



REFERENCE DOCUMENTS

I-DE-3000.00-1357-962-PPC-005-REV. C  
 DE-0000.00-6620-962-PBK-047-REV.0

GENERAL NOTES

- 1- ALL DIMENSIONS ARE SHOWN IN MILLIMETERS EXCEPT WHERE NOTED.
- 2- WHITE BELT PAINTED ALL AROUND.
- 3- PAINT PETROBRAS SYMBOL ON BOTH SIDES OF EACH FIN.
- 4- THE TORPEDO'S CENTER OF GRAVITY MUST BE LOCATED AT A MINIMUM DISTANCE OF 12500 mm AND THE MAXIMUM 13100mm FROM PAIDEYE WELD TO TUBE.
- 5- MINIMUM ANCHOR DRY WEIGHT: 120 Ton. (INCLUDING CAST STEEL PAIDEYES AND PIG IRON BALLAST) AND MAXIMUM ANCHOR DRY WEIGHT: 123 Ton.
- 6- ALL STEEL PLATES TO BE ASTM A131 GRADE AH36 OR ASTM A572 GRADE 50, COMPLYING WITH CHARPY V-NOTCH IMPACT TEST REQUIREMENTS ACCORDING TO ASTM A370 WITH MINIMUM AVERAGE ENERGY 34 J LONGITUDINAL OR 24 J TRANSVERSE @ 0°C, OR SIMILAR MATERIAL WITH THE SAME REQUIRED PROPERTIES, EXCEPT FOR TIP PLATES.
- 7- TIP PLATES TO BE ASTM A572 GRADE 50 OR SIMILAR. CONE TIP TO BE CAST STEEL ASTM A148 GR 8050.
- 8- ALL WELDS ACCORDING TO AWS D1.1 AND CLASSIFICATION SOCIETY REQUIREMENTS. ALL WELDS ARE FULL PENETRATION, EXCEPT OTHERWISE NOTED.
- 9- ALL GROOVE WELDING TO BE INSPECTED AS FOLLOWS:
  - 100% ULTRASONIC.
  - 100% MAGNETIC PARTICLE.
  - ADDITIONAL MAGNETIC PARTICLE TEST MUST BE PERFORMED ON PAIDEYE WELD ROOT.
- 10- THE MINIMUM DENSITY OF PIG IRON BALLAST FOR THE DESIGN PROPOSITION MUST BE 6.85 Ton/m<sup>3</sup>.
- 11- PIN MATERIAL SAE-1045, ALIGN PIN AND TUBE EXTERNAL SURFACES.
- 12- BALLAST TYPE 3 CAN BE LESS TALL FOR C.G. ADEQUATION.
- 13- GREEN BELT PAINTED ALL AROUND.
- 14- THE REGIONS IN CONTACT WITH THE SYNTHETIC LIFTING SLINGS SHALL BE SMOOTH, FREE FROM WELD SPLASH, ETC. FORWARD FIN'S SHARP EDGES MUST BE GROUND SMOOTH.

REV.	DESCRIPTION	DATE	EXEC.	CHECK	APPROV.
0	FOR CONSTRUCTION	30/NOV/12	KENUPP	OLAUO	ELISABETH

THE INFORMATION CONTAINED IN THIS DOCUMENT IS PETROBRAS PROPERTY AND MAY NOT BE USED FOR PURPOSES OTHER THAN THOSE SPECIFICALLY INDICATED HEREIN.  
 THIS FORM IS PART OF PETROBRAS N-38/REV. J ANEX. A - FIGURE A.3.  
 MICROSTATION/J71-DE-3000.00-1357-962-PPC-041-.dgn

CLIENT: E & P			
JOB: FLOATING PRODUCTION UNITS			
AREA:			
TITLE: TORPEDO PILE T-120 PIB PIG IRON BALLAST			
DESIGN	CENPES	EXEC.	KENUPP
SCALE	INDICATED	CHECK	OLAUO
DATE	30/NOV/12	APPROV.	ELISABETH
Nº I-DE-3000.00-1357-962-PPC-041		SHEET 1 of 1	