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	JOB :	HIGH CAPACITY FPSO	
	AREA:	BÚZIOS	
<b>SRGE</b>	TITLE:		INTERNAL
	<b>OILY WATER SEPARATOR PACKAGE (SAO-5330501)</b>		ESUP

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DATE	DEC/28/20	MAR/31/21							
PROJECT	ENG	ENG							
EXECUTION	CXZ0	CXZ0							
CHECK	BYA6	BYA6							
APPROVAL	CYEL	CYEL							

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THIS FORM IS PART OF PETROBRAS N-381 REV.J ANNEX A – FIGURE A.1.


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## 1. INTRODUCTION

### 1.1. OBJECTIVE

The purpose of this technical specification is to describe the minimum requirements for the design, manufacturing, assembly, supply, installation, commissioning, and tests of OILY WATER SEPARATOR PACKAGE (SAO-5330501) in conformance with relevant regulations and High Capacity FPSO basic design documentation.

OILY WATER SEPARATOR PACKAGE (SAO-5330501) PACKAGE has the purpose to treat the Bilge Water Settling Tank (TQ-5330501) inventory and discharge the effluent to the sea within the limits stated by MARPOL requirements.

### 1.2. DEFINITIONS

**PACKAGE:** It is defined as an assembly of equipment supplied interconnected, tested and ready to operate, requiring only the available utilities from the Unit for the Package operation.

**PACKAGER:** It is defined as the responsible for project, assembly, construction, fabrication, testing and furnishing of the Package.

OILY WATER SEPARATOR PACKAGE (SAO-5330501) the package name.

**OWNER:** PETROBRAS.

All definitions are found on I-ET-3010.00-1200-940-P4X-002 – GENERAL TECHNICAL TERMS.

### 1.3. ABBREVIATIONS

CS Classification Society

FAT Factory Acceptance Tests

FPSO Floating Production Storage and Offloading Unit

SOS.....Supervisory and Operation System


SOS-HMI..... Human Machine Interface of SOS

## 2. NORMATIVE REFERENCES

### 2.1. INTERNATIONAL CODES, RECOMMENDED PRACTICES AND STANDARDS

The equipment will be designed and manufactured in accordance with the following codes and standards, if not mentioned otherwise.

- ANSI American National Standards Institute
- API American Petroleum Institute
- ASME American Society Of Mechanical Engineers

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- BGV German Safety Regulations
- DIN German National Standard Code
- EN European Standards
- ISO International Standard Organization
- IMO – International Maritime Organization
- IMO Resolution MEPC 107 (49)
- MARPOL Annex I – Reg. 16/5
- SOLAS II-1, Regulation 3-5, and MSC.1/Circ. 1379
- VDE / IEC German National Electric Standard Codes / International Electric Codes
- IEC 61892, INMETRO Resolution 179, May 18th 2010 and INMETRO resolution 89, February 23rd 2012
- Classification Society defined for the Hull scope.

## 2.2. BRAZILIAN CODES AND STANDARDS

- NR – Brazilian Federal Government Regulatory Norms (Normas Regulamentadoras NRs)
- NORMAM-01 – Normas da Autoridade Marítima para Embarcações Empregadas na Navegação em Mar Aberto;

## 2.3. CLASS APPROVAL AND CERTIFICATION

PACKAGE shall be designed, manufactured and tested according to the design reference documents, normative requirements and in accordance with the latest editions of Classification Society Rules, Regulations and Standards.

## 3. REFERENCE DOCUMENTS

REF DOC NUMBER	REF DOC NAME
<b>GENERAL</b>	
I-DE-3010.1Y-1200-942-P4X-001	GENERAL ARRANGEMENT
I-DE-3010.1Y-5400-94A-P4X-001	AREA CLASSIFICATION – GENERAL
I-ET-3000.00-0000-940-P4X-002	SYMBOLS FOR PRODUCTION UNITS DESIGN
I-ET-3A36.00-1000-941-PPC-001	METOCEAN DATA



