



1. Work in conjunction with procedures "3000-D-EC-000-MC-SPE-0052-00-02C" & "3000-D-EC-000-MC-SPE-0053-00_02".
2. For manufacturing tolerances, see "3000-D-EC-000-MC-SPE-0053-00_02C", GOST 23118-2012.
3. Welds are designated according to ISO 2553-2017.
4. Weld seams should be welded according to the approved WPS welding technology, no. 478RHI-PR-02-04.
5. Ensure that the edges of the annular welds overlap by 2 mm on each side, the height of the reinforcement for thicknesses: S less than 25mm – 3mm(h) – for S 25-50 mm: – 4 mm (h); for S more than 50 mm – 5 mm(h).
6. Control of ring welded joints UT-100%, RT-100%, VT-100%, PT-100%, according to procedures no. 478-RHI-PR-08-08, no. 478-RHI-PR-08-09, no. 478-RHI-PR-08-05, no.478-RHI-PR-08-06.
7. Marking of not less than 200 mm from the end, according to technological instructions No. 25001 01395041 00381.
8. To cause a checkpoint-8 PCs located 90 degrees apart, a diameter of 3mm, depth of 2mm shock method at a distance of 80mm from the ends.
9. Ensure a minimum distance of at least 100 mm from the mounting parts to the longitudinal pipe weld.

| Спецификация деталей/Parts specification | | | | | | | | | | |
|---|-------------------------------|--|--------------------------------------|---------------------------------------|---|---|--|--|---|---------------------|
| № | Длина, мм Length, mm | Масса, кг/Weight, kg | | Марка стали Steel grade | Иден-ный номер SPMat Ident. Code | Отплата Payitem | Система покрытия 1 Coating System 1 | Система покрытия 2 Coating System 2 | Система Покраски Painting System | Примечание Notes |
| | | шт./pcs | общ./Total | | | | | | | |
| 35 | 1797 | 1838.0 | 1838.0 | | C355-6-Z35 | P10035 | 362102.03 | | | |
| нап. металла, кг/ Weld metal weight, kg: 11 | | | | 1838.0 | Общий вес кг/ Total weight kg: 1839.1 | | | | | |
| 30 | 1797 | 1582.1 | 1582.1 | | C355-6-Z35 | P10030 | 362102.03 | | | |
| нап. металла, кг/ Weld metal weight, kg: 0.7 | | | | 1582.1 | Общий вес кг/ Total weight kg: 1582.8 | | | | | |
| 25 | 7198 | 5303.2 | 5303.2 | | C355-6 | P100025 | 362102.02 | | | |
| нап. металла, кг/ Weld metal weight, kg: 18 | | | | 5303.2 | Общий вес кг/ Total weight kg: 5305.0 | | | | | |
| | | ABS-Assembly : ABS-Block : ABS-Workpack : ABS-ErectionBlock : | | AS 2P1/2 BL 2P1/1 - EB 2P1/1 | | 079322C-AWP1B-200-CS-KMD-04400-AS-003 079322C-AWP1B-200-CS-KMD-04400-BL-001 079322C-AWP1B-200-CS-KMD-04400-EB-001 | | | | |
| Ведомость элементов в составе SubAssembly/List of Assembly from SubAssembly | | | | | | | | | | |
| Марка Mark | | Чертеж Марку Assembly drawing | | | | Кол-во, шт Q-ty, pcs | Масса, кг Weight, kg | Площадь окрашиваемой поверхности, м2 Paint Surface area, m2 | | |
| K.2P1LP-016/2 | | 079322C-AWP1B-200-CS-KMD-04400-M-2011 | | | | 1 | 1838.0 | 7.0 | | |
| K.2P1LP-024/1 | | 079322C-AWP1B-200-CS-KMD-04400-M-2013 | | | | 1 | 1582.1 | 7.0 | | |
| K.2P1LP-032/1 | | 079322C-AWP1B-200-CS-KMD-04400-M-2012 | | | | 1 | 5303.2 | 27.9 | | |
| Масса нап. металла, кг Weld metal weight, kg | | 8.6 | Вес марки, кг Assembly Weight, kg | | 8723.3 | Итого, кг Total, kg | 87319 | Общая площадь окрашиваемой поверхности, м2 Total painting surface area, m2 | | 42.0 |

This document contains proprietary information and is intended for use by Arctic LNG2 LLC authorized personnel or companies only. The copyright of this document is vested in Arctic LNG2 LLC. All rights reserved. It is the responsibility of each user of this document to verify the current revision prior to use.

В настоящем документе содержится конфиденциальная информация, которая предназначена для использования исключительно уполномоченными сотрудниками ООО «Арктик СПГ 2» или уполномоченными компаниями. Авторские права на настоящий документ предоставляются ООО «Арктик СПГ 2». Все права защищены. Каждый пользователь настоящего документа обязан проверять текущую редакцию перед применением.

