTIVE MEMORANDUM – SAFETY, and I-FD-3010.2D-5400-947-P4X-001 - SAFETY DATA SHEET - TOPSIDE.
- 5.8.5 HAZOP and PHA shall be performed according to DR-ENGP-M-I-1.3 – SAFETY ENGINEERING GUIDELINE.
- 5.8.6 Double block & bleed arrangements are required for isolation of equipment in piping classes of 300# and above.
- 5.8.7 All safety signs and notices shall be in Portuguese language and according to I-ET-3010.00-5400-947-P4X-002 – SAFETY SIGNALLING.

**5.9 INSTRUMENTATION**

- 5.9.1 All instrumentation equipment and interface with FPSO automation and control design shall comply with I-ET-3010.00-1200-800-P4X-002 – AUTOMATION, CONTROL AND INSTRUMENTATION ON PACKAGE UNITS.
- 5.9.2 For package automation type classification and additional interfaces see I-ET-3010.2D-1200-800-P4X-014 – AUTOMATION INTERFACE OF PACKAGED UNITS.
- 5.9.3 All control, monitoring and safety protection instruments, instrumented valves, devices and associated accessories (such as, but not limited to, tubings thermowells, etc.) for

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remote indication, control, alarms, protection and shut down, etc. shall be included.

- 5.9.4 Automatic temperature control facilities shall be provided for the control of cooling medium flow.
- 5.9.5 Package Unit Control Panel and Remote I/O Panel shall fully comply with requirements of I-ET-3010.00-5520-888-P4X-001 - AUTOMATION PANELS.

**5.10 ELECTRICAL**

- 5.10.1 All materials and equipment proper to be used in hazardous areas shall have conformity certificates complying with: the latest revision of IEC 60079 and all its parts; PORTARIA INMETRO Nº 115 (march 21<sup>st</sup>, 2022); and shall be approved by CLASS.
- 5.10.2 Electrical equipment installed in external safe areas, that shall be kept operating during emergency shutdown ESD-3P and ESD-3T shall be certified for installation in hazardous areas Zone 2 (EPL Gc) Group IIA temperature T3, unless they are automatically disconnected if there is gas in the equipment area, according to IEC 61892-1.
- 5.10.3 Low-voltage and medium-voltage motors inside the package shall comply with I-ET-3010.00-5140-712-P4X-001 – LOW-VOLTAGE INDUCTION MOTORS FOR OFFSHORE UNITS and I-ET-3010.00-5140-712-P4X-002 – MEDIUM-VOLTAGE INDUCTION MOTORS FOR OFFSHORE UNITS.
- 5.10.4 All electrical equipment and material shall fully comply with the documents: I-ET-3010.00-5140-700-P4X-002 – SPECIFICATION FOR ELECTRICAL MATERIAL FOR OFFSHORE UNITS, I-ET-3010.00-5140-700-P4X-007 – SPECIFICATION FOR GENERIC ELECTRICAL EQUIPMENT FOR OFFSHORE UNITS, I-ET-3010.00-5140-700-P4X-009 – GENERAL REQUIREMENTS FOR ELECTRICAL MATERIAL AND EQUIPMENT FOR OFFSHORE UNITS, and I-ET-3010.00-5140-741-P4X-004 – SPECIFICATION FOR LOW-VOLTAGE GENERIC ELECTRICAL PANELS FOR OFFSHORE UNITS.
- 5.10.5 Heater panels shall comply with the requirements of I-ET-3010.00-5140-741-P4X-003 – POWER PANEL FOR THYRISTORIZED HEATER FOR OFFSHORE UNITS.
- 5.10.6 Power lighting and grounding installations inside the package shall comply with requirements of I-ET-3010.00-5140-700-P4X-001 – SPECIFICATION FOR ELECTRICAL DESIGN FOR OFFSHORE UNITS, I-ET-3010.00-5140-700-P4X-003 – ELECTRICAL REQUIREMENTS FOR PACKAGES FOR OFFSHORE UNITS, and I-DE-3010.00-5140-700-P4X-003 – GROUNDING INSTALLATION TYPICAL DETAILS.
- 5.10.7 Interfaces of the Package with Electrical System shall comply with I-ET-3010.00-5140-797-P4X-001 – ELECTRICAL SYSTEM AUTOMATION ARCHITECTURE, I-DE-3010.00-5140-797-P4X-002 – ELECTRICAL SYSTEM AUTOMATION TYPICAL ACTUATION DIAGRAMS, and I-LI-3010.00-5140-797-P4X-001 – ELECTRICAL SYSTEM AUTOMATION INTERFACE SIGNALS LIST.