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I-ET-3000.00-1200-940-P4X-001	TAGGING PROCEDURE FOR PRODUCTION UNITS DESIGN
I-ET-3010.00-1200-940-P4X-002	GENERAL TECHNICAL TERMS
I-RL-3010.1Y-1200-940-P4X-001	GENERAL SPECIFICATION FOR AVAILABLE UTILITIES
<b>CONSTRUCTION</b>	
I-ET-3010.00-1200-955-P4X-001	WELDING
I-ET-3010.00-1000-970-P4X-002	REQUIREMENTS FOR NDT
I-ET-3010.00-1200-955-P4X-002	REQUIREMENTS FOR WELDING INSPECTION
I-ET-3010.00-0000-970-P4X-001	REQUIREMENTS FOR PROCEDURES AND PERSONNEL QUALIFICATION AND CERTIFICATION
<b>HULL SYSTEMS</b>	
I-DE-3010.1Y-5330-944-P4X-001	BILGE, SLUDGE, BALLAST (AFT) AND GENERAL SERVICE SEAWATER SYSTEM
I-MD-3010.1Y-1200-940-P4X-027	DESCRIPTIVE MEMORANDUM - HULL SYSTEMS
<b>NAVAL</b>	
I-DE-3010.1Y-1350-960-P4X-002	CAPACITIES PLAN
I-ET-3010.1Y-1350-960-P4X-002	DESIGN REQUIREMENTS - NAVAL ARCHITECTURE
I-RL-3010.1Y-1350-960-P4X-009	MOTION ANALYSIS
<b>MECHANICAL</b>	
I-ET-3010.00-1200-300-P4X-001	NOISE AND VIBRATION CONTROL REQUIREMENTS
I-ET-3101.1Y-1200-500-P4X-003	MATERIAL SPECIFICATIONS FOR PRESSURE VESSELS AND TANKS



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I-ET-3010.00-1200-540-P4X-001	REQUIREMENTS FOR PRESSURE VESSEL DESIGN AND FABRICATION
I-ET-3010.00-1200-310-P4X-003	ASME B73 CENTRIFUGAL PUMPS SPECIFICATION
I-ET-3010.00-1200-310-P4X-002	POSITIVE DISPLACEMENT PUMPS SPECIFICATION
<b>PAINTING</b>	
I-ET-3010.00-1200-956-P4X-002	GENERAL PAINTING
DR-ENGP-I-1.15	COLOR CODING
<b>SAFETY</b>	
DR-ENGP-M-I-1.3	SAFETY ENGINEERING GUIDELINE
I-ET-3010.00-5400-947-P4X-002	SAFETY SIGNALING
<b>PIPING</b>	
I-ET-3010.1Y-1200-200-P4X-002	PIPING SPECIFICATION FOR HULL
I-ET-3010.00-1200-251-P4X-001	REQUIREMENTS FOR BOLTING MATERIALS
<b>ELECTRICAL</b>	
I-DE-3010.00-5140-700-P4X-003	GROUNDING INSTALLATION TYPICAL DETAILS.
I-ET-3010.00-5140-700-P4X-001	SPECIFICATION FOR ELECTRICAL DESIGN FOR OFFSHORE UNITS
I-ET-3010.00-5140-700-P4X-002	SPECIFICATION FOR ELECTRICAL MATERIAL AND EQUIPMENT FOR OFFSHORE UNITS
I-ET-3010.00-5140-700-P4X-003	ELECTRICAL REQUIREMENTS FOR PACKAGES FOR OFFSHORE UNITS
I-ET-3010.00-5140-712-P4X-001	LOW-VOLTAGE INDUCTION MOTORS FOR OFFSHORE UNITS
<b>INSTRUMENTATION AND AUTOMATION</b>	

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I-ET-3010.00-1200-800-P4X-002	AUTOMATION, CONTROL AND INSTRUMENTATION ON PACKAGE UNITS
I-ET-3010.1Y-1200-800-P4X-014	AUTOMATION INTERFACE OF PACKAGE UNITS
I-ET-3010.00-1200-800-P4X-013	GENERAL CRITERIA FOR INSTRUMENTATION PROJECTS
I-ET-3010.00-5520-888-P4X-001	AUTOMATION PANELS

Table 1 – Reference Documents

Note: Reference Documents latest revision shall be considered.

#### 4. DESIGN REQUIREMENTS


##### 4.1. DESIGN CONDITIONS

- 4.1.1. PACKAGE Equipment shall be designed for a 30-year life in a corrosive offshore environment without the need for replacement of any major component due to wear, corrosion, fatigue, or material failure.
- 4.1.2. PACKAGER shall design the equipment for the full range of operational conditions as specified in this technical specification.
- 4.1.3. PACKAGE Equipment shall be designed with the compliance of the normative and design requirements as stated in this specification and complying with the technical parameters stated on the above item 3 with the High Capacity FPSO design reference documents.
- 4.1.4. All elements of the PACKAGE shall be of proven design and well within the manufacturer's actual experience.

##### 4.2. SAFETY REQUIREMENTS

- 4.2.1. Personnel safety protection shall be provided according to Brazilian Regulatory Norms (NR) issued by Brazilian Government.
- 4.2.2. Warning signs in Brazilian Portuguese language shall be provided where risk of personnel injury exist.
- 4.2.3. Rotating equipment outer parts, such as pulleys, couplings, belts and flywheels, shall have rigid protection, manufactured with aluminum ASTM B211 and shall be capable of being easily removed.
- 4.2.4. In accordance with the requirements of SOLAS II-1, Regulation 3-5, and MSC.1/Circ. 1379, all equipment and material to be supplied by PACKAGER must be "asbestos free".



