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**TECHNICAL JOB
SPECIFICATION**

562/1

REVISION 0

DATE 05/04/2011

HIGH PRESSURE (HP) TRANSMISSION SYSTEMS

FLANGES

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QUALITY ASSURANCE PAGE
CHANGES LOG
REVISIONS LOG

0	05-04-2011	FIRST ISSUE	PQ DPT	V.G.
Rev. No	Rev. Date	REASON FOR CHANGE	Made By	Approved By

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REFERENCE DOCUMENTS

- Job Spec. No. 970/2
[Shop Inspection of Equipment and Materials for NGT project]
- Std. Dwg. No. STD-00-51-08
- ELOT EN 1759-1 [Flanges and their joints. Circular flanges for pipes, valves, fittings and accessories, class-designated. Steel flanges, NPS 1/2 to 24]
- ELOT EN 10045-1
[Charpy impact test on metallic materials; part 1: test method]
- ELOT EN 583 series
[Non-Destructive testing – ultrasonic examination]
- ASME B16.5 "Pipe Flanges and Flanged Fittings"

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1.0 **SCOPE**

1.1 **ITEM**

Steel flanges.

1.2 **SERVICE**

Sweet, natural gas with sporadic passage of water and glycol.

1.3 **ADDITIONAL INFORMATION**

Additional technical information may be given in the Material Requisition and should be read in conjunction with this material specification. Any conflict between requirements of this Specification and Material Requisition supplementary design data or Codes shall be referred to Owner for clarification, before proceeding with the fabrication of the affected part.

Flange Manufacturer/Vendor shall be responsible to design, fabricate and supply flanges in accordance with the requirements of applicable documents. In no event, however, dimensions thickness etc are to be less than those required by standards.

2.0 **GENERAL REQUIREMENTS**

2.1 **STANDARD**

As per **ELOT EN 1759-1**. For flanges with DN>600 not covered by this standard, dimensions given in ASME B16.5 applies.

2.2 **MATERIAL**

The flange material shall be in accordance with ELOT EN 1759-1 table 3b and shall be given in the relevant Material Requisition and Data Sheet.

Verification of mechanical properties shall include impact resistance. One set of three Charpy V-notch specimens shall be obtained in accordance with **ELOT EN 10045-1**.

Testing shall be carried out at -20°C. Minimum average absorbed energy shall be 31 Joules, lowest single > 24 Joules

Repair by welding shall not be permitted.

In any case the flange material shall have specified minimum yield strength and impact toughness not less than the abutting pipe or piping component.

2.3 **PRESSURE RATING**

As per Material Requisition.

See Material Requisition for details of design pressure, design factor, corrosion allowance and abutting pipe dimensions and Material Specifications.

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2.4 **TYPE**

Welding neck or blind.
As per Material Requisition.

2.5 **FACING**

Raised Face.

2.6 **SIZE**

As per Material Requisition.

2.7 **BORE**

As per Material Requisition, (specified by wall thickness).

2.8 **HEAT TREATMENT**

Only normalizing is allowed.

2.9 **NON DESTRUCTIVE TESTING**

Welding neck flanges DN > 350 shall be ultrasonically examined in accordance with **ELOT EN 583 series**.

2.10 **TOLERANCES**

Welding neck flanges DN > 350 shall, in addition to **ELOT EN 1759-1**, fulfill the following tolerances :

- inside diameter of welding ends shall be within + 1.6 mm of abutting pipes inside diameter
- thickness of the hub shall nowhere be less than the minimum calculated thickness

2.11 **FINISH**

Flanges DN >350 shall be free of injurious defects as defined in **ELOT EN 1759-1**.

2.12 **SURFACE TREATMENT**

Soluble rust-preventive varnish.

2.13 **MARKING**

As per **ELOT EN 1759-1**. Flanges shall additionally bear Owner Supply Contract Number.

2.14 **PACKING**

Flanges shall be bundled by bolting together or secured by wire of suitable strength passed through the bolt holes.

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3.0 SUPPLEMENTARY REQUIREMENTS

3.1 GENERAL

The following Supplementary Requirements (SR1, SR2, SR3 and SR4) shall not apply unless specifically requested in the Material Requisition.

Further requirements, if specifically mentioned in the Material Requisition, shall be valid. In case of conflict between such requirements and the requirements contained herein, the former shall prevail.

3.2 SUPPLEMENTARY REQUIREMENTS - SR1

Blind flanges shall be furnished with removable and threaded lifting eyes placed in the flange edge if the weight of the flange exceeds 50 kg. Thread size shall not exceed 1/3 of flange edge thickness. Other thread data shall be as specified in **ELOT EN 1759-1**.

3.3 SUPPLEMENTARY REQUIREMENTS - SR2

Bolt holes in welding neck flanges shall be threaded over entire length to accommodate mating flange bolts.

Thread size, series and class shall comply with **ELOT EN 1759-1** and the bolt diameter data of the applicable Template Table.

3.4 SUPPLEMENTARY REQUIREMENTS - SR3

Blind flanges shall be furnished with a drilled and threaded centre hole designed to accommodate a vent screw as shown on DESFA Std Dwg. No. STD-00-51-08.

Vent screw and safety splint will be supplied with the blind flange.

3.5 SUPPLEMENTARY REQUIREMENTS - SR4

Blind flanges shall be furnished with a drilled and threaded centre hole according to **ELOT EN 1759-1**.

3.6 SUPPLEMENTARY REQUIREMENTS - SR5

Notch toughness (impact testing) shall be satisfied according to para 2.2 here above at test temperature -20°C, or at the minimum design temperature whichever is lower.

4.0 TECHNICAL DOCUMENTATION

4.1 QUANTITY

Four copies of each inclusive of original for all Documents and Certificates. Also electronic files of all Documents and Certificates must be submitted by Contractor to the Owner.

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4.2 DOCUMENT REQUIREMENTS

4.2.1 WITH TENDER

Information about type of varnish offered and recommended method for future removal of varnish.

4.2.2 AFTER AWARD OF CONTRACT

For flanges DN > 350 design calculations in accordance with **ELOT EN 1759-1**.

4.2.3 ON DELIVERY

Flange Certification Package.

5.0 INSPECTION AND CERTIFICATION

Inspection requirements are defined in the following documents :

- a. Material Requisition.
- b. **Job Spec. No. 970/2** "Shop Inspection of Equipment and Material for NGT Project".
- c. Relevant Project Specifications.
- d. Inspection Clauses of Applicable Codes.

Inspection procedures to be followed, are detailed in Owner document "Inspection and Test instructions".