

## PART XIII. MATERIALS

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### 1. GENERAL

#### 1.1 APPLICATION

**1.1.1** The requirements of the present Part of the Rules apply to materials and products that are subject, in conformity with the other parts of the Rules, to the survey by the Register during manufacture.

Requirements pertaining to the choice and application of materials and products shall be found in the relevant parts of the Rules.

**1.1.2** In addition to the requirements of the present Part, materials and products shall meet the requirements of the relevant parts of the Rules.

**1.1.3** Materials, being part of a structure or product, on which the requirements not included in the present Part are imposed, due to conditions of their operation, as well as materials not regulated by the present Part, the chemical composition, mechanical and service properties of which were not considered by the Register for a particular application, shall be specially considered by the Register.

Materials being manufactured according to international and national standards or specifications, or other technical documentation may be permitted by the Register for a specific application, provided the requirements of the Rules are followed. In so doing standards, specifications or other technical documentation are recognized by the Register by means of its inclusion in the appropriate Register document

and/or by stamping.

The Register may permit the delivery of materials and products only according to the standards, specification or special technical documentation.

Given the distinctions between the above documentation and the Rules, materials testing and their assessment shall be carried out taking into account the strictest requirements.

**1.1.4** The materials and products subject to survey by the Register, which are listed below, shall be supplied with the Register certificates (refer to **1.3.1.4**) and shall be manufactured by the works, for which Recognition Certificates for Manufacturer were issued (refer to **1.3.1.4** and 1.3.5):

**.1** rolled products of hull structural steel, Z-steel and higher strength steel for welded structures;

**.2** rolled steel for Class I and Class II boilers and pressure vessels;

**.3** steel pipes for boilers, pressure vessels and Class I and Class II piping;

**.4** steel forgings and castings;

**.5** iron castings;

**.6** castings of non-ferrous and light alloys;

**.7** semi-finished products of non-ferrous and light alloys;

**.8** chains cables and ropes;

**.9** chain steel;

**.10** slabs, blooms and billets for rolling of shipbuilding and boiler steel, if they are produced at works not constituting a part of a rolling mill;

- .11 anchors;
- .12 wire ropes;
- .13 ropes of natural and synthetic fibre.

**1.1.5** The materials and products subject to survey by the Register, which are listed below, may be supplied with the manufacturer's certificates, provided the works have the quality system recognized by an authorized national or international organization or the Register and the Type Approval Certificate for the type of products manufactured (refer to Subsection 6.1):

- .1 materials for reinforced plastic structures;
- .2 laminated textiles;
- .3 retro-reflective materials;
- .4 plastic foams;
- .5 corrosion-resistant coatings;
- .6 plastic valves and pipes.

As an alternative to the quality system certified by the Register, product manufacture under direct survey of the Register is permitted upon an agreement with the Register (refer to 1.3.3). In this case, the products are supplied with the Register Certificate (refer to 6.1).

## **1.2 DEFINITIONS AND EXPLANATIONS**

Definitions and explanations concerning main terms of the Rules are stated in the General Regulations for the Classification and Other Activity and part I "Classification" of the Rules for Classification and Construction of Sea-Going Ships<sup>1</sup>.

For the purpose of the present Part the following definitions have been adopted.

**Recognized laboratory**

means a laboratory (centre) included into the List of laboratories (centres) having Recognition Certificates of Testing Laboratories.

**Recognized works** mean an enterprise included into the List of recognized (approved) materials and manufacturers.

**Product** — for the purpose of the present Part, semi-finished products, chain cables and accessories, and ropes as well.

**Acceptance (certification) tests** mean a test extent established by the Register Rules or documentation agreed upon by the Register for the products delivered under survey by the Register; the test results serve the basis for issue of the Register Certificates.

**Z-steel** is steel with guaranteed through thickness properties, which is intended for welded structures and can withstand considerable stresses perpendicular to the plate surface.

**A specimen** is a test piece of specified shape and size prepared from a sample and used for the determination of mechanical, technological and other properties of material by testing.

**Register stamp** means a brand, stamp or punch of a certain type specified by the Register applied to finished products, or to products during their manufacture, to confirm the fact of survey by the Register and identify the products with the documents issued for them.

**A semi-finished product** is an ingot, slab, bloom, billet intended for further rerolling, technological treatment.

**A semi-finished product** is

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<sup>1</sup> Hereinafter — part I "Classification".

a casting, forging, plate or tube and etc. intended for machining and technological treatment to acquire the finished state.

A batch is the limited number of semi-finished products and products, to which the results of statutory tests are extended.

Initial tests mean a particular scope of control tests specified in a special program approved by the Register and performed during the works survey exercised by the Register prior to issue of the Recognition Certificate for Manufacturer to the works.

A sample is a portion of a semi-finished product or a specially fabricated blank of which test specimens shall be machined.

Recognition Certificate for Manufacturer means a document confirming the compliance of the manufacturer's products and conditions of their manufacturer with the Register rules and warranting the introduction (entry) of the works into the List of recognized materials and manufacturers.

Manufacturer Certificate means a document of the works certifying the compliance of a particular volume of the specific type of product with the requirements of the order and confirming that the products are manufactured in compliance with production practice adopted at works.

The Certificate is issued by the manufacturer and shall be certified by signature of the person representing the Quality Control Department.

Type Approval Certificate means a document confirming the compliance of the products produced by the works with the Register

rules and certifying an entry of the works into the List of approved (recognized) materials and manufacturers.

Register Certificate means a document certifying the compliance of a particular volume of the specific type of product with the requirements of the Register rules or, if agreed upon specifically, with conditions of the order. The Certificate is issued by the surveyor to the Register surveying manufacture of the products.

Approval of quality system means an action of the Register, or other organization authorized by the Register, certifying that the necessary degree of certitude is obtained that the properly identified quality management system complies with the Register requirements. The Register-confirmed compliance of the works quality management system with the requirements of ISO 9000 or respective national requirements will be considered acceptable.

Lamellar tearing is breaking of welded structure components, made of rolled plates or pipes, due to considerable welding stresses and/or external loads applied in the direction perpendicular to the plate surface.

### **1.3 SURVEY**

#### **1.3.1 General**

**1.3.1.1** General provisions, regulating the scope and the procedure of survey shall be found in the General Regulations for the Classification and Other Activity.

**1.3.1.2** For this purpose the Register carries out survey of the works, which comprises the following:

- .1 review and recognition of

technical documentation specifying the properties and conditions of production;

.2 direct survey of production and the quality system of the firm (if required by rules);

.3 survey and conducting of check testing during manufacture of materials;

.4 issue of the survey results.

**1.3.1.3** All the procedures necessary for obtaining Register documents as specified in 1.1.4 and 1.1.5 (Recognition Certificate for Manufacturer and Type Approval Certificate), confirming the recognition of the firm and its products by the Register, shall be executed under survey of the Register, before the start of products manufacture.

Conditions for issuance of a Recognition Certificate for Manufacturer for a works are established in **1.3.1.4**, 1.3.5, and conditions for issuance of a Type Approval Certificate are established in 6.1.

Technical documentation is usually considered and approved before material testing is performed.

#### **1.3.1.4 Survey and recognition of firms manufacturing materials and products**

**1.3.1.4.1** In order to obtain recognition of a product and its production practice by the Register as those complying with the requirements of the Rules, and to obtain a Recognition Certificate for Manufacturer, a firm shall submit a relevant application to the Register.

General recognition procedure for a firm which manufactures materials and products specified in 1.1.4 includes following stages:

.1 review and analysis of the works application and its appendixes (refer to

**1.3.1.4.2**);

.2 works survey and conduction of check testing (refer to **1.3.1.4.3**);

.3 execution of a Recognition Certificate for Manufacturer (refer to **1.3.1.4.4**).

**1.3.1.4.2** The application shall be complemented with data on material purpose and production method, technical documentation for manufacturing including chemical composition, mechanical, handling or special properties, results of previously performed tests and practical application data (if any) which confirm that the material may be used for the intended purpose.

The application is complemented with data on production practice and quality control system for the surveyed object, as well as with a check testing program.

Presence of a quality assurance system complying with standards ISO 9002 or 9001, which is confirmed by a document issued by a competent body, may be accepted by the Register as an evidence of necessary degree of the works quality control systems, with no additional requirements in this field.

Check testing program shall be based on the requirements of the Rules and additional requirements of the Register, standards or other technical documentation enabling stable quality of products fabricated by a particular manufacturer.

**1.3.1.4.3** If the results of review of submitted data and technical documentation for materials production have been positive, and test program has been approved, the works is being surveyed and testing is being conducted.

Tests shall be conducted at manufacturing works or in Register recognized laboratories. Tests shall be conducted in accordance with a Register approved program in presence of the Register representative.

**1.3.1.4.4** If results of the testing are satisfactory, material use for the intended purpose is permitted, and the works is recognized as a manufacturer.

A Recognition Certificate for Manufacturer is executed as per 1.1.4. Its validity period and continuation conditions are determined in the course of the document execution.

Usually, validity period of the document may be continued based on the results of the previous validity period of the document. To provide a starting condition for such a decision, the manufacturer may confirm that issuance conditions of the Recognition Certificate for Manufacturer have not changed. If the firm has not been manufacturing products specified in the Certificate during the established period and has not provided a confirmation that issuance conditions of the Certificate has not changed, testing shall be conducted in the scope of initial tests in order to continue the Certificate validity.

**1.3.1.4.5** A detailed recognition procedure for manufacturers of hull structural steel is stated in 1.3.5.

Main provisions of this procedure may be applied to recognition of manufacturers of materials and products specified in 1.1.4 other than that made of hull structural steel, the requirements for which are given in this part.