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4.2.5. Safety signaling shall be in full compliance with I-ET-3010.00-5400-947-P4X-002 – SAFETY SIGNALING.

4.2.6. Double block & bleed arrangements are required for isolation of equipment in piping classes of 300# and above.

4.2.7. PACKAGER shall comply with the requirements of NR-13 (Brazilian Government Regulation) on design and fabrication of all PACKAGE equipment or piping that stands under NR-13 norm and shall provide all corresponding documents.

### 4.3. NOISE AND VIBRATIONS

4.3.1. Noise and vibrations limits shall be in conformance with I-ET-3010.00-1200-300-P4X-001 – NOISE AND VIBRATION CONTROL REQUIREMENTS.

### 4.4. MOTIONS AND ACCELERATION

4.4.1. All equipment shall be able to withstand with the UNIT subjected to 100-year return period environmental conditions.

4.4.2. All equipment shall be able to operate with the UNIT subjected to 1-year return period environmental conditions.

4.4.3. All environmental conditions are defined in I-ET-3A36.00-1000-941-PPC-001 – METOCEAN DATA, at any draft from fully loaded to the minimum loaded / ballasted condition.

4.4.4. For the Hull loading conditions details and the maximum designed operational trim and heel inclinations refer to I-ET-3010.1Y-1350-960-P4X-002 – DESIGN REQUIREMENTS - NAVAL ARCHITECTURE.

4.4.5. For the design data and information regarding motion requirements refer to I-RL-3010.1Y-1350-960-P4X-009 – MOTION ANALYSIS.

4.4.6. PACKAGE is also to withstand inertial forces during transportation from construction site to the final offshore location.

## 5. PACKAGE SCOPE OF SUPPLY

### 5.1. SCOPE OF SUPPLY

5.1.1. PACKAGE shall be supplied as the following minimum components:

	TAG	Description	Qty
1	SAO-5330501	Oily Water Separator Package	1x100%
2	PN-SAO-5330501	Oily Water Separator Package Control Panel	1x100%


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Table 2 – Scope of Supply

5.1.2. In addition to the table 2, PACKAGE shall supply the following items:

- a. An oily water pump.
- b. An oil / water separation section.
- c. A sludge pump for the sludge removal to the Hull sludge system.
- d. Oily water discharge monitor.
- e. Filtering system where necessary.
- f. Skid mounted with drip trays, lifting lugs, earthing lugs and flanged drains with valves.

5.1.3. All necessary ancillaries, control panel, electrical and instrumentation installation, interconnecting piping, fittings and valves within the limits of skid.

5.1.4. All other parts or components required for safe and suitable operation of the system.

## 5.2. EQUIPMENT LOCATION

5.2.1. PACKAGE will be installed on Engine Room: a closed and non-classified compartment as defined on I-DE-3010.1Y-5400-94A-P4X-001 – AREA CLASSIFICATION – GENERAL.

5.2.2. I-DE-3010.1Y-1200-942-P4X-001 – GENERAL ARRANGEMENT and shall be used as reference for equipment location.

## 6. PACKAGE SPECIFICATION

### 6.1. OILY WATER SEPARATOR PACKAGE (SAO-5330501)


6.1.1. PACKAGE shall be designed for continuous operation at full load duty, unless otherwise stated in the process data sheets.


6.1.2. PACKAGE Equipment shall be designed to perform the bilge water suction from the structural tank Bilge Water Settling Tank (TQ-5330501) installed inside the Engine Room with a minimum flow rate of 5 m<sup>3</sup>/h with the maximum oil content of 500 ppm.

6.1.3. PACKAGE shall discharge the bilge water to overboard with a maximum oil content of 15 ppm, as required by IMO Resolution MEPC 107 (49) requirements and MARPOL Annex I – Reg. 16/5.

