

port openings.

OD	Port Opening (max)
<400 mm	0.5 mm
>400 mm	1.0 mm

12. The fusion machine and pipe support rollers shall not misalign during repositioning of equipment during the stringing process.
13. The machines shall be kept in good operating condition. Proper maintenance and frequent checking of machine systems shall be carried out. There shall be adequate gauges and readouts installed and monitored to ensure successful welding.
14. Each weld on the string shall be numbered to match the reference number on the data printout for each weld. Samples taken shall likewise be numbered and catalogued for traceability.
15. Beads shall not be trimmed on the internal faces to be flush with the pipe surface.

#### **2.2.4 Drilling Fluid**

- A. Use a water bentonite based slurry lubrication material. Mix slurry in a tank equipped with a proper high shear mixer blade to properly disperse bentonite powder (agglomerates). Agitate the drilling fluid continuously during the drilling operation.
- B. Pass drilling fluid from the drilling operations through cleaning machines before returning to the drilling fluid tank for re-use with freshly mixed drilling fluid. Constantly monitor the drilling fluid to ensure that it is within the submitted data and method statement approved by the Engineer.
- C. Provide a berm of minimum height of 300mm around the drilling fluid mixing chamber and all other areas subject to drill fluid spills where considered necessary by the Engineer for environmental protection. Height and layout of berm to be sized to ensure no spill over of the maximum spillage of drilling fluid. Provide supporting calculations for approval.

### **2.3 Part 3 Execution**

#### **2.3.1 General**