### **1.3.2 Testing**

**1.3.2.1** Check testing in course of the firm recognition is carried out according to the program approved by the Register.

The program is compiled on the basis of the respective requirements of the present Part of the Rules, national or international standards and other technical documentation.

Testing under the Register technical supervision during manufacture of products shall be conducted in compliance with the requirements of the chapters of the present Part depending on the materials and products subjected to the tests and/or the standards and specifications recognized by the Register.

**1.3.2.2** The site and time of the prescribed tests shall be specified by the manufacturer in advance.

Sampling, test procedures, specimen cut-out procedures shall be effected in compliance with the applicable requirements of the Rules (according to Section 2).

Unless otherwise specified, the Register's representative shall brand the samples and specimens and the tests shall be carried out in his presence.

**1.3.2.3** Where the test results are unsatisfactory, unless otherwise specified in the relevant chapters, retesting shall be conducted with the following conditions being observed.

#### **1.3.2.3.1 Tensile test**

From the semi-finished product, which has failed the test, a double number of specimens may be machined from the locality nearest to the area, from which samples have been originally cut out.

In case the results of tests carried out on this double number of specimens are satisfactory, the semi-finished product

submitted to tests, as well as the relevant batch may be accepted.

If at least one specimen (from the additional set) yields unsatisfactory results, the semi-finished product submitted shall be rejected. However, the Register may accept the rest of the batch, provided the test results obtained on two other semi-finished products of the same batch prove satisfactory.

If one of two semi-finished products selected additionally yields unsatisfactory results, the whole batch shall be rejected.

#### **1.3.2.3.2 Impact test**

The cases of unsatisfactory test results include:

when the average value of three impact tests (*KV*) fails to meet the prescribed requirements;

or more than one result out of three is below the required average value;

or the result on any one of the specimens is more than by 30 % below the required average value.

In any one of the cases listed, retesting may be carried out on additional number of specimens machined from the same semi-finished product at the locality nearest to the area of preceding cutting out.

The submitted semi-finished product and the batch may be accepted if the new average value of test results (three initial tests plus three additional tests) exceeds the required average value and not more than two results out of six are below the required average value and not more than one specimen has yielded the result, which is below by 30 % the required one.

Where the results of retesting of the semi-finished product representing a batch are unsatisfactory, this product shall be rejected, but the remaining semi-

finished products of the batch may be accepted in case where the results of tests carried out on two additional semi-finished products of this batch are satisfactory.

Where the test results of two additional semi-finished products are unsatisfactory, the batch shall be rejected. The mentioned additional semi-finished products shall be the thickest among the products available in the batch.

The test principle proposed here for *KV* may be applicable to U-notched specimen.

**1.3.2.3.3** Where the test results are unsatisfactory due to local defects in the specimen material, faulty machining or faulty test equipment or in case of tensile test fracture occurs beyond the design length of the specimen, on agreement with the Register, the test may be repeated on the same number of specimens.

At the manufacturer's discretion, the semi-finished products from the batch rejected may be submitted to tests item-by-item and where the results are satisfactory, they may be accepted by the Register for supply.

At the manufacturer's discretion, the semi-finished products from the batch rejected may be re-tested after heat treatment, repeated heat treatment, or may be submitted as a category other than that initially declared.

Where test results in case of such repeated submission are satisfactory for supply, the Register may accept the material.

Any material that yielded unsatisfactory results during subsequent machining or application shall be rejected irrespective of the availability of records of tests carried out previously or

appropriate certificates.

**1.3.2.4** If confusion of specimens or test results is detected or the test results do not make it possible to assess the material properties with the required degree of accuracy, the Register may require any tests to be repeated in the presence of its representative.

**1.3.2.5** Material produced, the properties of which do not fully agree with the requirements of this Part, the deviations being not essential for the operation of the structure or product, may be used in accordance with the purpose only subject to special review of the deviations by the Register and in case a relevant application from the manufacturer and agreement of the customer is available.

**1.3.2.6** Where results of surveys and tests specified in 1.3.1.4, 1.3.2 and 1.3.3 are positive, the Register issues the documents in the format it has established.

Before the Register surveyor signs the certificates, the manufacturer shall provide him with a confirmation executed in written form that the material has been manufactured in accordance with a permitted production practice and has passed all tests required by the Rules with satisfactory results.

The Register may accept such a confirmation form, if it is stamped or printed on each issue of the test certificate or Manufacturer Certificate, with the manufacturer name specified and a following signature of an authorized person provided:

*“This hereby certified, that the material has been manufactured in accordance with a permitted process and has yielded satisfactory test results as per the Rules for the Classification and*

*Construction of Sea-Going Ships of the Ukrainian Register of Shipping.”*

### **1.3.3 Manufacture survey**

**1.3.3.1** All materials and products specified in 1.1.4, except for those specified in 1.1.4.10, are subject to manufacture survey and test in a scope corresponding to the requirements of this part and/or standards and technical documentation, which is approved by the Register.

The manufacturer provides the Register representative with all necessary means to fulfil his duties in accordance requirements of the Rules for survey of manufacturer works, tests conduction, testing machinery and equipment, material sampling for the purpose of testing and so on.

Surface, dimensions and weight of materials and products shall be controlled by the manufacturer. Availability of a Register Certificate does not indemnify the manufacturer, if a material or a product then appears to be defective or such that does not meet the approved standards or technical requirements for dimensions, weight and surface condition.

Materials and products are usually surveyed and tested, with subsequent issuance of relevant documents of the Register, at the manufacturer works, but in any case after the terminal production process, which defines material properties (for example, heat treatment).

**1.3.4** Prior to inspections and tests, the manufacturer shall provide the Register with the following data:

name, type or grade of a material or a product;

standard name and code;

grades or material requirements in accordance with the Rules or technical

documentation;  
 condition of supply;  
 customer's name and order number,  
 an object material or product is intended  
 for (if known);  
 number;  
 number of cast, identification  
 number;  
 numbers of samples or specimens  
 prepared for testing.

The manufacturer shall confirm that materials or products submitted meet the requirements of the Register.

When steel is accepted as per Subsection 3.13, in addition to all above mentioned, the following data shall be provided: condition of supply, welding recommendations, cold and hot shaping and post-welding heat treatment.

### **1.3.5 Recognition procedure for manufacturers of hull structural steel**

#### **1.3.5.1 General**

These provisions establish a procedure of Register recognition for production process of rolled normal and higher strength steel, which is required in accordance with **1.3.1.4**.

These provisions also cover Register recognition of production processes for such processable products as slabs, blooms and billets for rolled hull structural steel production.

On the basis of the recognition procedure, the Register certifies manufacturer's ability to ensure satisfactory quality of products, which is, in its own turn, ensured by production practice, including programmed rolling schedules, and by the existing quality system of the manufacturer works in accordance with 3.2.1.3 and 3.2.1.4.

Recognition of production process of a particular steel grade in accordance with

the proposed procedure usually means recognition of a particular type of product made of steel of this grade, the steel being supplied by the works and meeting the requirements of the Register Rules.

#### **1.3.5.2 Application of recognition. Documentation**

##### **1.3.5.2.1 Initially submitted documentation**

In order to obtain recognition, the manufacturer shall provide

the Register with a check tests program (see Subsection 3.1) and with main information describing the works and its products:

*a)* works name and address, location of manufacturing facilities (shops disposition plan), designations used in the plan, shops areas, types and annual production volumes of products supplied for the purpose of shipbuilding and other purposes (if acceptable);

*b)* management and quality:  
 production management scheme;  
 workers staff;  
 non-manual workers staff and Quality Control Subdepartment management;

qualification of personnel engaged in activities aimed at assurance of proper quality control, ISO Compliance Certificate for ISO series 9001 or 9002 (if available);

certificates of works approval by other classification associations (if available);

*c)* production facilities:  
 brief description of the production process;

origination and storage of charge mixture (ingoing materials);

storage and preservation of finished products;

regular testing equipment and facilities used in the production practice;

d) quality control system and equipment:

description of a materials identification system which is used at different stages of production;

chemical analysis, mechanical tests and metallography equipment, as well as appropriate calibration devices for such equipment;

non-destructive testing equipment;

list of procedures aimed at products quality control assurance;

e) types of semi-finished products (plate, section, coiled rolled steel), steel grades, thickness, main mechanical properties of material);

permissible content of chemical elements, including deoxidating elements and grain refining microalloying admixtures, as well as admixtures depending on steel grade (where content of chemical elements depends on rolled steel thickness and condition of supply, corresponding deviations shall be regulated by documents);

maximum permissible equivalent carbon content, which is determined using the formula given in 3.2.2;

maximum values of  $P_{CM}$ , which are determined for high strength steel with carbon content less than 0.13 %;

statistical data on chemical composition and mechanical properties ( $R_{eH}$ ,  $R_m$ ,  $A$ , %,  $KV$ ), which shall demonstrate manufacturer's ability to fabricate products in accordance with established requirements;

f) steel production:

steel production process and capacity of furnaces and/or a convertor;

charge materials used;

deoxidation and alloyage;

desulfation (if necessary) and vacuum treatment;

casting method; ingot making or continuous casting. If continuous steel casting is used, data shall be provided on the type of a pig machine, casting practice, oxidation preventing methods, sweating control and non-metallic inclusions control, electromagnetic melt mixing, soft reduction etc.;

size and mass of an ingot or a slab;

surface machining of ingots or slabs;

ingot head ends cutoff and elimination of surface defects by flame cleaning;

g) machining and rolling:

furnace type and heating modes;

rolling: relationship between slab/bloom/billet size and end product thickness, relationship between rolling temperature and time of rolling completion;

burring in the course of rolling;

rolling mill capacity;

h) heat treatment:

type of furnaces, their temperature capabilities, recording of parameters during steel heat treatment;

accuracy and calibration of temperature control and maintenance devices;

i) rolling schedules:

for semi-finished products which are supplied controlled rolled (CR) or thermo-mechanically rolled (TM), the following information shall be provided:

rolling process description;

steel normalisation, recrystallization and ( $A_{r3}$ ) temperatures and methods used for its treatment;

standard values of parameters which are controlled in the course of steel

rolling, depending on steel grades and thickness (temperature and thickness in the beginning of passes, inter-pass period, reduction ratio, temperature range and rate during metal accelerated cooling (if used) and existing control methods for abovementioned parameters;

check testing of measurement and recording equipment;

*j)* recommendations on steel bending and welding in CR or TM condition of supply;

on hot and cold bending (if required) in addition to general practice of steel works at shipyards and at manufacturing works;

minimum and maximum values of heat input rate, if they differ from usual values for shipyards and manufacturing works (15-20 kJ/cm);

*k)* additional information on delegation of a part of manufacturing process to another manufacturing facility or manufacturer (if possible) shall be submitted to the Register in all cases;

*l)* to obtain Register recognition for such products as slabs, blooms or billets, data listed in points *a)* — *e)* shall be submitted to the Register.