6.1.4. SAO-5330501 shall be IMO type approved.

6.1.5. SAO-5330501 shall have a control system to activate an alarm on SOS-HMI with

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<p>set for oil content in water of 15 ppm or more. After alarm activation, the following actions shall be taken by the system:</p> <ol style="list-style-type: none"> <li>a. Automatic redirection of oily water to the Bilge Water Settling Tank (TQ-5330501) and automatic interruption of the oily water discharge to the sea.</li> <li>b. After the redirection concluded the pump shall be automatically stopped.</li> <li>c. The automatic redirection of the oily water to the Bilge Water Settling Tank (TQ-5330501) in conjunction with the discharge interruption shall be performed by a three-way valve.</li> <li>d. The Three-way vale shall be supplied by PACKAGER. This valve shall be installed on SAO-5330501 inside the PACKAGE limits and upstream the discharge line of the SAO-5330501 to the overboard.</li> </ol> <p>6.1.6. An oily water discharge monitoring and alarm shall be supplied by PACKAGER and installed in the Oil Water Separator (SAO-5330501) PACKAGE. This system shall comply with the following requirements:</p> <ol style="list-style-type: none"> <li>a. One (1) sampling collecting point in the Oil Water Separator overboard discharge.</li> <li>b. One (1) oil cell with range between 0 and 30 ppm of oil.</li> <li>c. Oil cell shall be IMO type approved to attend the MARPOL requirements.</li> </ol> <p>6.1.7. Oily Water Separator PACKAGE shall have protection and control devices for the safe operation of the system.</p> <p><b>6.2. GENERAL</b></p> <p>6.2.1. PACKAGE shall be PACKAGER's standard design, provided it covers the requirements of this specification. Prototypes are not acceptable.</p> <p>6.2.2. PACKAGER shall assume full unit responsibility for the complete PACKAGE, including drivers and all auxiliaries.</p> <p>6.2.3. The utility requirements and consumption of the equipment shall be clearly defined by the PACKAGER.</p> <p>6.2.4. The Oily Water Separator Package (SAO-5330501), including all auxiliary equipment, shall be assembled to the maximum extent possible and pre-checked in PACKAGER's shop, allowing shipment to the conversion yard with minimal fieldwork.</p> <p>6.2.5. The Oily Water Separator Package (SAO-5330501) shall be manufactured, inspected, and verified to comply with all specifications mentioned in Section 2 and 3 of this document and on the CS regulations.</p> <p>6.2.6. Dissimilar materials shall be isolated to avoid galvanic corrosion.</p>			


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- 6.2.7. The assembly shall be designed in such a way to permit:
- a. Easy accesses for maintenance of all instruments, valves and other components.
  - b. Access for the maintenance and removal of any part of the Unit.
- 6.2.8. PACKAGE weight and dimensions shall be minimized.
- 6.2.9. Each PACKAGE component and respective accessories shall be resistant to the marine environment and shall follow manufacturer standard.
- 6.2.10. The PACKAGER shall furnish drawings and procedure for handling and installation of the Units and specify the required devices for the Units maintenance, such as davits, monorails, etc.
- 6.2.11. Manufactures to supply Data Sheets filled out with all details on the whole of the equipment mounted on the unit. Data Sheets shall contain technical characteristics of equipment such as: type, capacity, flow rates, pressures, temperatures, materials, diameters of connections, dimensions, weight, air, water and electric consumption, location of center of gravity, electric power rating and such other information as may be deemed necessary.
- 6.2.12. PACKAGE shall be connected, wired and supplied as a complete unit, ready for installation and operation.


## 7. GENERAL REQUIREMENTS


### 7.1. ELECTRICAL REQUIREMENTS

- 7.1.1. All electrical equipment installed in hazardous areas (see Area Classification documentation) or installed outdoors and kept on during emergency condition (ESD) shall be certified according to IEC 61892, INMETRO Resolution 179, May 18th 2010 and INMETRO resolution 89, February 23rd 2012.
- 7.1.2. All electrical signal connections for external interconnection with the panel shall be clustered in junction boxes with at least IP-56 level of protection, located inside the panel and grouped according to the different types of signals involved.
- 7.1.3. Electrical equipment and material shall comply with requirements of I-ET-3010.00-5140-700-P4X-002 – SPECIFICATION FOR ELECTRICAL MATERIAL AND EQUIPMENT FOR OFFSHORE UNITS.
- 7.1.4. Electrical induction motors shall comply with requirements of I-ET-3010.00-5140-712-P4X-001 – LOW-VOLTAGE INDUCTION MOTORS FOR OFFSHORE UNITS.
- 7.1.5. Concerning electrical system voltages and quantity of feeders for motors, panels and auxiliaries, centrifugal pumps shall be fed according to definitions of I-ET-3010.00-5140-700-P4X-003 – ELECTRICAL REQUIREMENTS FOR PACKAGES FOR OFFSHORE UNITS.