**5.11 TELECOMMUNICATIONS**

- 5.11.1 Design of PAGA equipment shall fulfill the requirements, including standards and



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documents referred herein as well as referenced data sheets. PAGA installations and interfaces shall comply with requirements of:

- A. I-ET-3010.00-5518-767-PPT-002 - TOPSIDES PUBLIC ADDRESS SYSTEM
- B. I-MD-3010.00-5510-760-PPT-001 - GENERAL CRITERIA FOR TELECOMMUNICATIONS DESIGN
- C. I-ET-3010.2D-1350-196-P4X-001 - ERGONOMICS REQUIREMENTS FOR TOPSIDES

5.11.2 Package shall be delivered with PAGA horns and cables installed and tested based on detail design done by SELLER.

5.11.3 SELLER shall be responsible for the design, supplying, installation and integration of the PAGA System items of its package, complying with all applicable requirements described in I-ET-3010.00-5518-767-PPT-002 - TOPSIDES PUBLIC ADDRESS SYSTEM for the entire system.

5.11.4 Since the PAGA network inside package to be designed is part of the entire system that is scope of SELLER detail design, SELLER shall ask BUYER any specific characteristics of the system, as well as the approval of the sound calculation memory and detailed design, to assure fully interoperability.

5.11.5 The acoustic horns and cables shall be designed by SELLER in 02 (two) different and independent groups A and B. Each of these groups shall be ended inside a proper interface box to be installed at the edge of the package, in accordance with the classifications zone and groups established by IEC / ABNT and SELLER.

5.11.6 SELLER shall be responsible for commissioning the PAGA network inside the package of its own scope of supply before the lifting of the package, when the system will be accepted by BUYER.

5.11.7 SELLER shall supply all needed facilities to test the PAGA network inside package before lifting.

5.11.8 Wherever there are closed areas in package module, they shall also be covered by UHF, LTE, and WLAN systems. So, SELLER shall make available MCT (Multi cable and pipe transit) for cables entrance and internal fixing supports for internal UHF and LTE antennas and their RF cables and industrial access points with their fiber optic cable and electrical cable. Such equipment and cables will be delivered by SELLER according to its detail design, if required.

5.11.9 Since the UHF Active Repeater, LTE and WLAN Systems are part of complete systems scope of SELLER, SELLER shall ask the BUYER any specific characteristics of infrastructure required and detailed design to assure interoperability and functionality inside closed areas of packages module.

**5.12 INSTALLATION REQUIREMENTS****5.12.1 Skid Details**

This section is only applicable for equipment that is built on a skid:

- A. The skid shall be designed to accommodate the entire equipment within the scope of supply. The skid shall be of rigid construction, which will not distort during

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hoisting, operation and shipment and shall withstand all moments and forces due to the vessel motion.

- B. All equipment shall be installed by SELLER over structural steel deck plate in position shown in I-DE-3010.2D-1422-942-P4X-001 – M-11 – WATER INJECTION AND SULPHATE REMOVAL UNIT – EQUIPMENT LAYOUT PLAN.
- C. All piping terminations shall be flanged.
- D. The set of equipment and their skids must be designed, arranged and assembled in such a way to allow the safe personnel access, operation, and maintenance.
- E. Lifting facilities shall enable lifting of the equipment with crane as a single point lift for transportation and installation. The design and manufacture of the lifting lugs shall be certified. The arrangement of equipment, piping and superstructure shall be such that the center of gravity coincides approximately with the geometrical center of the skid. When lifting the skids, complete with all equipment mounted, beam deflection shall not exceed 1/400 L.
- F. The skid shall resist all sling forces, including both horizontal and vertical components of the applied sling angle (sling angles shall be within between 50° and 90° with the horizontal plane).
- G. Lifting beams, spreader bars, slings, shackles, etc. are within SELLER's scope of supply.
- H. Drip trays with drain connections shall be provided underneath equipment where significant spillage is likely to occur.
- I. The skid shall be welded to the supporting structures. Skid floor shall be made of plate material with a raised on-slip tread. Welds underneath skid beams shall be ground flush. Skid shall have two diagonally opposed earthing bars.

#### 5.12.2 Maintenance Lifting Beams

- A. All required maintenance lifting beams, complete with the necessary hoisting and lifting gear, shall be provided to facilitate safe and easy maintenance.
- B. All lifting beams shall overhang by at least 1.2 m into agreed lay-down areas.
- C. The deflection of the maintenance crane/hoisting beams shall not exceed 1/500 of the span length.
- D. All beams and lifting gear shall be subject to load testing, witnessed by BUYER representative and CLASS.

