

MV PAUL – STEEL REPAIR ON MAIN DECK 11.06.2017





MARINE & INDUSTRIAL ENGINEERING SOLUTIONS



Vessel Owner : Reederei Jens & Waller GmbH & Co. KG

Vessel Name : MV PAUL

Project Manager : Faruk AVCIOĞLU

Date : 10 – 11 JUNE 2017 (28 Hours)



INTERIM CERTIFICATE

Ship's Name: PAUL
LR/IMO Number: 9154866

Port of Survey: TUZLA

Date of Build: 09/01/1998
Port of Registry: MONROVIA
Gross Tons: 14762

Certificate Number: IST 1710123
First Visit: 11/06/2017
Last Visit: 11/06/2017

I have carried out the surveys listed below. All recommendations made by me have been dealt with to my satisfaction. I am recommending that class be maintained with new records as follows.

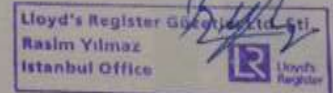
SURVEYS HELD	STATUS	NEW RECORD
CoC No. 29	Deleted	-
CoC No. 31	Deleted	-
CoC No. 32	Deleted	-
CoC No. 33	Deleted	-

7

The above recommendation is made subject to any outstanding conditions of class being dealt with as previously recommended.

Signed:
Surveyor to Lloyd's Register Gözetim Ltd.Şti.

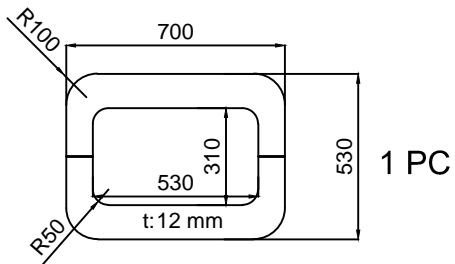
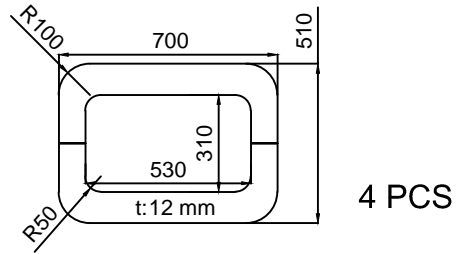
Date: 11/06/2017



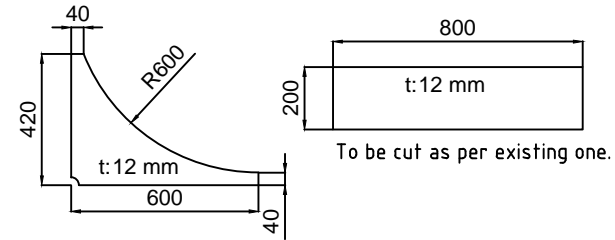
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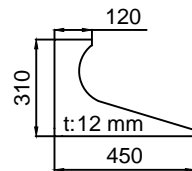
ITEM 4: EXCESSIVELY CORREDED AREAS



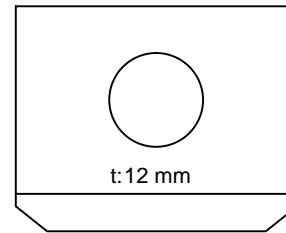
ITEM 3: CRACKS ON NO:3 HATCH COAMING



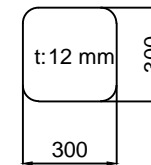
ITEM 5: CRACKS ON BULWARK BRACKET




NO:2 CH Bulhead Support



No:3 PS Bulwark Insert



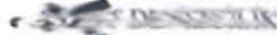
REV.	PROJECT NAME			DRW NAME		
	MV "PAUL"			DECK-STEEL-REPAIR		
DATE	DRW NO	REV.	Sheet	Format	Location	Work Order Nr
	MIP01 - 001	02	1/1	A4 Scale 1/1		
DESCRIPTION	 Marine&Industrial Engineering Solutions E-Mail : solution@marineindustry.net				Prepared by	Owner Approval
					FARUK-AVCIOGLU	
					Checked by	Date
					FARUK-AVCIOGLU	
Total Weight ~					Date
					KG. kg



WELDER APPROVAL TEST CERTIFICATE

**according to Bureau Veritas Rules
for the Classification of Steel Ships**

Employer's name and address :