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<p>7.1.6. Power lighting and grounding installations inside the package shall comply with requirements of I-ET-3010.00-5140-700-P4X-003 – ELECTRICAL REQUIREMENTS FOR PACKAGES FOR OFFSHORE UNITS.</p> <p>7.1.7. Grounding installations shall comply with I-ET-3010.00-5140-700-P4X-001 – SPECIFICATION FOR ELECTRICAL DESIGN FOR OFFSHORE UNITS and I-DE-3010.00-5140-700-P4X-003 – GROUNDING INSTALLATION TYPICAL DETAILS.</p> <p><b>7.2. INSTRUMENTATION AND AUTOMATION REQUIREMENTS</b></p> <p>7.2.1. PACKAGE shall be protected with all necessary instruments to operate safely, adequately and without interruption in a tropical marine environment.</p> <p>7.2.2. The instrumentation and control design shall fulfill the requirements of the following technical specifications:</p> <ul style="list-style-type: none"> <li>i. I-ET-3010.00-1200-800-P4X-002 – AUTOMATION, CONTROL AND INSTRUMENTATION ON PACKAGE UNITS.</li> <li>ii. I-ET-3010.00-1200-800-P4X-013 – GENERAL CRITERIA FOR INSTRUMENTATION PROJECTS.</li> </ul> <p>7.2.3. The minimum requirements for the adequate interfacing of the PACKAGE Automation and Instrumentation System with the UNIT are described on I-ET-3010.1Y-1200-800-P4X-014 – AUTOMATION INTERFACE OF PACKAGE UNITS.</p> <p>7.2.4. For the control and automation panels design requirements I-ET-3010.00-5520-888-P4X-001 – AUTOMATION PANELS shall be considered.</p> <p><b>7.3. PAINTING REQUIREMENTS</b></p> <p>7.3.1. Painting and coating in accordance with I-ET-3010.00-1200-956-P4X-002 – GENERAL PAINTING and DR-ENGP-I-1.15 COLOR CODING.</p> <p>7.3.2. All components shall be delivered fully painted/coated, unless otherwise indicated on this specification.</p> <p>7.3.3. The performed pre-treatment and complete coating shall be in accordance with the paint manufacturer's data sheets.</p> <p><b>7.4. MECHANICAL, PIPING AND ACCESSORIES</b></p> <p>7.4.1. All PACKAGE interconnection piping shall comply with the requirements of ASME B31.3.</p> <p>7.4.2. PACKAGE piping and accessories of the skid mounted equipment shall be in accordance with the specification ASME B31.3.</p> <p>7.4.3. Piping flanges according to the ASME B16.5.</p>			

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<p>7.4.4. The use of concentric type Butterfly Valves are not permitted.</p> <p>7.4.5. Sampling point / facilities shall be provided complete with necessary fittings and valves, and the design should reflect the nature of the fluids being sampled.</p> <p>7.4.6. Pumps shall comply with the requirements of I-ET-3010.00-1200-310-P4X-003 – ASME B73 CENTRIFUGAL PUMPS SPECIFICATION or I-ET-3010.00-1200-310-P4X-002 – POSITIVE DISPLACEMENT PUMPS SPECIFICATION.</p> <p>7.4.7. All pressure vessels shall comply with the requirements of I-ET-3010.00-1200-540-P4X-001 – REQUIREMENTS FOR PRESSURE VESSELS DESIGN AND FABRICATION.</p> <p>7.4.8. For Hull piping and valves specification refer to I-ET-3010.1Y-1200-200-P4X-002 – PIPING SPECIFICATION FOR HULL.</p> <p>7.4.9. For bolts and nuts refer to I-ET-3010.00-1200-251-P4X-001 – REQUIREMENTS FOR BOLTING MATERIALS.</p> <p><b>7.5. SKIDS LAYOUT AND FOUNDATION REQUIREMENTS</b></p> <p>7.5.1. PACKAGE components detailed on item 5.1 which are supplied assembled on skids shall follow the below minimum requirements.</p> <p>7.5.2. PACKAGE skid structure shall be designed to withstand the design conditions mentioned on item 4.4 and also to ensure the lifting conditions on manufacturing site and shipyard. Lifting lugs shall be provided according to PACKAGER lifting procedure.</p> <p>7.5.3. Skid foundation structural steel components shall be designed and fabricated in accordance with AISC ASD.</p> <p>7.5.4. The Skid main frame shall be all welded construction. Structural skid welds, including lifting facilities shall be continuous and shall comply with AWS D1.1 (structural welding code) and CS Rules.</p> <p>7.5.5. Skid structure shall be designed to be welded to the supporting structure unless otherwise specified.</p> <p>7.5.6. PACKAGE skid layout and arrangement shall be designed to provide sufficient access to pumps, instruments, equipment, and control panels so as to ease the operability and maintenance with safe conditions. Instruments and valves shall be installed on a suitable height to allow safe access for monitoring, operation, and maintenance.</p> <p>7.5.7. All necessary maintenance davits, monorails, padeyes or trolleys shall be provided to ensure the safe and easy maintenance conditions.</p> <p>7.5.8. Access ladders, platforms, gratings and any other access device shall be metallic type and designed according to PACKAGER / MANUFACTURER standard and to the industrial recognized international codes.</p>			

