

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**.

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.

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.

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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.

External Documents

Unless otherwise stipulated, the applicable version of these documents, including relevant appendices and addendums, is the latest revision published at the effective date of this document.

Reference	Title
ASME BPVC Section IX	Welding, Brazing, and Fusing Qualifications
ASTM A370	Standard test method and definitions for mechanical testing of steel products
ASTM E112	Standard test method for determining Average grain size
ASTM E125	Standard Reference Photographs for Magnetic Particle Indications on Ferrous Castings
ASTM E709	Standard Guide for Magnetic Particle Testing
AWS A5.01M/A5.01	Procurement guidelines for consumables - Welding and Allied Processes - Flux and Gas Shielded Electrical Welding Processes
AWS D1.1/D1.1M	Structural welding code - Steel
EN 10204	Metallic products - Type of inspection documents
ISO 148-1	Metallic materials - Charpy pendulum impact test - Part 1: Test method
ISO 4063	Welding and allied processes - Nomenclature of processes and reference numbers
ISO 6507-1	Metallic material - Vickers hardness test - Part 1: Test method
ISO 9712	Non-destructive testing - Qualification and certification of NDT personnel
NORSOK M-122	Cast structural steel

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Total General Specifications

Unless otherwise stipulated, the applicable version of these documents, including relevant appendices and addendums, is the latest revision published.

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 § 5 above.
Approval	Means the authorisation in writing given by the Company to the Supplier on a procedure or to proceed with the performance of a specific part of the work without releasing in any way the Supplier from any of his obligations to conform with the technical specifications, requisitions, etc. The words "Approve", "Approved" and "Approval" shall be construed accordingly.
Casting for Welding	Means a casting component dedicated to be welded. The welds considered are in the main load path.

4. Member classification

Unless approved by Company, cast products shall be considered as Special Category members according to **GS EP STR 301**.