**1.3.5.2.2** Documentation submitted in case of alteration of recognition conditions

The manufacturer shall provide the Register with the documents on claimed alteration of conditions of previously obtained recognition, accompanied with documentation listed in 2.1, in the following cases:

*a)* if production practice of any of the following processes has been altered: steel making, casting, rolling and/or heat treatment;

*b)* if maximum thickness (dimension)

of rolled steel has been altered;

*c)* if chemical content has been altered (content modified, alloying implemented, etc.);

*d)* if conditions of supply, thermal and other equipment are used other than those indicated in the course of rolled steel production practices recognition by the Register;

*e)* if billets, slabs and blooms used for rolling are manufactured by other works, which are not recognized by the Register.

In this case, if any of the listed documents comprises a copy of a respective document, which has been considered and approved by the Register in the course of previous recognition or recognition confirmation for this type of product, consideration of such a document by the Register is not required. The foregoing provision is not applicable to test program (refer to 1.3.5.3.1).

**1.3.5.3** Tests during recognition of rolled steel production practice and quality

**1.3.5.3.1** Scope of testing

The scope of testing is outlined in general terms in 1.3.5.3.6 and 1.3.5.3.7; types and number of tests may be specified by the Register based on initial information submitted by the manufacturer in accordance with 1.3.5.2.1 and 1.3.5.2.2. In particular, number of casts, semi-finished products of a certain thickness and steel grade, which are subject to testing, may be reduced, or, at the Register discretion, the tests may be waived. Decisions are taken with due regard to the following provisions:

*a)* the manufacturing is already recognized by another classification association, and documentation confirming relevant tests and their results

is available;

b) for steels, which are applied for Register recognition, statistical data are available, confirming stability of chemical analysis results and mechanical properties of the steel;

c) recognition of any steel grade manufacturing can be extended to any lower steel grade of the same strength class, provided that sameness of manufacturing technology, conditions of supply and control and testing methods is confirmed;

d) recognition of manufacturing of higher strength steel with a particular strength level may be extended to steel with a lower strength level, if it is manufactured according to the same production process, including deoxidation and grain refining, as well as casting method and condition of supply;

e) alteration of conditions of the firm recognition by the Register;

f) recognition of manufacture of processable products such as slabs, blooms and billets.

Number of casts and semi-finished product of different thickness, which are subject to testing, may be increased if new production practices, steel types and rolling types are introduced.

#### **1.3.5.3.2 Test program approval**

If number of tests notably differs from the number specified in 1.3.5.3.6 and 1.3.5.3.7, the program shall be submitted for agreement with the Register prior to testing together with documentation specified in 1.3.5.2.1 and 1.3.5.2.2.

#### **1.3.5.3.3 Inspection**

Tests carried out at the manufacturer's site shall be certified by the Register representative in the course of the works survey, which may be required

prior to or during his visit to the works.

If it is impossible to conduct the tests at the manufacturer works, the required tests shall be carried out in a laboratory recognized by the Register.

#### **1.3.5.3.4 Scope of testing**

Usually, tests shall be conducted on one semi-finished product of maximum thickness for each type of semi-finished product and each relevant manufacturing process (including the entire cycle of steel making, casting, rolling and condition of supply).

For initial manufacture recognition, the Register may also require for testing of semi-finished products of a medium thickness.

Semi-conducted products, which are subject to testing, are selected from casts which shall be chosen on the basis of a regulated and typical for this manufacture chemical composition,  $C_{eq}$  or  $P_{CM}$  value and content of deoxidating and grain-refining alloying elements used.

#### **1.3.5.3.5 Sampling**

Unless otherwise stated, samples of semi-finished product (plate, strip, section and bar) from which specimens will be cut out shall be selected so that sample metal corresponds to the upper part of the ingot. In case of continuous casting, samples are selected randomly.

According to the requirements of Table 1.3.5.3.6-1, samples are machined from the "top" or "bottom" along the rolled piece length, while samples disposition in the direction of the piece width shall meet the requirements of 3.2.5.

#### **1.3.5.3.6 Tests**

##### **1.3.5.3.6.1 Types of tests**

Tests shall be conducted in accordance with the requirements of

Table 1.3.5.3.6-1.

**1.3.5.3.6.2** Test specimens and methods

In general, test specimens and methods shall meet the requirements of Subsection 2.2.

In addition, the following peculiarities of tests mentioned below shall be taken into account:

*a)* tensile test:

for plates made of hot-rolled coiled steel, one additional specimen is machined from the coil middle;

for plates more than 40 mm thick, where capacity of existing machines is insufficient to test full thickness specimens, several specimens shall be tested with a general thickness equal to metal thickness. As an alternative, two round bars may be selected with axes located at a distance of  $\frac{1}{4}$  and  $\frac{1}{2}$  of the plate thickness from the plate surface;

*b)* impact test:

for plates made of hot-rolled coiled steel, an additional set of specimens is machined from the coil middle;

for plates more than 40 mm thick, an additional set of specimens with axes coincident with the middle line of plate thickness is machined;

when conducting impact tests, the ratio of a ductile (brittle) constituent shall be determined in addition to energy value required to break the specimen;

strain ageing susceptibility tests shall be performed as per 2.2.3.4, unless otherwise stated. If rolled steel thickness exceeds 40 mm, the Register may also require for testing of specimens machined from the middle of a rolled product. Test results standards shall be in accordance with Tables 3.2.2-1 and 3.2.3, depending on the grade of the steel being tested;

Table 1.3.5.3.6-1

Test type	Samples locality, direction of specimens cutting <sup>1</sup>	Notes			
Tensile test	Top and bottom, transverse <sup>2</sup>	$R_{eH}$ , $R_m$ ( $A_5$ ), %, $R(A)$ are determined			
Tensile test (with stress relief) for TM steel only	Top and bottom, transverse <sup>2</sup>	Stress relief at 600 °C (2 mm/min during 1 hour)			
Impact test <sup>3</sup> for steel grades:	Top and bottom, longitudinal	Test temperature, °C			
A, B, A32, A36, A40		+20	0	-20	-
D, D32, D36, D40		0	-20	-40	-
E, E32, E36, E40		0	-20	-40	-60
F32, F36, F40		-20	-40	-60	-80
A, B, A32, A36, A40	Top, transverse <sup>4</sup>	+20	0	-20	-
D, D32, D36, D40		0	-20	-40	-
E, E32, E36, E40		-20	-40	-60	-
F32, F36, F40		-40	-60	-80	-
Post-ageing impact test <sup>3</sup> for steel grades:	Top, longitudinal	Test temperature, °C			
A32, A36, A40		+20	0	-20	-
D, D32, D36, D40		0	-20	-40	-
E, E32, E36, E40		-20	-40	-60	-
F32, F36, F40		-40	-60	-80	-

Chemical analysis <sup>6</sup>	Top	General analysis including alloying components
Sulphur segregation	Top	–
Microstructure	Top	–
Grain size	Top	Only for steel treated with grain refining elements
Dropweight test	Top	Only for steels of grades E, E32, E36, E40, F, F32, F36, F40
Through-thickness tensile testing	Top and bottom	Only for steels with enhanced through-thickness properties

<sup>1</sup> For hot-rolled coiled steel — refer to 1.3.5.3.6.2 a).

<sup>2</sup> For steel sections, rods and strips of less than 600 mm in width — longitudinal.

<sup>3</sup> Each test is performed on three V-notched specimens as per 2.2.3.4.

<sup>4</sup> Is not required for steel sections, rods and strips of less than 600 mm in width.

<sup>5</sup> Deformation — 5 % + 1 hour at 250 °C.

<sup>6</sup> Chemical analysis of a ladle sample is also required.

c) chemical composition:

chemical analysis shall be performed for a ladle sample and for rolled steel which is subject to testing. Tensile test specimens serve as material for chemical analysis. Usually, content of the following elements is determined: C, Mn, Si, P, S, Ni, Cr, Mo, Al, N, Nb, V, Cu, As, Sn, Ti. For steel made in electric furnaces or open-hearth furnaces, Sb and B content shall also be determined;

d) sulphur segregation:

segregation shall be determined on samples machined from plate edges, perpendicular to axes of an ingot or a slab, respectively. Sulphur prints shall be of about 600 mm long and machined from the centre, so that the central line of the ingot is cut out, and shall cover the full plate thickness;

e) microphotographic analysis:

microphotographies shall represent plate structure through all its thickness. For thick rolled steel, three control photographs of structure are usually made, from the centre, the ¼ plane and the surface respectively.