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<p>7.5.9. PACKAGE skid shall have a drip pan to collect drained water from the equipment with drain flanges for the connection with the Hull draining system.</p> <p>7.5.10. PACKAGE Equipment and components shall be located entirely within the skids / equipment base perimeter, including all equipment, piping, valves, electrical, instrumentation and controls.</p> <p><b>7.6. AVAILABLE ON BOARD</b></p> <p>7.6.1. For other utilities available onboard refer to I-RL-3010.1Y-1200-940-P4X-001 – GENERAL SPECIFICATION FOR AVAILABLE UTILITIES.</p> <p><b>7.7. NAMEPLATES AND TAG NUMBERING</b></p> <p>7.7.1. PACKAGER / MANUFACTURER Equipment shall have nameplates in Brazilian Portuguese language, made of stainless steel AISI 316L, with 3 mm minimum thickness and fixed by stainless steel (AISI 316L) bolts or fasteners on visible and accessible location.</p> <p>7.7.2. Tagging of all instruments, electrical, mechanical and piping items, including valves, shall be carried out.</p> <p>7.7.3. Tags shall be supplied with the number and description in the Brazilian Portuguese Language, unless otherwise stated in the technical data sheets.</p> <p>7.7.4. For TAG numbering refer to I-ET-3000.00-1200-940-P4X-001 – TAGGING PROCEDURE FOR PRODUCTION UNITS DESIGN.</p> <p>7.7.5. For Instrumentation tagging the ISA –5.1 and N-1710 shall be followed.</p> <p><b>8. PACKAGE MANUFACTURING</b></p> <p><b>8.1. GENERAL</b></p> <p>8.1.1. All materials and equipment supplied by PACKAGER / MANUFACTURER shall be brand new (not overhauled), field proven, free from defects and accepted by Owner and the Classification Society.</p> <p>8.1.2. Materials and equipment shall be manufactured according to internationally recognized standards for the offshore oil drilling and production industries and shall be in conformance with the Basic Design and Agreement specifications and requirements.</p> <p>8.1.3. Field proven definition: Systems and equipment shall demonstrate satisfactory operation at least in 3 floating offshore installation units, operating under process conditions (pressure, flow, capacity and similar fluids) for a minimum of 24,000 hours. For rotating equipment, they must demonstrate operation with fluid, flow and discharge pressure similar to the design. Unproven designs or prototypes (including components) without offshore service will not be accepted.</p> <p><b>8.2. QUALITY ASSURANCE AND CONTROL SYSTEM</b></p>			

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<p>8.2.1. PACKAGER shall submit his Quality Assurance / Quality Control handbook to HULL SUPPLIER for information.</p> <p>8.2.2. Engineering, fabrication and manufacturing shall conform to good manufacturing practices. Quality system according to ISO 9001 in relevant extent shall be in place and implemented.</p> <p><b>8.3. WELDING AND NDT</b></p> <p>8.3.1. All equipment, structures and piping welds shall be performed according to the requirements described in the latest revision of I-ET-3010.00-1200-955-P4X-001 – WELDING.</p> <p>8.3.2. Welding shall be carried out with procedures and welders qualified in accordance with ASME Section IX. Welding shall not be performed before qualified welding procedures have been approved.</p> <p>8.3.3. Intermittent fillet welds are not acceptable.</p> <p>8.3.4. Welding inspection and NDTs shall be performed according to the requirements described in the latest revision of</p> <ul style="list-style-type: none"> <li>○ I-ET-3010.00-1000-970-P4X-002 – REQUIREMENTS FOR NDT and</li> <li>○ I-ET-3010.00-1200-955-P4X-002 – REQUIREMENTS FOR WELDING INSPECTION.</li> </ul> <p>8.3.5. Qualification and Certification for procedures and personnel shall be in accordance with I-ET-3010.00-0000-970-P4X-001 – REQUIREMENTS FOR PROCEDURES AND PERSONNEL QUALIFICATION AND CERTIFICATION.</p> <p>8.3.6. Final NDTs, for acceptance purposes shall be carried out after completion of any post weld heat treatment (when applicable) and before the applications of painting, hydrostatic testing, etc.</p> <p>8.3.7. For pressure vessels, additional requirements are established in I-ET-3010.00-1200-540-P4X-001 – REQUIREMENTS FOR PRESSURE VESSEL DESIGN AND FABRICATION.</p> <p>8.3.8. The following minimum NDT requirements shall be executed for pressure vessels:</p> <ul style="list-style-type: none"> <li>▪ 100% RT on all main seam welds plus the pipe / flange connections on nozzles.</li> <li>▪ 100% UT on nozzle to shell connections.</li> <li>▪ 100% MP (CS) or LP (SS) on all weld attachments to pressure retaining parts.</li> <li>▪ 100% LP on all weld overlays.</li> </ul>			



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### 8.3.9. Welding Repair

8.3.9.1. Repair by welding or by plugging shall be undertaken only when permitted by the material specification and shall only be applied with the procedures specified.