Güzelyalı Mah. Elka Sok. No:15 34903

Pendik / İstanbul

MEHMET SEZGİN

Welder's
photograph
(optional)

Welder's name :

Identification :

1

Method of identification :

ID CARD

Date and place of birth :

KDZ.EREĞLİ / 24.12.1981

Production type	Steel hull	X	Aluminium alloys structures	Others (1)	
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(1) Approval conditions are based on following recognized standard :

Manufacturer's Welding Procedure(s) Specification number	
WPS 1-2-3-4	
Type of test and examination	Not performed / Performed & Test report number
Visual examination	PERFORMED - 16-PR 030/034
Radiography test	PERFORMED - 16-PR 030/026
Magnetic particle test	--
Dye penetrant test	PERFORMED - 16-PR 030/030
Macrography	---
Fracture test	---
Bend test	---
Others	---
Welding variables	Range of approval
Welding process	FCAW (136)
Welding consumable	GEKA ELKOR R71/CO2
Base material group	DH 36
Type of base product	STEEL PLATE
Type of weld joint	BUTT WELD
Range of thickness	≥5 mm
Welding positions	2G(PC), 3G(PF)
Backing and gouging condition	CERAMIC
Others	N.A.

This is to attest that the welder identified above has passed the approval tests, under the supervision of Bureau Veritas, in accordance with Rule Note NR 476 and Bureau Veritas Rules for the Classification of Steel ships.

Date and place of issue :

10.03.2016

This certificate expires on :

09.03.2018

Surveyor's name, signature and stamp :

HAKAN TIRYAKI



Employer's endorsement to confirm the validity for the following six months (date, name, position, signature) :

10.09.2016

10.03.2017

10.09.2017

This Certificate is delivered within the scope of the General Conditions of BUREAU VERITAS Marine Division. Any person not a party to the contract pursuant to which this document is delivered may not assert a claim against Bureau Veritas for any liability arising out of errors or omissions which may be contained in said document, or for errors of judgment, fault or negligence committed by personnel of the Society or of its Agents in establishment or issuance of this document, and in connection with any activities for which it may provide.



BV Rules on Material and Welding for the Classification
of Marine Units,
NR216, Ch 5, Sec 4,
Approval of Welding Procedures

WPS

WPS NO : 09

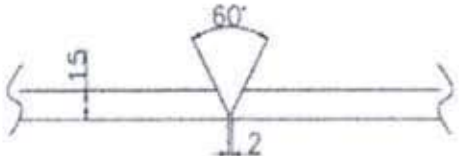
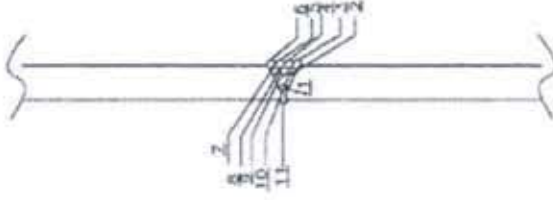
Date of Issue:02/08/2016

Page : 1/1

WELDING PROCEDURE SPECIFICATION

WPQR No	:05	Parent Material Grade	: DH36	Part 1	Part 2
Method of preparation and cleaning	:CNC :Grinding, Brushing	Range of Material thickness	: 7,5 mm	DH36	DH36
Joint Type	: V Butt Joint	Range of Outside diameter	: ---	---	---
Parent Material Spec.	:Carbon Steel	Range of Welding Position	: PC	PC	PC
Both Sides Welding with Back Gauging					

Weld Preparation Details

Joint design	Welding sequences
	

Welding Details

Run number	1	2-5	6	7-10	11
Welding process	SMAW (111)	SMAW (111)	SMAW (111)	SMAW (111)	SMAW (111)
Autom. Welding .nr. of heads	PC	PC	PC	PC	PC
.weaving	---	---	---	---	--
Filler metal:wire (W) or electrode (E)	---	---	---	---	--
.Designation	E	E	E	E	E
.Grade	ASKAYNAK WELDING				
.Description	3YH10				
.Diameter	AS B 248				
Shielding:Flux (F) or gas (G)	2,5 mm	3,25 mm	3,25 mm	3,25 mm	3,25 mm
.Power flux .description	---	---	---	---	---
.type and trade name	---	---	---	---	---
.Gas flux .description	---	---	---	---	---
.type and trade name	---	---	---	---	---
.Backing .flow rate (l/mn)	---	---	---	---	---
.Shielding .flow rate (l/mn)	---	---	---	---	---
.Plasma	---	---	---	---	---
Tungsten electrode: type/size	---	---	---	---	---
Type of current	---	---	---	---	---
Electrode or wire polarity	DC	DC	DC	DC	DC
Current (A)	+	+	+	+	+
Voltage (V)	90	110	110	115	115
Travel speed S (cm/min)	19	20	21	20	20
Wire feed speed (cm/min)	6	7	7	7	7
Heat input (J/cm) = [k x V x A x 60] / S	---	---	---	---	---
Interpass temperature in °C (min/max)	13680	15085	15840	15771	15771
Welding equipment trade mark / type	LINCOLN				