All microphotographies shall be

made with X100 magnification, and if ferrite grain prevails in accordance with the requirements of ASTM 10, then X500 magnification is also required. Ferrite grain size shall be determined for each of the specified microphotographies;

f) dropweight test:

the test shall be conducted in accordance with the requirements of ASTM E208. As a result of the test, values of nil-ductility temperature (NDT) and microphotographies of tested specimens are obtained;

g) through-thickness tensile testing:

tests shall be performed as per 2.2.2.5. Test results shall meet the requirements of Subsection 3.2 for corresponding steel grades.

**1.3.5.3.6.3** Other types of tests

Additional tests, such as CTOD, ductile (brittle) constituent ratio determination for full-thickness specimens of a rolled product or others tests, may be required if new types of steel are implemented, other than types specified in Subsection 3.2, or if the Register considers such tests necessary.

**1.3.5.3.7** Weldability test

**1.3.5.3.7.1 General**

The test is required for normal strength Grade E steel and for higher strength steel.

Necessary weldability testing of steel plates shall be carried out on specimens of a maximum, full plate thickness.

**1.3.5.3.7.2 Preparation and welding of welding samples**

The following tests are usually required:

*a)* for one butt weld sample — welding with a rate of energy input of about 15 kJ/cm;

*b)* for one butt weld — welding with a rate of energy input of about 50 kJ/cm.

Welding seam shall be normal to the direction of the last rolling pass of steel bars used for sample preparation. Thus, impact test specimens cut out of the sample will be localized along rolling direction.

Edge bevels shall preferably correspond to  $\frac{1}{2} V$  or K.

Whenever possible, welding process shall be equivalent to conventional welding process used at shipyards for this type of steel.

Information shall be provided on welding parameters, such as class of welding electrodes, their diameter, preheating temperature, inter-pass temperatures, rate of energy input, number of passes etc.

**1.3.5.3.7.3 Types of tests**

Specimens shall be cut out of samples as follows:

*a)* one transverse specimen — for tensile test;

*b)* four specimen sets, of three specimens each, — for impact test (*KV*): in this case, the notch shall be made along weld-fusion line on one set, at a distance

of 2 and 5 mm from the weld-fusion line respectively on two other sets, and at a distance not less than 20 mm from the weldfusion line on the fourth set (refer to Fig. 6.4.5 of part XIV “Welding”). Weld-fusion line boundaries are determined after etching treatment. Test temperature shall comply with the temperature proposed for testing of steel of this grade;

*c)* hardness HV5 in the cross-section of a weldment:

hardness shall be determined along the line normal to the welding seam, under the plate surface, both on the weld face and weld root, at a distance of 1 mm from: weld-fusion line;

heat affected zone; every 0.7 mm from the weld-fusion line to the base metal unaffected by welding heat (at least 6-7 measurements for each heat affected zone).

Maximum hardness value shall not exceed 350 HV.

Test results shall be presented with the weld drawing enclosed and with edging dimensions, number of passes and measurements points indicated, as well as with microphotographies of the weld section enclosed.

**1.3.5.3.7.4 Other types of tests**

Additional tests, such as cold tears test (CTS), CTOD or other types of tests may be required, if new types of steel which are not subject to the requirements of Subsection 3.2 are introduced, or if the Register requires for such testing.

**1.3.5.4 Results**

All test results and testing conditions shall meet the requirements of the Rules and be approved by the Register: in documents submitted for approval, tests results (both regulated and not regulated by the Rules) and respective tests

conditions shall be reported.

In addition, the manufacturer shall compile a package of documents which contains full information in accordance with 1.3.5.2, which is applicable to semi-finished products subject to testing. The package of documents shall include all results of tests and analyses, operational records of melting, casting, rolling processes and heat or thermo-mechanical treatment of material which has been subject to testing. This package of documents shall also be required by the Register for reviewing.

#### **1.3.5.5 Recognition**

##### **1.3.5.5.1 Results of recognition**

If the result of works inspection and testing has been satisfactory, the works receives the Recognition Certificate for Manufacturer.

**1.3.5.5.2** List of recognized manufacturers.

Firms possessing Certificates of Manufacturer Recognition are included into the List of firms recognized by the Register. In addition to names of manufacturers, the List contains information on products which are produced by them and are recognized by the Register: steel categories and/or grades and main conditions required to complete formalities of works recognition by the Register.

##### **1.3.5.6 Continuation of recognition**

Maximum validity period of the Recognition Certificate for Manufacturer may comprise five years. Continuation (reissuance) of the Recognition Certificate for Manufacturer may be performed on the basis of audit and analysis of inspection results obtained during the validity period of the Certificate.

If audit, which is required for

recognition continuation (continuation of validity period of the Recognition Certificate for Manufacturer), is performed beyond the validity period of this recognition due to production reasons, the manufacturer may be considered recognized by the Register only if audit date was agreed within the validity period.

If audit results are positive, validity period of recognition and its continuation date will correspond to the initial ones.

Manufacturers which have not been producing and supplying steel categories/grades and rolled steel types recognized by the Register within the validity period of the Recognition Certificate for Manufacturer, shall perform all required tests in order to reissue the Certificate. At the discretion of the Register, continuation of recognition of these steel grades and rolled steel types (their preservation in the Recognition Certificate for Manufacturer) may be executed based on the results of production of equivalent steel grades and rolled steel types.

**1.3.5.7** Reconsideration of recognition conditions

Within the validity period of the certificate, recognition conditions may be reconsidered in the following cases:

*a)* if defects have been detected in the course of rolled steel use or operation, and reasons affecting rolled steel quality have been found;

*b)* in case of improper steel quality which has been revealed in the course of its use or operation;

*c)* in case of unsatisfactory functioning of the quality control system;

*d)* if a manufacturer alters recognition conditions without their prior agreement with the Register;

e) if numerous fails during rolled steel testing have been reported.

Conditions of recognition continuation (reissuance of the Recognition Certificate for Manufacturer) shall also be applied to all rolled steel grades and types that had been recognized by the Register before these changes were incorporated into the requirements of the Rules.

For works which have obtained recognition earlier, respective actions in accordance with the foregoing procedure on reissuance of effective documents having been issued by the Register shall be executed within five years.

## **1.4 MARKING AND DOCUMENTATION**

### **1.4.1 Identification**

During manufacture of materials and products at works, the system of monitoring shall be applied, which enable to check the products manufacture at any stage, beginning from the original ladle of metal.

Upon the request of the Register representative, the latter shall be given a confirmation of availability of such a system at the works.

### **1.4.2 Marking**

Prior to submission to the Register representative the materials shall be respectively marked.

The marking of the materials, unless specified otherwise, (the peculiarities of marking shall be agreed in advance and shall reflect the particular products properties, for example, refer to 3.2.8), shall be carried out according to the standards taking the following requirements in consideration:

**.1** in the case of semi-finished

products delivered in single pieces each one of them shall be marked.

For shipments in bundles two strong weather-resistant labels containing the marking shall be provided and firmly fastened to the opposite ends of the bundle.

When a great number of semi-finished products are delivered and these are of small size, the marking procedure and the content of the marking shall be agreed with the Register.

Semi-finished products to undergo further machining shall be stamped, as far as possible, in spots shall not be machined.

The stamp shall stand out clearly and be framed with a bright paint resistant to atmosphere;

**.2** as a rule, the stamp shall include the following information:

category or grade of material;

figures or other designation to indicate the origin of the semi-finished product (number of semi-finished product, number of cast and the like);

manufacturer's name or trade mark;

stamp of the quality control service of the manufacturer's;

Register's brand (if required);

**.3** if the semi-finished product does not withstand the tests required by the Rules or defects are revealed, which make its use in accordance with the purpose impossible, the Register brand and the material grade designation shall be removed or cancelled.

### **1.4.3 Documentation**

Every batch of the materials and products, or a separate semi-finished product and a separate item, if the delivery is performed in single pieces, which passed the tests, shall be accompanied by

the Register Certificate or the manufacturer's document certified by the Register representative.

#### **1.4.3.1 Manufacturer Quality Certificate**

The Register representative simultaneously with the submission of the final material or in advance shall be presented with the Material Quality Certificate. The Certificate shall be attested by the works quality division, witnessed by the authorized person, and, as minimum, shall contain the following data:

- name of the enterprise and order number;

- project number, if known;

- name, number, dimensions and mass of the semi-finished product with indication of the drawing number or sketch, (if applicable);

- grade (category) of the material, type of alloy, number of ladle and chemical composition;

- identification number;

- type and mode of heat treatment (if necessary);

- mechanical test results;

- non-destructive testing results, (satisfactory or unsatisfactory), if applied.

**1.4.3.2** The Register Certificate, at least, shall contain the following data:

- order number;

- building project, if known;

- name, number, dimensions and mass of the material;

- grade (category) of the material and delivery status;

- number of Manufacturer Quality Certificate;

- number of batch or semi-finished product or identification number, which enables to identify the supplied material;

- drawing number (if applicable).

The obligatory supplement to the Register Certificate shall be the Manufacturer Quality Certificates attested by the authorized representative of the Manufacturer.

Test reports verified by the Register representative may be also added to supplements of the Register Certificate, if they are required by a customer.

If the material is supplied only with the manufacturer certificates, attested by the Register representative, its form and contents shall be agreed with the Register and the purchaser.

### **1.5 LABORATORIES ENGAGED IN TESTING**

**1.5.1** The present Subsection applies to laboratories engaged in testing of materials subject to the survey by the Register.

**1.5.2** Laboratories of metallurgical works and firms engaged in manufacture of materials recognized by the Register are entitled to effect testing for the purpose of determining material properties without being specially recognized by the Register.