8.3.9.2. A major weld repair shall always be followed by a suitable heat treatment.

8.3.9.3. Details of all major weld repairs and heat treatment shall be recorded and reported to OWNER.

## 8.4. INSPECTION AND TESTS


8.4.1. PACKAGER / MANUFACTURER shall develop and implement an Inspection and Test Plan (ITP) containing hold points, review and witness points following the schedule of the PACKAGE inspections, tests and events accordingly.

8.4.2. PACKAGE inspection, tests and events shall be attended by the MANUFACTURER, PACKAGER, HULL SUPPLIER, CS and OWNER inspection team whenever necessary.

8.4.3. PACKAGE shall be tested according to the design codes, applicable industry standards, CS Rules and any other one requirement stated on this technical specification.

8.4.4. Unless waive by OWNER, the following PACKAGE inspections and checks shall be witnessed by OWNER inspector:

- i. verification of equipment construction materials (vessels, heat exchangers, pumps, etc.) for conformity with the specification requirements.
- ii. verification of piping, fittings and valves conform to specification of materials and fabrication.
- iii. reports for all NDT performed on the pressure retaining parts (radiographic, dye penetrant, magnetic particles and ultrasonic inspection).
- iv. approval of the relief valve settings and witness of their testing after setting.
- v. review of Inspection and Test Records.
- vi. visual check noting:
  - That the thickness of pressure retaining parts meets or exceeds the quoted design thickness.
  - Any repairs.
  - Internal coating is complete (dry-film thickness as quoted).

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- General appearance, materials, workmanship and finish standard are acceptable.

vii. Electrical tests as:

- a MEGGER test for cables and electric motors.
- all tests stated in the respective motors and power / control panel respective specifications.

**8.5. FACTORY ACCEPTANCE TEST (FAT)**


8.5.1. FAT is a set of functional and performance tests to be executed in any equipment, electrical, instrumentation and telecom panels or any other commissionable item carried out on the PACKAGER / MANUFACTURER factory or in specialized test facilities, in order to demonstrate its compliance with the project specifications and allow its release to shipyard.


8.5.2. For Factory Acceptance Test (FAT) minimum scope requirements:

- i. Pressure test (usually hydrostatic) test of all vessels, heat exchangers, tanks, pumps, pipes and valves.
  - o Note: All piping systems and equipment shall be drained and dried after hydrostatic testing.
- ii. Performance test, NPSH test and Mechanical running test of all pumps.
- iii. Electrical continuity checks on all wiring and earthing.
- iv. Functional checks on all instruments and valves.
- v. Alarms and Equipment Protection Tests.
- vi. All other equipment tests and factory checking to be carried out according to the FAT procedure approved by parts.

8.5.3. For Factory Acceptance Test (FAT) event invitation e reports:

- i. OWNER, CS and HULL SUPPLIER shall be communicated about the FAT event following ITP and the fabrication schedule. FAT invitation schedule shall be negotiated during PACKAGE kick-off meeting on the detail design phase.
- ii. PACKAGER shall issue the FAT procedure for all parts involved as OWNER, HULL SUPPLIER and CS, where applicable, and submit to them for approval.
- iii. PACKAGER shall issue the FAT report with all test results and duly signed or stamped by all parts that witnessed the FAT and with the test reference documentation attached.

