



Exploration & Production

GENERAL SPECIFICATION

STRUCTURAL

GS EP STR 202

Cast Materials for Steel Structures

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1. Scope

This specification defines the COMPANY's minimum general requirements for the manufacture and supply of cast structural materials to be used in the construction of steel structures or parts of thereof.

This specification covers exclusively carbon steel materials.

This specification shall be read in conjunction with **GS EP STR 201**, **GS EP STR 301**.

Where required, this specification shall be used in conjunction with a Project Particular Specification (PPS) detailing the additional tests and requirements or the possible modifications to the present specification, based on the particular design conditions or the local legislation of the structural project.

Regarding the multiple cases of use of cast products, if estimated necessary for service by COMPANY, COMPANY may impose complementary or more stringent requirements than those described hereafter.

Contractor shall issue a manufacturing procedure at the bid stage, including full technical features of the proposed material/products as chemical composition, NDT, mechanical tests locations and expected results...

No deviations from the requirements stated in the present specification shall be permitted unless prior written approval has been obtained from the COMPANY.

Attention is drawn on certain materials that shall be subject to inspection and approval by a Third Party Inspection (TPI) or a Classification Society, according Purchase Order or Particular Project Specification.

If classification of the structure is required, any CONTRACTOR's request for clarification or deviation to Classification Society Rules shall be submitted to Classification Society through a form previously agreed. COMPANY shall be in copy of any Technical Query and Classification Society answers.

2. Reference documents

The reference documents listed below form an integral part of this General Specification. Unless otherwise stipulated, the applicable version of these documents, including relevant appendices and supplements, is the latest revision published at the EFFECTIVE DATE of the CONTRACT.

The order of precedence of the applicable documents shall be:

- The Purchase Order (PO)
- The Project Particular Specification (PPS)
- The present General Specification
- The codes and standards in reference.

Applicable Codes and Standards which are to be used in conjunction with this specification are stated in paragraphs hereafter.

Unless otherwise specifically indicated in writing by the COMPANY, the SUPPLIER shall work in accordance with the requirements specified herein and the applicable requirements of the latest editions at date of Contract award of the referenced Codes and Standards, whenever asked in the present specification.



Where this specification states no overriding requirements, the referenced Codes and Standards shall apply in full.

Standards equivalent to those referred to herein shall not be substituted without written approval of the COMPANY. Approval of equivalent standards will not, in any way, remove responsibility of the SUPPLIER to meet the requirements of the standards referred to and amended herein, in the event of conflict.

The SUPPLIER shall equip himself with copies of all the reference specifications referred to in this specification and shall make them readily available to all fabrication, testing and inspection personnel involved on the work.

Standards

Reference	Title
ASTM A 370	Standard test method and definitions for mechanical testing of steel products
ASTM E 112	Standard test method for determining Average grain size
ASTM E 125	References photographs for MPI of ferrous castings
ASTM E 186	Reference Radiographs for Heavy-Walled (2" to 4.5") steel castings
ASTM E 280	Reference Radiographs for Heavy-Walled (4.5" to 12") steel castings
ASTM E 446	Reference Radiographs for steel castings up to 2" in thickness
ASTM E 709	Practice for Magnetic Particle Examination
EN 473	Non destructive testing - Qualification and certification of NDT personnel - General principles
EN 10204	Metallic products - Type of inspection documents
EN 12680-1	Founding - Ultrasonic examination - Part 1: Steel castings for general purposes
EN 12680-2	Founding - Ultrasonic examination - Part 2: Steel castings for highly stressed components
ISO 6507-1	Metallic material - Vickers hardness test - Part 1: Test method

Professional Documents

Reference	Title
Not applicable	



Regulations

Reference	Title
Not applicable	

Codes

Reference	Title
ANSI/AWS A5.01	Filler metal procurement guideline
ANSI/AWS D1.1	Structural welding code - Steel

Other documents

Reference	Title
Not applicable	

Total General Specifications

Reference	Title
GS EP STR 201	Materials for offshore steel structures
GS EP STR 301	Fabrication of offshore steel structures

3. Definitions

Throughout this specification, the following definitions shall apply:

- **SUPPLIER** Means the company designated on the Purchase Order form or Contract as being the selected supplier of the said materials.
- **Manufacturer** Means the company or its sub-contractors selected by the COMPANY or the SUPPLIER (as applicable) as the Manufacturer of the said materials.
- **Purchaser** Means the COMPANY or the SUPPLIER (as applicable) which have placed the Purchase Order to the Manufacturer.
- **Inspector** Means the COMPANY's or SUPPLIER's representative(s), (as applicable), or member(s) from an Inspection Agency duly appointed by the COMPANY or the SUPPLIER (as applicable) to act as its representative(s) for the purpose of the contract.
- **PPS** Designates the Project Particular Specification as defined in para. 5 above.