

The testing program

Annex No 2 to Tender terms & Conditions

The program is intended to monitor performance parameters of the Dual Column and Boom manipulators system at site. For that purpose, cylinder shaped pieceparts will be presented for further welding and checking them in the prescribed methods. The next cylinder pieceparts will be provided:



Table 1

Thickness t, mm	H, mm	D, mm	Q-ty, pcs.	Joint preparation
4	250	1900	4	Square but-but
6	250	1900	8	Square but-but
8	250	1900	4	Square but-but
10	250	1900	4	Square but-but
15	250	1900	4	Single-V groove

Material of pieceparts- AISI304.

Material of welding wire- AISI304 or AISI316, particular diameter is to be chosen by the Suplier.

4 pcs. of the cylinders of one thickness will be tack-welded into one body so as three longitudinal welds could be performed.

Position of welding (ASME / AWS)- 2G.

The best one of the three welds would be considered as representative and weld parameters as well as quality will be monitored.

NDT methods: VT and RT.

Weldment assesment standard: ISO 5817 level B.

Weldment quality results interpretation: acceptable/not acceptable

During weldment of the representative weld, the next parameters should be kept and controled:

Table 2

Test No	Thickness t, mm	No of passes	Processes used	Equipment used	Weld speed cm/min to be achieved
1	4	1	PAW	The main CAB	≥30
2	6	1	PAW	The main CAB	≥23
3	6	1 PAW 2 TIG (3 in total)	PAW+TIG	The main CAB+ the suppl. CAB simultaneously	≥18 PAW keyhole ≥30 TIG
4	8	1	PAW	The main CAB	≥18
5	10	2	PAW keyhole+PAW with wire	The main CAB	≥18 PAW keyhole ≥18 PAW wire
6	15	not indicated	PAW+TIG	The main CAB+ the suppl. CAB simultaneously	≥18 PAW keyhole ≥30 TIG

The testing program is considered successfully passed when all 6 tests meet the next 2 conditions:

1. At least one complete seam of each thickness gets evaluation after RT: acceptable
(10% of all length of the seam is to be tested and 100% of T seam-intersections)
and
2. the RT passed weld was performed under conditions set in the Table 2.