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<p>iv. Acceptance of FAT will not be considered as the final acceptance test of the PACKAGE.</p>			
<p><b>8.6. PRE-COMMISSIONING AND COMMISSIONING</b></p>			
<p>8.6.1. PACKAGER / MANUFACTURER shall be required to provide any necessary support for installation, assembly, pre-commissioning and commissioning of the PACKAGE either at a shore based fabrication yard or onboard the FPSO.</p>			
<p>8.6.2. PACKAGER / MANUFACTURER is responsible for assembly supervision of the PACKAGE equipment, including the assembly of components to be delivered loose (for example, some components of the pumps, like stuffing box, etc.).</p>			
<p>8.6.3. Final acceptance will be on satisfactory completion of commissioning tests as specified by OWNER.</p>			
<p><b>9. PACKAGE DELIVERY REQUIREMENTS</b></p>			
<p><b>9.1. PRESERVATION, PACKING AND TRANSPORTATION</b></p>			
<p>9.1.1. PACKAGER / MANUFACTURER shall ensure all the conditions and practices of preservation, packing and transportation are fulfilled and following the PACKAGE / Equipment specific and technical characteristics recommendations.</p>			
<p>9.1.2. PACKAGER / MANUFACTURER shall submit to HULL SUPPLIER the PACKAGE preservation requirements and recommendations with all necessary considerations for the PACKAGE Equipment preservation during the UNIT whole design life.</p>			
<p>9.1.3. Preservation and packing shall be proper for transportation and storage in a marine environment and protected against moisture and damage during transport, handling and lifting.</p>			
<p>9.1.4. In any case, suitable preservation and protective measures shall be provided to prevent equipment deterioration prior to entering into service.</p>			
<p>9.1.5. All packing shall be clearly marked for shipping, including lifting points, gross weight, dimensions and center of gravity.</p>			
<p>9.1.6. All sea fastening and temporary supports used on the equipment for shipment shall be clearly identified.</p>			
<p>9.1.7. PACKAGER / MANUFACTURER shall ensure that all loose valves, tubes and instruments are supplied with plastic caps.</p>			
<p>9.1.8. PACKAGER / MANUFACTURER shall also ensure that all electric panels and motors will be supplied with Volatile Corrosion Inhibitor (VCI) impregnated plastic protection or similar, and external plug for space heater connection.</p>			
<p>9.1.9. PACKAGER / MANUFACTURER shall provide clear and comprehensive instructions on the exterior of all packages advising the necessary warning</p>			

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notices for unpacking, handling and installing the equipment on arrival at destination.

9.1.10. The equipment shall be thoroughly cleaned internally and be free of all loose foreign materials.

- i. The preparation shall make the equipment suitable for outdoor storage in a coastal tropical climate from the time of Shipment.
- ii. If there is a risk of damage to valves and other appurtenances during transportation, they shall be disconnected and tagged. All components shall then be securely packed as above.
- iii. Spare parts and tools to be packed separately and clearly marked "Spare Parts" and "Tools" respectively.

## 9.2. SPARE PARTS, CONSUMABLES AND TOOLS

9.2.1. All equipment / material consumable and spare parts recommended by PACKAGER / MANUFACTURER for the construction, testing, commissioning, pre-operation and start-up phases.

9.2.2. All spare parts recommended or required by the CS, such spare parts will be delivered together with the relevant equipment;

9.2.3. All special tools required for construction, pre-commissioning, commissioning and all levels of maintenance and operation.


9.2.4. Spare parts list recommended by PACKAGER / MANUFACTURER for two years of operation.

## 9.3. DOCUMENTATION

9.3.1. Drawings and Weight Control

For Engineering Documentation minimum requirements:

- i. PACKAGER / MANUFACTURER design drawings shall show all necessary dimensions and details required for interface information and installation.
- ii. Clearances for maintenance shall be shown on the drawings.
- iii. Drawings and documents shall be clear and completely legible with all text in the English language.
- iv. Instruction manuals for operation and maintenance of the PACKAGE equipment shall be provided in Portuguese language.
- v. Drawings are only accepted when signed by PACKAGER as checked and approved. All revised editions of drawings or documents shall show the

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revisions clearly marked up, the issue date and PACKAGER's checked and approved signatures.

- vi. PACKAGER / MANUFACTURER shall produce a weight / center of gravity data sheet considering each PACKAGE component with the respective assembly dry and operational weight and CoG.
  - o Note: Operational weight means the component dry weight added to the respective component fluid weight on operational condition.
- vii. PACKAGER shall send in advance all recommendations for PACKAGE installation, maintenance and commissioning.

#### 9.3.2. Data Book

PACKAGER shall issue a PACKAGE / Equipment Data Book to be delivered to HULL SUPPLIER for approval. Data Book minimum content shall be as the following:

- i. Certified drawings, data sheets, technical specifications, performance curves and calculation memorandum.
- ii. Construction, maintenance and operating manuals, instructions for preservation and commissioning, and all catalogs, including of the sub-suppliers.
- iii. All certificates of materials and equipment, certificates of electrical cables and equipment to hazardous areas, all tests, destructive and non-destructive examinations, test reports (including FAT), certificates and reports of classification society, procedures for welding qualifications and welding processes.
- iv. The documentation requested by Brazilian law NR-13, subdivided for equipment (if applicable).
- v. The documentation requested by Brazilian law NR-10, subdivided for equipment (if applicable).

Data Book delivery standard and conditions including number of parts and sections, number of printed and electronic copies will be further defined by OWNER on detail design phase.

#### 9.4. TRAINING

- 9.4.1. PACKAGER shall provide training to qualify OWNER technicians for operation and maintenance (install, dismantle, replace parts, make adjustment, etc.) of each equipment.