Reports or statements of those laboratories on the tests conducted are sufficient ground for entering data on chemical composition, mechanical properties, etc. in the certificate for material.

Laboratories of other firms or independent laboratories may determine chemical composition and conduct tests to determine mechanical and other properties of the items of supervision only after being recognized by the Register.

**1.5.3** The provisions mentioned in 1.5.2 are fully apply to the laboratories

engaged in testing of items of the Register supervision by non-destructive methods.

**1.5.4** Laboratories engaged in non-destructive testing of materials and products shall have a Recognition Certificate issued by the Register and/or any other appropriate document of the authorized national or international organization, which confirms the competence of the laboratory.

In the Certificate or the document the scope and conditions of applying testing shall be defined. To be recognized for applying the ultrasonic testing, a request shall be forwarded to the Register supplemented by the following documents confirming that the laboratory is ready to carry out the non-destructive testing:

documents in confirmation of availability of qualified personnel together with the name of the body having carried out the certification of the personnel;

technical characteristics of relevant equipment and the scope of its application;

instructions for personnel.

Tests shall be made to confirm reliability of the test results and the

possibility of their reproduction.

The test program shall be approved by the Register.

Laboratories from the List of firms recognized by the Register, which have non-destructive control of materials and products included into their Recognition Certificate, are not required to possess the foregoing documents (refer to 1.5.3) the requirements of this paragraph are taken into account in the course of firm recognition.

**1.5.5** The results of material testing and investigations conducted are recorded in the prescribed way (entered in the test log, report, etc.).

The test log (report, etc.) shall contain all the data necessary for the assessment of material quality and subsequent issue of certificate.

A report of testing of products shall include at least the following information: kind of product, material and major dimensions of product, testing method, testing frequency, type of unified reference block, size and position of defects, name of operator and date of testing.

## **2. PROCEDURES OF TESTING**

### **2.1 GENERAL**

**2.1.1** The requirements of the present Section cover the types and procedures of testing materials, which are subject to survey by the Register during their manufacture.

The need to conduct the tests and

evaluation criteria of test results are defined in the relevant sections of the present Part or other parts of the Rules.

**2.1.2** The Section gives general requirements for testing conditions, types and dimensions of test specimens, and their preparation.

Alternative testing procedures and types of test specimens may be adopted, subject to approval of the Register and on condition that they provide adequate accuracy, reproducibility and dependability of tests carried out for determination of material properties required by the Rules.

**2.1.3** Types and procedures of special tests for the materials intended for specific use and evaluation criteria, if no instructions are contained in the Rules, shall be agreed with the Register.

**2.1.4** When tests are carried out, the requirements of the standards or other regulating documents approved by the Register shall be met.

**2.1.5** Samples, from which test specimens are cut shall have undergone the same treatment as the material, from which they have been taken (e.g. heat treatment).

Test specimens shall be prepared in such a manner that properties of the material are not affected.

**2.1.6** The tests shall be carried out by competent personnel on testing machines of adequate capacity being maintained in the appropriate operating condition.

The measurement accuracy of testing machines shall be within  $\pm 1\%$ . The machines shall be regularly, as a rule at least once per year, checked and calibrated by the duly designated national authorities.

The results of regular checks shall be submitted to the Register.

Charpy machines for impact tests shall be verified in accordance with the requirements of ISO 148-2 or another standard recognized by the Register.

Machines for tensile/compression tests shall be verified in accordance with

the requirements of ISO 7500-1 or another standard recognized by the Register.

## 2.2 TESTING PROCEDURES FOR METALS

### 2.2.1 Test temperature

The temperature of the ambient air during the tests shall comply with the requirements of the standards unless expressly provided otherwise in the subsequent sections and subsections of the present Part.

### 2.2.2 Tensile tests

**2.2.2.1** When carrying out tensile tests at the ambient temperature the following tensile properties of metals shall be determined:

**.1** yield stress  $R_e$  is the value of stress measured at the commencement of plastic deformation at yield or the value of stress measured at the first peak obtained during yielding even when that peak is equal to or less than any subsequent peaks observed during plastic deformation at yield.

Elastic stress rate shall be within the limits specified in Table 2.2.2.1.1.

Table 2.2.2.1.1

Modulus of elasticity $E$ , N/mm <sup>2</sup>	Stress rate, N/mm <sup>2</sup> per second	
	Min	Max
< 150,000	2	20
≥ 150,000	6	60

**.2** when no well defined yield phenomenon exists, the proof stress shall be determined. Proof stress  $R_p$  is the value of stress at which plastic deformation reaches the set value, which is expressed in per cent of the initial gauge length (0.2 % corresponds to proof stress  $R_{p0.2}$ ).

For austenitic and duplex stainless steel products the 1 % proof stress  $R_{p1}$

may be determined in addition to  $R_{p0.2}$ .

The stress rate shall be as stated in 2.2.2.1.1;

**.3** tensile strength  $R_m$  is the value of stress corresponding to the maximum strain rate directly before the test specimen fractures.

To determine the tensile strength  $R_m$  the test specimen is subjected to extension up to the fracture by the continuously rising strain rate.

After reaching the yield stress or proof stress, for ductile material the machine speed during the tensile test shall not exceed that corresponding to a strain rate of 0.008 per second. For brittle materials, such as cast iron, the stress rate shall not exceed 10 N/mm<sup>2</sup> per second;

**.4** fracture elongation  $A$  is the ratio of an increment of the gauge length after fracture to the original gauge length, expressed in per cent.

The elongation value is, in principle, valid only if the distance between the fracture and the nearest gauge mark is not less than one third of the original gauge length ( $L_0$ ). However, the result is valid irrespective of the location of the fracture if the elongation value is equal to or greater than the expected value.

Elongation  $A_5$  is usually determined on the small proportional test specimens.

$A_0$  is determined on the non-proportional test specimens, for instance, with a gauge length  $L = 200$  mm and calculated by the formula

$$A = 2A_5(\sqrt{S_0}/L_0)^{0.4}, \%$$

Non-proportional test specimens are usually used for ferritic type steels of low and medium strength made without application of cold working;

**.5** fracture reduction in area  $Z$  is the ratio of the difference between the original

and the minimum cross-sectional areas of the test specimen after fracture to the original cross-sectional area, expressed in per cent. It is determined for test specimens of circular cross-section;

**.6** when tensile tests are carried out at an elevated temperature, the test temperature shall be indicated by the inferior figure, for instance  $R_{m/350}$ ,  $R_{eL/350}$ ,  $A_{5/350}$ ,  $Z_{350}$ , where the number 350 is the test temperature in degrees Celsius.

**2.2.2.2** For determination of the test specimen dimensions the following symbols are used:

$d$  — diameter of the parallel test length, mm;

$a$  — thickness of the parallel test length; mm;

$b$  — width of the parallel test length, mm;

$L_0$  — gauge length, mm;

$L_c$  — parallel test length, mm;

$R$  — transition radius, mm;

$S_0$  — cross-section, mm<sup>2</sup>;

$D$  — external tube diameter, mm;

$t$  — rolled products thickness, mm.

**2.2.2.3** Tensile tests shall be carried out on the test specimens of the following types (refer to Fig. 2.2.2.3).

Test specimens of rectangular cross-section with a gauge length equal to  $L_0 = 5,65\sqrt{S_0}$  or of circular cross-section with a gauge length  $L_0 = 5d_0$  are called proportional test specimens.

Proportional test specimens are preferable for tensile tests. The minimum elongation values given in this Part are specified for these specimens. The gauge length  $L_0$  of the specimen shall preferably be greater than 20 mm.

The value of the specimen gauge length after its measuring may be rounded off to the nearest 5 mm, provided that the

difference between this length and  $L_0$  shall be less than 10 % of  $L_0$ .

Tensile tests for flats up to 40 mm thick shall be carried out with flat specimens of full thickness. It is allowed to reduce the specimen thickness by machining one of the rolled surfaces. The specimen thickness reduction may be caused by the insufficient capacity of a testing machine.

Tests shall be carried out on the specimens according to Table 2.2.2.3.

Test specimens for a tensile test, as a rule, shall be cut out so that their longitudinal axes were aligned with the metal basic deformation. Test specimens may be cut out transverse if there is the relevant instruction in sections of the present Part, or on agreement with the Register. During the works initial survey the rolled plates can be tested using both the longitudinal and transverse test specimens.

**2.2.2.4** For the determination of tensile strength ( $R_m$ ) of grey iron, test specimens of circular cross-section shown in Fig. 2.2.2.4 shall be used.

**2.2.2.5** Flat specimens shall be used in tensile tests of semi-finished products of wrought aluminium alloys for thickness

up to and including 12.5 mm. The tensile test specimens shall be prepared so that both rolled surfaces are maintained. For semi-finished products over 12.5 mm thick, round tensile test specimens are used. Test specimens from semi-finished products up to 40 mm thick are cut out so that their axis is located in the middle of the thickness. Test specimens from semi-finished products over 40 mm thick are cut out so that their axis is located at a distance from one of the surfaces equal one quarter of the thickness.

**2.2.2.6** When wire is tested, its specimens of full cross-section shall be of the following dimensions:

$$L_0 = 200 \text{ mm,}$$

$$L_c = L_0 + 50 \text{ mm.}$$

**2.2.2.7** Through thickness tensile tests shall be carried out on test specimens the longitudinal axis of which is perpendicular to the rolling surface (direction Z, refer to Fig. 2.2.2.7-1).

Test procedures and dimensions of the round specimens shall comply with the national and international standards recognized by the Register.

The scope of testing is given in 3.14.4.