Pre heat	NO	Temperature°C	Holding Time.....
Post heating	NO	Temperature°C	Holding Time.....
Post Weld Heat treatment	NO	Temperature°C	Holding Time.....

Prepared by Representative

Name: Tunçer KAYIKCI


Signature: 

Stamp: 

Endorsed by BV Surveyor

Name: Hakan TIRYAKI

Signature: 

BV Stamp: 



BV Rules on Material and Welding for the Classification
of Marine Units,
NR216, Ch 5, Sec 4,
Approval of Welding Procedures

WPS

WPS NO : 08

Date of Issue:02/08/2016

Page : 1/1

WELDING PROCEDURE SPECIFICATION

WPQR No :04
Method of preparation and cleaning :CNC
Grinding, Brushing
Joint Type : V Butt Joint
Parent Material Spec. :Carbon Steel
Both Sides Welding with Back Gauging

Parent Material Grade : DH36
Range of Material thickness : 7,5 mm
Range of Outside diameter : ---
Range of Welding Position : PF

Part 1 : DH36
Part 2 : DH36
30 mm

PF PF

Weld Preparation Details

Joint design	Welding sequences

Welding Details

Run number	1	2	3	4	5
Welding process	SMAW (111)	SMAW (111)	SMAW (111)	SMAW (111)	SMAW (111)
Autom. Welding .nr. of heads	PF	PF	PF	PF	PF
.weaving	---	---	---	---	---
Filler metal:wire (W) or electrode (E)	---	---	---	---	---
.Designation	E	E	E	E	E
.Grade	ASKAYNAK WELDING				
.Description	3YH10				
.Diameter	AS B 248				
Shielding:Flux (F) or gas (G)	2,5 mm	3,25 mm	3,25 mm	3,25 mm	3,25 mm
.Power flux .description	---	---	---	---	---
.type and trade name	---	---	---	---	---
.Gas flux .description	---	---	---	---	---
.type and trade name	---	---	---	---	---
.Backing .flow rate (l/mn)	---	---	---	---	---
.Shielding .flow rate (l/mn)	---	---	---	---	---
.Plasma	---	---	---	---	---
Tungsten electrode: type/size	---	---	---	---	---
Type of current	---	---	---	---	---
Electrode or wire polarity	DC	DC	DC	DC	DC
Current (A)	+	+	+	+	+
Voltage (V)	90	110	110	115	115
Travel speed S (cm/min)	19	20	21	21	20
Wire feed speed (cm/min)	6	10	10	10	10
Heat input (J/cm) = [k x V x A x 60] / S	---	---	---	---	---
Interpass temperature in °C (min/max)	13680	10560	11088	11592	11040
Welding equipment trade mark / type	LINCOLN				

Pre heat NO
Post heating NO
Post Weld Heat treatment NO

Temperature°C Holding Time.....
Temperature°C Holding Time.....
Temperature°C Holding Time.....

Prepared by Representative

Endorsed by BV Surveyor

Name: Tuncer KAYIKCI

Name: Hakan TIRYAKI

Signature

Signature:

Stamp

BV Stamp

No: 15 P...
T...
w...