### 5.13 PAINTING

5.13.1 Painting requirements shall be according to I-ET-3010.00-1200-956-P4X-002 – GENERAL PAINTING.

5.13.2 Color code adopted shall be in accordance with DR-ENGP-I-1.15 – COLOR CODING.

## 6 NAMEPLATES

### 6.1 GENERAL

6.1.1 SELLER shall attach corrosion resistant stainless steel type 316 nameplates on each item of equipment in an accessible location, fastened with corrosion resistant stainless steel type 316 pins, and in Portuguese language.

6.1.2 For pressure vessels, columns and filters the nameplates shall be according to I-ET-

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3010.00-1200-540-P4X-001 – REQUIREMENTS FOR PRESSURE VESSELS DESIGN AND FABRICATION.

6.1.3 For the other equipment the nameplates shall include, as a minimum, the following information:

- A. Petróleo Brasileiro S.A. – PETROBRAS;
- B. Purchase order number;
- C. Manufacturer and year of build;
- D. Tag number;
- E. Service;
- F. Serial number;
- G. Main data for design, operation and testing (Power, Pressure, Volume, Temperature, Rotation, Flow rate), where applicable;
- H. Specific requirements;
- I. Installation identification;
- J. Driver power rating and speed, where applicable;
- K. Design code;
- L. Empty weight;
- M. NR-13 information (if applicable).

6.1.4 Valves, instruments and orifices shall be tagged with the applicable number only.

## 7 TAG NUMBERING

### 7.1 GENERAL

7.1.1 Tagging of all instruments, electrical, telecommunication, mechanical and piping items, including valves, shall be in accordance with the latest revision of I-ET-3000.00-1200-940-P4X-001 – TAGGING PROCEDURE FOR PRODUCTION UNITS DESIGN.

7.1.2 For main item tag numbers, refer to I-FD-3010.2D-1251-560-P4X-002 – SULPHATE REMOVAL UNIT (UT-1251002).

7.1.3 Tag numbers for remaining ancillary equipment shall be given after purchase order placement.

## 8 CERTIFICATION REQUIREMENTS

### 8.1 CLASSIFICATION SOCIETY CERTIFICATION

8.1.1 SELLER shall provide a CLASS Certificate of Compliance for the entire Unit.

8.1.2 In order to obtain the Certificate of Compliance all related CLASS activities and CLASS technical requirements are within the SELLER scope of work, as well as the all cost associated with it.

### 8.2 HAZARDOUS AREAS CERTIFICATION

8.2.1 All materials and equipment proper to be used in hazardous areas, shall have conformity certificates complying with: the latest revision of IEC 60079 and all its parts;



PORTARIA INMETRO Nº 115 (march 21<sup>st</sup>, 2022); and shall be approved by CLASS.

## 9 REPAIR

### 9.1 GENERAL

9.1.1 Welding repairs and heat treatments must be recorded and submitted for BUYER's approval.

## 10 INSPECTION, TESTING AND COMMISSIONING

### 10.1 GENERAL

10.1.1 SELLER is required to propose a program for inspection and testing of all supplied equipment for approval by BUYER, prior to commencement of work in accordance with document schedule. ITP shall be issued for the equipment that are part of the Unit.

10.1.2 Unless otherwise stated, all inspections and tests shall be performed at the workshop of SELLER in the presence of BUYER representative and CLASS surveyor as applicable.

10.1.3 Inspections and tests are an integral part of the order which will not be considered complete until such inspections and tests have been carried out in full and recorded in an inspection report that shall be part of data book.

10.1.4 BUYER shall issue an Inspection Release Certificate (IRC) only after completion of all required inspections and tests and after the manufacturing data books have been issued and approved.

### 10.2 PERSONNEL QUALIFICATION AND CERTIFICATION

10.2.1 Personnel qualification and certification shall be in accordance with I-ET-3010.00-1200-970-P4X-003 - REQUIREMENTS FOR PERSONNEL QUALIFICATION AND CERTIFICATION.

### 10.3 QUALITY AND INSPECTION

10.3.1 SELLER shall provide documented schedules with the estimated completion dates. These schedules shall be issued by the same time the drawings are submitted for approval, as indicated in the agreed document schedule.

10.3.2 BUYER reserves the right to inspect all items at any time during fabrication to ensure that the materials and workmanship are in accordance with this specification and all applicable documentation.

10.3.3 SELLER is responsible for the overall compliance of the Unit when it comes to the CLASS requirements, including certificates, work examinations and tests, as well as final inspection activities and shipment.