Table 2.2.2.3

Semi-finished product	Specimen type	Specimen dimensions, mm
-----------------------	---------------	-------------------------

Forgings, castings, bars	<p>Fig. 2.2.2.3, <i>a</i></p> <p>Fig. 2.2.2.3, <i>c</i></p>	<p><b>Proportional round specimens</b></p> <p><math>10 \leq d \leq 20</math>, for deposited metal <math>d = 10</math>, preferably;  <math>L_0 = 5d</math>;  <math>L_c = L_0 + d</math>.  <math>R = 10</math> (for materials with <math>A_5 \leq 10\%</math>, <math>R \geq 1.5</math>, for nodular cast iron).  The axes of the round test specimens shall be located at approximately <math>\frac{1}{4}</math> of the thickness from one of the rolled surfaces.</p> <p>For rods and products of small dimensions, on agreement with the Register, test specimens of full thickness and with relevant other dimensions may be used.  <math>L_c = L_0 + d</math></p>
Plates, strips, sections	<p>Fig. 2.2.2.3, <i>b</i></p>	<p><b>Proportional flat specimens</b></p> <p><math>a =</math> plate thickness; <math>b = 25</math>; <math>L_0 = 5,65 \sqrt{S_0}</math> ;  <math>L_c = L_0 + 2 \sqrt{S_0}</math> ; <math>R = 25</math>  or:  <b>Non-proportional flat specimen</b>  <math>a =</math> plate thickness; <math>b = 25</math>; <math>L_0 = 200</math>; <math>L_c \geq 212.5</math>;  <math>R = 25</math>.  For plates over 40 mm thick, specimen as per Fig. 2.2.2.3, <i>a</i> may be used. It is recommended to use specimens with following dimensions:  <math>d = 14</math>; <math>L_0 = 5d</math>; <math>L_c \geq l_0 + d/2</math>  If the capacity of available testing machines is insufficient to test full-thickness specimens, these can be reduced by machining of one of rolled surfaces, on the agreement with the Register.</p>
Tubes	<p>Fig. 2.2.2.3, <i>d</i> or Fig. 2.2.2.3, <i>e</i></p>	<p><math>L_0 = 5,65 \sqrt{S_0}</math> ; <math>L_c = L_0 + D/2</math>, where <math>L_c</math> is the distance between the grips or the plugs, whichever is the smallest;  <math>a = t</math>; <math>b = 12</math>;  <math>L_0 = 5,65 \sqrt{S_0}</math> ; <math>L_c = L_0 + 2b</math>;  If possible, round specimen with a long axis coincident with the central axis of wall thickness may be used as per Fig. 2.2.2.3 <i>a</i>.</p>

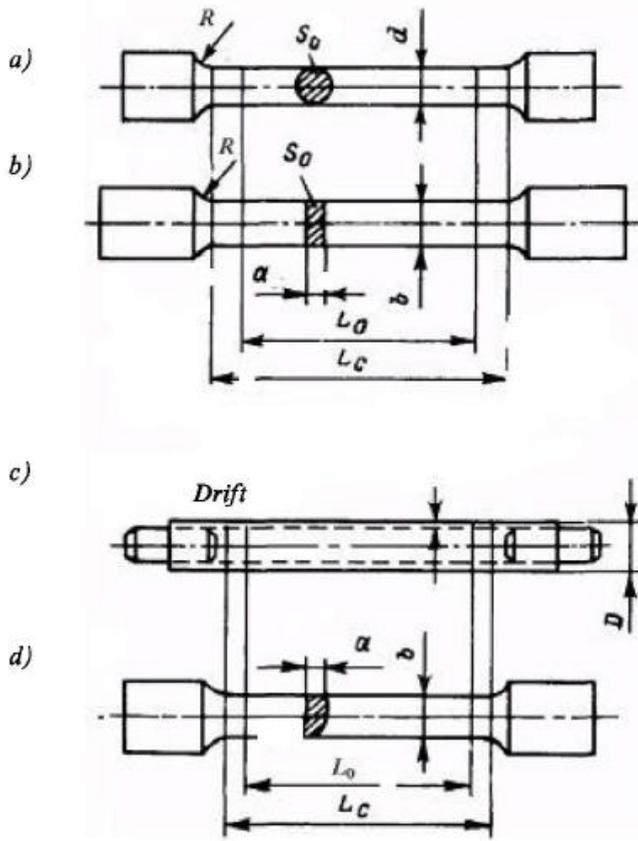


Fig. 2.2.2.3

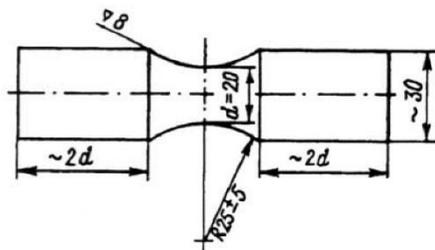


Fig. 2.2.2.4

For plates and wide flats, test samples shall be machined close to the longitudinal centreline of one end of rolled piece, as shown in Fig. 2.2.2.7-2.

The sample shall be large enough to accommodate the preparation of six specimens. Three test specimens shall be prepared, while the rest of the sample remains for possible retest.

If specimen fracture occurs in the weld or in the respective heat-affected zone, the results of a test are considered unsatisfactory, and retesting is required.

**2.2.2.8** In weldability tests (refer to 2.4) tensile test specimen shall have the following dimensions:

for deposited metal:

$d = 10 \text{ mm}$ ;

$L_0 = 50 \text{ mm}$ ;

$L_C \geq 55 \text{ mm}$ ;

$R \geq 10 \text{ mm}$ .

Upon agreement with the Register, when necessary, the specimens with other dimensions may be used (the geometrical relationship of the above parameters therewith shall be observed);

for butt-weld tensile test (refer to Fig. 2.2.2.8):

$a = t$ ;

$b = 12 \text{ mm}$  for  $t \leq 2 \text{ mm}$ ;

$b = 25 \text{ mm}$  for  $t > 2 \text{ mm}$ ;

$L_C = \text{width of weld} + 60 \text{ mm}$ ;

$R \geq 25 \text{ mm}$ .

The upper and lower surfaces of the flat specimen weld shall be machined flush with the surface of the base metal.

**2.2.2.9** The tolerances on specimen dimensions given in 2.2.2 shall be in accordance with ISO 6892-84.

If made according to the standards recognized by the Register, the specimen deviations shall comply with these standards.

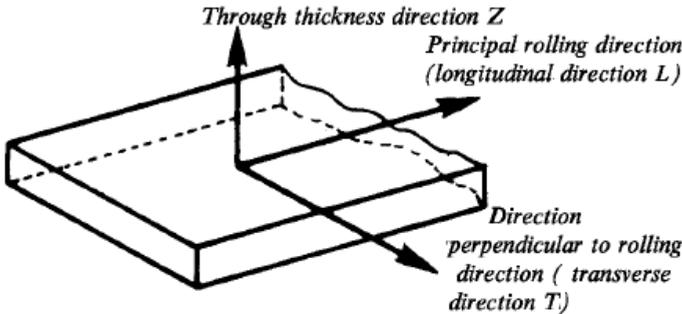


Fig. 2.2.2.7-1

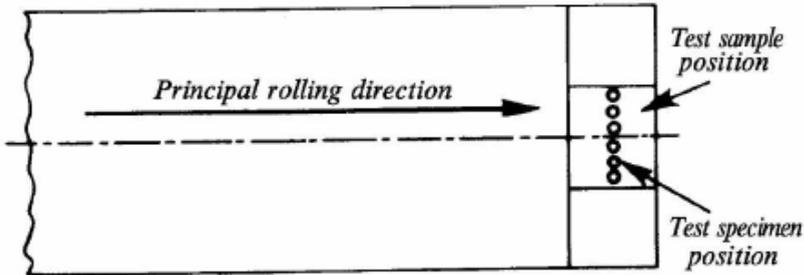


Fig. 2.2.2.7-2

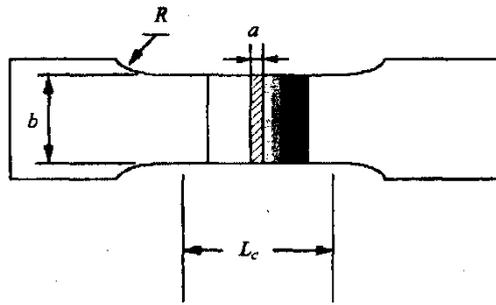


Fig. 2.2.2.8

### 2.2.3 Impact tests

**2.2.3.1** The impact toughness  $KCU$  shall be determined on U-notched specimens as per Fig. 2.2.3.1-1 and Table 2.2.3.1-1, the impact energy  $KV$  and  $KU$  shall be determined on V-notched and U-notched specimens, as per Fig. 2.2.3.1-2 and 2.2.3.1-3 and Tables 2.2.3.1-2 and 2.2.3.1-3.

The impact tests shall be carried out on Charpy machines complying with the requirements of ISO 148-2 or other national or international standard recognized by the Register, and having a striking energy of not less than 150 J. Where the test temperature is other than ambient, the temperature of the

test specimen at the moment of breaking shall be the specified temperature within  $\pm 2$  °C.

The impact energy  $KV$  and  $KU$  is determined as an average value obtained at testing of three specimens.

The required mean values of the impact energy depending on the dimensions of the specimens selected for tests ( $E$  is the required minimum value of impact energy) are given in Table 2.2.3.1-4. In this case, test result for one of the specimens may be less than that specified in Table 2.2.3.1-4, but not less than 70 % of the required value.