УКРАИНА
UKRAINE



П А О "АЛЧЕВСКИЙ МЕТАЛЛУРГИЧЕСКИЙ КОМБИНАТ"
PJSC "ALCHEVSK IRON & STEEL WORKS"

94202 г.Алчевск, ул. Шмидта, 4
тёл. : (06442) 7-34-25 7-33-20 7-33-82
факс: (06442) 7-33-76

94202, Ukraine, Alchevsk, Schmidt str. 4,
Tel: (06442) 7-34-25 7-33-20 7-33-82
Fax:(06442) 7-33-76

ЗАВОДСКОЙ СЕРТИФИКАТ КАЧЕСТВА №
MILL'S QUALITY CERTIFICATE №

62302

Дата
Date

05.12.2015

Лист из листов
Sheet 1 of 1 sheets

Свидетельство о приемочных испытаниях
Inspection certificate

EN 10204/3.2

Контракт №
Contract №

Заводской заказ №

Manufacturer's production order №

4060

Заказчик:

Customer:

Вагон №
RW-car №

53447728

LOT 1

Наименование товара: Description of goods:	горячекатаный стальной лист с обрезными кромками hot rolled steel plates with sheared edges	Стандарт: Правила ABS для стальных судов-2015 Standard: ABS Rules for steel Vessels-2015 ASTM A6/A6M-09
Марка стали Grade of steel	AB/A	

Состояние поставки:
Delivery condition:

горячекатаный
as-rolled

№ позиц. Item	Номера плавков Cast №	Номера партий Test №	Размеры, мм Dimensions, mm			Количество товара, шт/мест Quantity/pcs	Теоретический вес, тн Theoretical weight, m.t.
			Толщина Thickness	Ширина Width	Длина Length		
5	15K11692	12278	12	2000	8000	7	10,549
5	15K11692	12279	12	2000	8000	32	48,224
5	15K11692	12280	12	2000	8000	4	6,028
Total quantity (pcs):						43	
Total theoretical weight (m.t.):							64,801

Выплавка : конверторный способ производства
 Steelmaking process : basic oxygen steel making
 Способ разливки: непрерывнолитые слябы
 Casting method: continuous cast slabs

Заводской сертификат качества №
 Mill's quality certificate №

62302

Номер плавки Cast №	Химический состав, % Chemical composition, %						Chemical composition, %						C+Mn/6 X100			
	C	Mn	Si	S	P	Cr	Ni	Cu	Al	N	V	Mo		Ti	As	Nb
15K11692	14	66	20	10	19	3.7	1.3	1	26			7.8				25

РЕЗУЛЬТАТЫ ИСПЫТАНИЙ TEST RESULTS

№ партии test №	Испытание на растяжение и ударный изгиб Tensile and impact test										Исходные данные Initial data						
	Размеры образца D.m. of specimen		Отбор образца Specimen			Температура испытаний Test temperature C°	Предел текучести Yield point ReH N/mm ²	Предел прочности Tensile strength Rm N/mm ²	Относ. удлинение Elongation Lo=200 %	Сужение Reduction of area Z %	1=(J) 2=(J/sm ²) 3=(%) 4=	Энергия удара KU Energy Absorption Ударная вязкость KCU Impact strength Волокнистая составляющая Shear Fracture Твердость Hardness HB	Изгиб Bend				
	толщина thickness, mm Ø	ширина width, mm	Место, Location	Направление Direction	Положение Position												
	Значения Values																
12278	12	25		Т		+20	311	457	28.0								
12279	12	25		Т		+20	306	457	28.5								
12280	12	25		Т		+20	306	454	28.0								

Маркировка: сделано в Украине, № заказа, АВ/А, размеры, № плавки, № партии, URKMEZ, Turkey, 89012, тов. знак комбината, Заводской идентификационный номер (№ ID)

Marking: made in Ukraine, order №, АВ/А, dimensions, cast №, test №, URKMEZ, Turkey, 89012, mark of the works, Plant identification number (№ ID)

Клеймовка: № плавки, № партии, марка стали, тов. знак комбината, К, клеймо, Заводской идентификационный номер (№ ID)

Hard stamp: cast №, test №, grade of steel, mark of the works, К stamp, Plant identification number (№ ID)


Цвет. маркировка: одна серая полоса по торцам листа.

Color marking: one grey strip on transversal edges of the plate.

Complies with ABS requirements for grade A steel
 Check tests witnessed and satisfactory.

We hereby certify that the material described herein has been made to the applicable specification by the approved process (basic oxygen steel making) and tested in accordance with the requirements of ABS.

Surveyor of ABS


ATTACHMENT TO MATERIAL REPORT
 Подпись
 Signature
 KI 3058628 / 08 JAN. 2016


ОТК №3
 Для сертификатов
 КОМБИНАТ

 Штамп эксперта
 Expert's stamp