10.3.4 In addition to BUYER inspection, equipment such as valves and fittings, etc. shall be subject to all CLASS authority and may range from a review of SELLER's quality manual to a physical survey of SELLER's shop or end products.

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10.3.5 The CLASS inspector shall have the right to request inspections or examinations to ensure that the equipment complies with the relevant CLASS requirements. If examination reveals any deficiencies, SELLER shall bear the full cost of repair or replacement when necessary. Any repair work shall be approved by BUYER. The subsequent examination necessary to ensure the satisfactory manufacture of the equipment in question will be on behalf of the SELLER.

10.3.6 Except if approved by BUYER inspector, all equipment shall be presented for inspection in an unpainted state. SELLER shall provide notice to the inspector to witness the specified tests at least 2 (two) weeks in advance for Brazilian manufacturer and 3 (three) weeks for foreign manufacturer.

10.3.7 Manufacturing Survey Inspection shall be performed according to I-ET-3010.00-1200-972-P4X-006 - REQUIREMENTS FOR MANUFACTURING SURVEY INSPECTION.

10.3.8 Traceability of material shall comply with I-ET-3010.00-1200-978-P4X-005 - REQUIREMENTS FOR MATERIALS TRACEABILITY.

10.3.9 Equipment, piping and accessories under scope of NR-13 shall comply with I-ET-3010.00-1200-970-P4X-013 - COMPLIANCE WITH NR-13 AND SPIE REQUIREMENTS.

**10.4 WELDING AND WELDING INSPECTION**

10.4.1 All equipment (such as pressure vessels, filters, tanks, heat exchangers, pump, turbomachinery etc.), structures, valves and piping weldments shall be according to the requirements stated in I-ET-3010.00-1200-955-P4X-001 – WELDING.

10.4.2 Welding shall be carried out with procedures and welders qualified in accordance with Design Code and additional requirements stated in contractual technical specifications. Welding shall not be performed before qualified welding procedures specification have been approved.

10.4.3 Intermittent fillet welds are not permitted.

10.4.4 Welding inspection shall be according to the Design Code and additional requirements stated in the contractual technical specification, such as I-ET-3010.00-1200-200-P4X-115 – REQUIREMENTS FOR PIPING FABRICATION AND COMMISSIONING, I-ET-3010.00-1200-540-P4X-001 – REQUIREMENTS FOR PRESSURE VESSELS DESIGN AND FABRICATION, I-DE-3010.00-1400-140-P4X-004 – GENERAL NOTES FOR TOPSIDES STRUCTURES, etc.

**10.5 NON DESTRUCTIVE TEST**

10.5.1 NDT shall be according to the respective design Code and I-ET-3010.00-1200-970-P4X-004 - NON-DESTRUCTIVE TESTING REQUIREMENTS FOR METALLIC AND NON-METALLIC MATERIALS

10.5.2 Final NDTs, for acceptance purposes shall be carried out after completion of any post weld heat treatment (when applicable) and prior to paint application, hydrostatic testing, etc.

## 10.6 TESTING

10.6.1 The following tests shall be included in SELLER's scope:

- A. Pressure test (usually hydrostatic) of all vessels, heat exchangers, tanks and piping/valves;
- B. Electrical insulation and continuity checks on all wiring and earthing;
- C. Functional checks on all instruments and valves.

10.6.2 Hydrostatic testing shall be carried out in the presence of BUYER inspectors and shall include all pressure vessels, heat exchangers and applicable piping/valves.

10.6.3 All piping systems and equipment shall be drained and dried after hydrostatic testing.

10.6.4 Preservation to be applied shall be as detailed in I-ET-3010.00-1200-200-P4X-115 – REQUIREMENTS FOR PIPING FABRICATION AND COMMISSIONING.

## 10.7 ELECTRICAL

10.7.1 The following testing shall be carried out in the presence of BUYER inspectors and shall include:

- A. Insulation (MEGGER) test for cables, electric motors and electric panels shall be provided;
- B. Tests stated in the respective motors and power/control panel specifications.

## 10.8 PACKAGE INSPECTION

10.8.1 Unless waived by BUYER, the following inspections and checks shall be witnessed by BUYER inspector:

- A. Verification of equipment construction materials (vessels, heat exchangers, pumps, etc.) for conformity with the specification requirements;
- B. Verification of piping, fittings and valves conform to specification of materials and fabrication;
- C. Reports for all NDT performed on the pressure retaining parts (radiographic, dye penetrant, magnetic particles, and ultrasonic inspection);
- D. Approval of the relief valve settings and witness of their testing after setting;
- E. Review of Inspection and Test Records;
- F. A visual check noting:
  - That the thickness of the pressure retaining parts meets or exceeds the quoted design thickness;
  - Any repairs;
  - Dry-film thickness of applied coatings;
  - The general appearances, materials, workmanship and standard of finish;
  - Dimensional check;
  - Alignment to be demonstrated.