Table 2.2.3.1-1

Dimensions	Nominal dimension	Tolerance
Length $L$ , mm	55	$\pm 0.60$
Width $b$ , mm	10	$\pm 0.10$
Thickness $a$ , mm	10	$\pm 0.10$
Depth of notch $h$ , mm	8	$\pm 0.10$
Root radius $r$ , mm	1	$\pm 0.10$
Distance of notch from end of test specimen $L/2$ , mm	27.5	$\pm 0.40$
Angle between plane of symmetry of notch and longitudinal axis of test specimen $\theta$ , °	90	$\pm 2$

Table 2.2.3.1-2

Parameter	Nominal dimension	Tolerance
Length $L$ , mm	55	$\pm 0.60$
Thickness $a$ , mm	10	$\pm 0.10$
Width $b$ , mm	10	$\pm 0.10$
	7.5	$\pm 0.10$
	5.0	$\pm 0.06$
Angle of V-notch $\gamma$ , °	45	$\pm 2$
Depth of notch $h$ , mm	8	$\pm 0.06$
Root radius $r$ , mm	0.25	$\pm 0.025$
Distance of notch from end of test specimen $L/2$ , mm	27.5	$\pm 0.040$
Angle between plane of symmetry of notch and longitudinal axis of test specimen $\theta$ , °	90	$\pm 2$

Table 2.2.3.1-3

Parameter	Nominal dimension	Tolerance
Length $L$ , mm	55	$\pm 0.60$
Width $b$ , mm	10	$\pm 0.11$
Thickness $a$ , mm	10	$\pm 0.11$
Depth of notch $h$ , mm	5	$\pm 0.09$
Root radius $r$ , mm	1	$\pm 0.07$
Distance of notch from end of test specimen $L/2$ , mm	27.5	$\pm 0.42$
Angle between plane of symmetry of notch and longitudinal axis of test specimen $\theta$ , °	90	$\pm 2$

Table 2.2.3.1-4

Specimen dimensions, mm	Average value of impact energy, J
$10 \times 10 \times 55$	$1E$
$10 \times 7.5 \times 55$	$5/6E$

$10 \times 5 \times 55$

2/3E

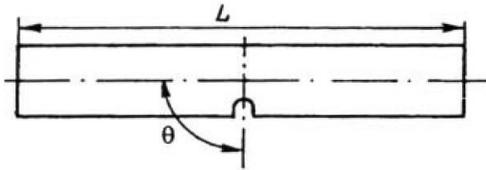


Fig. 2.2.3.1-1

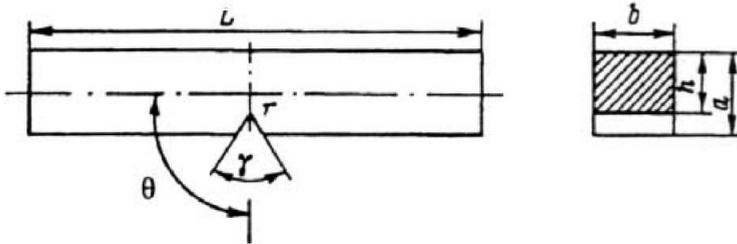


Fig. 2.2.3.1-2

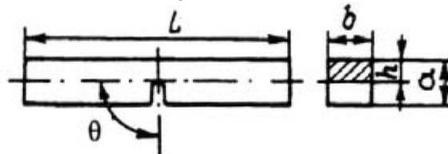


Fig. 2.2.3.1-3

Usually, specimen selected for rolled products of less than 11 mm thick are  $7.5 \times 10 \times 55$  mm in size, and for rolled products of less than 8 mm thick —  $5 \times 10 \times 55$  mm in size. Tests on rolled products of less than 6 mm thick are not usually conducted.

Impact toughness *KCU* is determined as an average value obtained at testing of two specimens. In this case, each obtained value of impact toughness shall be not less than the required value.

For specimens of less than 10 mm thick, impact toughness is determined on the demand of the Register, and required minimum *KCU* value shall be agreed with the Register.

**2.2.3.2** Dimensions of test specimens without any notch used for impact tests, in mm, shall be as per Fig. 2.2.3.2.

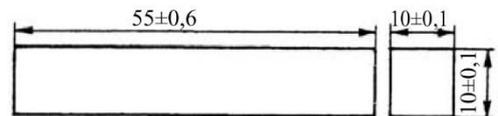


Fig. 2.2.3.2

**2.2.3.3** Impact tests shall be carried out on Charpy machines with a striking energy not less than 150 J.

Distance between the supports shall be  $40 \pm 0.5$  mm. The pendulum shall break the specimen in the plane of symmetry of the notch and on the side opposite to it, and distance between

principal planes of the notch and that of the pendulum shall not exceed 0.5 mm.

When conducting tests at low temperatures, specimens shall be subjected to supercooling in order to provide the assigned temperature. For test temperature up to 60 °C, specimens may be supercooled down to -4 °C, in addition, permissible deviation from the required test temperature at the moment of breaking shall not exceed  $\pm 2$  °C.

**2.2.3.4** Strain ageing sensibility tests shall be conducted on specimens made of samples machined in the same way as impact test specimens. Unless otherwise stated, metal strips, from which specimens will be cut out, are subject to extension deformation assuming 5 % residual elongation.

Impact test specimens made of strips subjected to extension deformation, shall be subject to even heating (artificial ageing) to 250 °C, with 1 hour conditioning at this temperature and subsequent cooling in the ambient air.

Impact test of these specimens shall be carried out at room temperature (within 18-25 °C) and/or at a separately specified temperature.

Unless otherwise stated, strain ageing sensibility tests of hull structural steel are required at the initial survey of the manufacturer, at procedure alterations and in doubtful or arguable cases related to the rolled products quality on the surveyor to the Register demand. At the initial survey and test procedure alteration, tests shall be carried out according to the requirements of 1.3.5.3.6.

In other cases, the steel tests shall be usually carried out at room temperature and at the impact test temperature of

impact test for a particular steel grade (for example, -20 °C for steel of grade D32).

Unless otherwise stated, results of strain ageing sensibility tests of hull structural steel shall comply with the requirements established by the Rules for steel during impact tests (for example, average value of impact test results for D32 steel shall not be less than 31 J at -20 °C with the steel thickness up to 50 mm — refer to Table 3.2.3).

When the above tests are carried out at temperatures lower than the prescribed for the submitted steel grade (for example, below -20 °C for steel of grade D32), the required average value of test results is established by the steel manufacturer, on agreement with the Register.

#### 2.2.4 Hardness testing

Hardness shall be determined according to Brinell (HB), Vickers (HV), Rockwell (HRC) hardness tests or using any other method approved by the Register.

#### 2.2.5 Technological tests

**2.2.5.1** Bend test specimens shall be cut out as shown in Fig. 2.2.5.1.

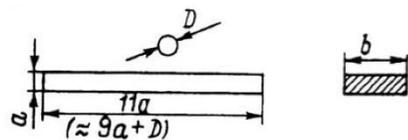


Fig. 2.2.5.1

Specimen edges on the tension side may be rounded to a radius of 1-2 mm.

The mandrel diameter and the angle of specimen bending are indicated in relevant subsections of this Part.

Bending tests of plates and sections, as well as of welded transverse specimens (2 sides) shall be carried out on specimens of the following dimensions:  $a = t$ ;  $b = 30$  mm ( $t$  — product thickness).

Where thickness of a semi-finished product exceeds 25 mm, the specimen may be machined on one side to a thickness of 25 mm. The machined surface shall be on the compression side during testing.

The bend tests of steel forgings, castings or similar semi-finished products shall be carried out on specimens with the following dimensions:  $a = 20$  mm,  $b = 25$  mm.

**2.2.5.2** Flattening tests are performed on specimens (pipe lengths) from 10 to 100 mm long.

The specimen ends shall be plain and smooth, their cuts shall be normal to the longitudinal axis of the tube (according to the requirements of ISO 8492).

**2.2.5.3** Drift expanding tests shall be carried out on specimens made in accordance with the requirements of ISO 8493 (refer to Fig. 2.2.5.3).

For metal tubes, the specimen length (tube length)  $L$  is equal to twice the external diameter  $2D$ , if the angle of the drift  $\beta$  is  $30^\circ$ , and is equal to  $1.5D$ , if the angle of the drift is  $45^\circ$  or  $60^\circ$ .

Shorter specimens may be used for testing, provided that after testing the remaining cylindrical portion is not less than  $0.5D$  in length.

The rate of mandrel penetration shall not exceed 50 mm per minute.

**2.2.5.4** Rings tensile tests shall be carried out in accordance with the requirements of ISO 8496.

The length of specimens (tube lengths) is equal to 15 mm, and the rate in tests not exceeds 5 mm/s.

**2.2.5.5** Flanging tests are carried out in accordance with the requirements of ISO 8494 on specimens (tube lengths) of a length equal to  $1.5D$  (see Fig. 2.2.5.5).

Shorter specimens may be used for testing, provided that after testing the remaining cylindrical portion is not less than  $0.5D$  in length.

The rate of mandrel penetration shall not exceed 50 mm per minute.

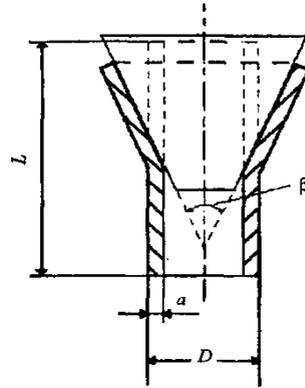


Fig. 2.2.5.3

**2.2.5.6** Rings expanding test is carried out in accordance with the requirements of ISO 8495 (see Fig. 2.2.5.6). The length of specimens (pipe lengths) may vary from 10 to 16 mm, mandrel penetration rate shall not exceed 30 mm/s.

### **2.2.6 Dropweight test for determination of nil-ductility temperature**

When required by the Rules, the tests and results assessment are effected in accordance with the ASTM standards and Register approved procedures.