## 10.9 PACKAGE TEST

10.9.1 A full function test of completed package shall be performed. The satisfactory operation of all indicators, selectors and controllers shall be demonstrated.



10.9.2 The correct operation of all controllers, alarm and fault protection equipment and indicators shall be demonstrated and if necessary, fault simulations.

10.9.3 SELLER shall submit a FAT procedure with a test schedule covering all items within the scope of supply.

10.9.4 SELLER shall prepare a FAT procedure for the package and submit for BUYER approval.

10.9.5 FAT will be witnessed by BUYER representatives. SELLER shall advise BUYER of the test schedule at least 2 (two) weeks for Brazilian manufacturers /Sub-Suppliers and 3 (three) weeks for foreign manufacturers/Sub-Suppliers before the planned test dates. SELLER shall invite CLASS surveyor for FAT.

10.9.6 Acceptance of the FAT will not be considered as the final acceptance test of the package.

## **10.10 ASSEMBLY ASSISTANCE AND COMMISSIONING REQUIREMENTS**

10.10.1 SELLER is responsible for assembly supervision of the equipment, including the assembly of components to be delivery as loose parts (for example, some components of the pumps, like stuffing box; some internals of pressure vessels, etc.).

10.10.2 SELLER is responsible for pre-commissioning and commissioning supervision of the equipment/system. Final acceptance shall be on satisfactory completion of commissioning tests as specified by BUYER.

10.10.3 An Initial Service Safety Inspection shall be performed on the piping and on the static equipment of the Unit (pressure vessels, heat exchangers, and so on) once the Unit itself has been erected to its final location.

10.10.4 Requirements of I-ET-3010.00-1200-200-P4X-115 – REQUIREMENTS FOR PIPING FABRICATION AND COMMISSIONING shall be attended.

## **11 SELLER RESPONSIBILITY**

### **11.1 GENERAL**

11.1.1 SELLER shall assume sole contractual and total engineering responsibility for the package equipment.

11.1.2 SELLER's responsibility shall also include, but is not limited to:

- A. Technical responsibility for the entire scope of supply;
- B. Resolving all engineering questions and/or problems relating to design and manufacture;
- C. All coordination with manufacturers and collection of all details, drawings, calculations, and data to achieve optimum design and full submission of the documents requested in the specification;
- D. Providing details as requested of any sub-vendors relating to design and manufacture;
- E. To submit to the certifying authority the documentation as described in the latest edition of their rules for equipment on offshore facilities;

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- F. Installation at site by others, however, presence of supervision will be required;
- G. SELLER's responsibility shall also include Commissioning & Training for operation;
- H. Pre-Commissioning;
- I. Attend HAZOP meetings arranged by BUYER.

11.1.3 Any exclusion and/or alternative to what is specified in this Technical Specification, including the use of the SELLER's standard and exclusive technology, shall be presented in a Deviation List, subject to BUYER acceptance during the clarification phase, preceding the proposal presentation. Otherwise the requirements herein will be considered as "Agreed", and so required.

## 12 PREPARATION FOR SHIPMENT

### 12.1 MARKING

- 12.1.1 All items supplied to this specification shall be adequately marked for identification against a certificate or relevant test documentation. Marking shall be such that it will not damage or impair the component.
- 12.1.2 Items that cannot be identified shall be rejected. Rejected items may be re-certified by carrying out all relevant testing, with prior approval of BUYER.

### 12.2 SHIPMENT PACKING

- 12.2.1 Shipment packing preparation of the equipment shall be suitable for 24 months of outdoor storage from time of shipment.
- 12.2.2 All open ends of tubes on the equipment shall be treated and closed off by plastic caps and taped. Small bore threaded connections shall be taped over.
- 12.2.3 All carbon steel vessels, etc. shall be protected with corrosion inhibitor prior to shipment.
- 12.2.4 The package shall be protected from corrosion.
- 12.2.5 Vulnerable instruments shall be removed and packed separately for shipment.
- 12.2.6 Transportation bracing/support shall be used where necessary and shall be clearly identified as temporary.
- 12.2.7 All crates and boxes will contain sufficient moisture absorbing agent to avoid condensation.
- 12.2.8 SELLER shall specify any limitations applicable to the transport and installation phase.