Tests shall be conducted on specimens of the following types:

type P-1:  $25 \times 90 \times 360$  mm;

type P-2:  $19 \times 50 \times 130$  mm;

type P-3:  $16 \times 50 \times 130$  mm.

Specimens dimensions are chosen so that their thickness approximates that of the material to be tested.

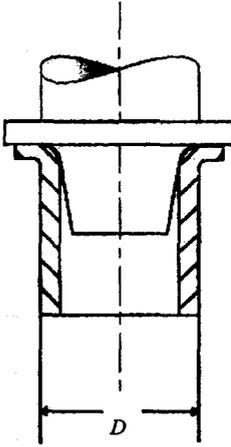


Fig. 2.2.5.5

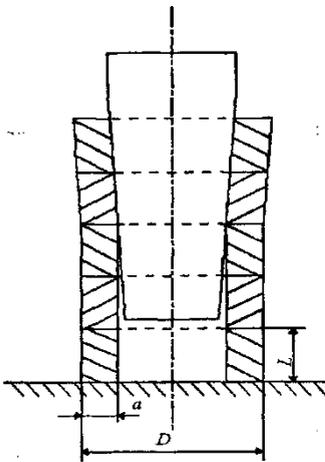


Fig. 2.2.5.6

Unless otherwise stated, the following conditions shall be fulfilled:

.1 if specimens are made by machining, no warming up is allowed (if flame cutting is used, the specimen side shall be distanced from the cut line by at least 25 mm);

.2 no machining is allowed for the tensile side of the specimen;

.3 the specimens of the series shall be of the same orientation.

### 2.2.7 Macro- and microstructural analysis

When required by this part or other parts of the Rules, macro- and microstructural analysis shall be performed in compliance with the relevant standards.

### 2.2.8 Chemical analysis

The methods for determination of chemical composition of metals and permissible deviations are specified in relevant standards.

### 2.2.9 Non-destructive testing

**2.2.9.1** If radiographic testing of a material is performed, the results shall be recorded in a form of radiographs with a summary of test evaluations attached.

**2.2.9.2** Ultrasonic testing shall be carried out using the pulse-echo methods. For control purposes dual-search units are used.

To provide for more precise testing, single-dual and prismatic search units are used on agreement with the Register.

Good condition and accuracy of the test equipment shall be checked on a regular basis.

The method for determination of a defect size is selected in compliance with relevant standards, otherwise it shall be agreed with the Register. The size of permissible defects and criteria for their estimation are subject to agreement with the Register as a part of design documentation for the product.

Product surface shall provide a safe and uniform acoustic contact with the search unit.

The ultrasonic testing is carried out after heat treatment at the stage of manufacture when the product has the simplest shape.

### 2.2.9.3 For magnetic particle testing

only technique proved satisfactory in practice may be used. The material surface under test shall have appropriate intensity of the field.

A need in demagnetization of the product after completion of the test shall be specified in the technical documentation.

**2.2.9.4** On agreement with the Register, testing methods other than those referred to in 2.2.9.1 — 2.2.9.3 may be also used. Test results evaluation criteria shall be agreed with the Register.

**2.2.9.5** The evaluation of non-destructive testing results shall be made only by the works responsible for the results submitted to the Register.

Records of testing shall be appended to the Register Certificate in case non-destructive testing is required by the Rules.

## 2.3 PROCEDURES OF TESTING NON-METALLIC MATERIALS

### 2.3.1 Testing conditions

**2.3.1.1** Before testing test specimens shall be conditioned at ambient temperature of  $23 \pm 2$  °C and relative humidity of  $50 \pm 5$  %. Unless otherwise stated, conditioning duration shall be not less than 16 hours.

Testing shall be carried out immediately after completion of conditioning of the test specimens.

Conditioning is not required, if the Register will receive substantiation that testing conditions have no notable impact on test results and their stability.

**2.3.1.2** The test specimens of reinforced materials are cut in the warp or weft direction so that the axis of the test specimen shall be parallel to the fibres of warp or weft, respectively.

**2.3.1.3** In substantiated cases, upon agreement with the Register, tests may be performed on specimens with shape or size differing from those required by this Subsection.

**2.3.1.4** Testing conditions which are not specified in this Subsection shall comply with the relevant standards.

### 2.3.2 Tensile tests

**2.3.2.1** Tensile strength of glass-reinforced plastics shall be determined on the test specimens according to Figs 2.3.2.1-1 and 2.3.2.1-2 and Table 2.3.2.1.

**2.3.2.2** The tensile strength and fracture elongation of laminated textiles are determined on test specimens  $50 \pm 1$  mm wide having the original length between the grips of testing machine  $200 \pm 5$  mm.

The preload is 2 N for cloth with a density up to  $200 \text{ g/m}^3$ , 5 N for cloth with a density from  $200 \text{ g/m}^3$  up to  $500 \text{ g/m}^3$  and 10 N for cloth with a density more than  $500 \text{ g/m}^3$ .

The moving rate of the testing machine grip is  $100 \pm 20$  mm/min.

Fracture elongation shall be in accordance with 2.2.2.1.6.

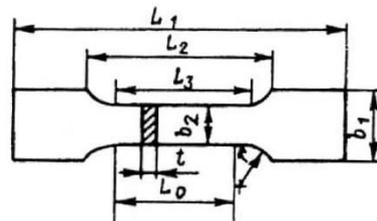
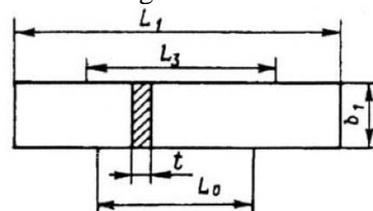


Fig. 2.3.2.1-1





Before testing, protective paper is removed from the adhesive layer of the material on a length of  $80 \pm 5$  mm, and placed on the surface being tested which measures  $(50 \pm 5) \times (90 \pm 5)$  mm.

The loose end of the specimen is secured in the dead lock of the testing machine. Separation of the specimen is achieved by turning the panel by  $180^\circ$  round the axis passing through the specimen end opposite to the loose one.

### 2.3.3 Compression test

**2.3.3.1** Compression strength of glass-reinforced plastics shall be determined on the test specimens according to Fig. 2.3.2.1-1 and Table 2.3.3.1.

Table 2.3.3.1

$L_1, L_2$ , mm	$L_3$ , mm	$b_1$ , mm	$b_2$ , mm	$r$ , mm	$t$ , mm
Not regulated	80	20	$10 \pm 0.5$	160	10

**2.3.3.2** Compression strength of rigid foamed plastics shall be determined on rectangular test specimens with side dimensions

$(50.0 \pm 0.5) \times (50.0 \pm 0.5)$  mm and a height from  $25 \pm 1$  to  $50 \pm 1$  mm.

The load is increased uniformly. The stress rate shall not exceed 5 mm/min.

### 2.3.4 Determination of modulus of elasticity for glass-reinforced plastics.

The modulus of elasticity in tension shall be determined according to 2.3.2.1, and in compression according to 2.3.3.1.

The strain increment is determined under initial load  $P_0$  and maximum load  $P_{\max}$ , which constitute 2 and 8-10 % of rupture load respectively.

### 2.3.5 Bend test

**2.3.5.1** The bend test of rigid foamed plastics shall be carried out on the test

specimens, the length of which is  $120 \pm 1.2$  mm, the width is  $25 \pm 0.25$  mm, and the thickness is  $20 \pm 0.2$  mm.

The distance between the supports shall be 100 mm, rounding of the supports and the punch  $5 \pm 0.2$  mm. The rate of punch feed is  $10 \pm 2$  mm/min.

**2.3.5.2** The bend test of glass-reinforced plastics shall be carried out on test specimens, the length of which equals 20 times their thickness and the breadth is 25 mm.

The distance between the supports shall equal 16 times the specimen thickness. The load applied to the midlength of the specimen shall be smoothly increased until the latter breaks.

### 2.3.5.3 Bending test of laminated textiles.

The test is effected on rectangular specimens measuring  $(300 \pm 5) \times (50 \pm 1)$  mm, which are fixed in the testing arrangements shown in Fig. 2.3.5.3.

When the test specimen is fixed the distance between the grips shall be 30 mm. The test specimen being fixed, the grips are brought together until they touch each other.

At this time, the load upon test specimen shall be equal to 10 N.

During the test, the movable grip makes 500 cycles of reciprocating movement with a frequency of 2 Hz and amplitude of 50 mm.

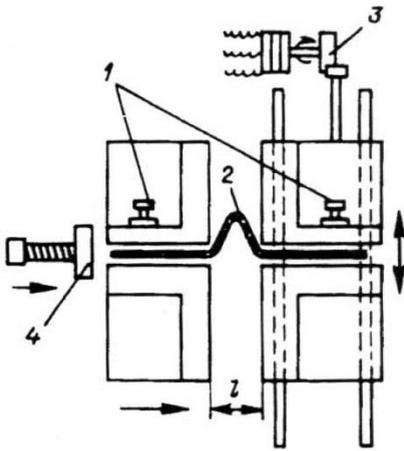


Fig. 2.3.5.3:

1 — grip; 2 — test specimen; 3 — eccentric motor; 4 — lateral movement of a specimen loop.

### 2.3.6 Determination of relative glass content in glass-reinforced plastic by mass.

In a furnace at temperature of  $625 \pm 25$  °C resin is removed from a specimen of length and width equal to  $(10 \pm 1.0) \times (10 \pm 1.0)$  multiplied by thickness of the bar, the mass of which together with a crucible shall be determined with accuracy up to 0.01 g.

The glass content in the mass in per cent  $S$ , %, is determined as per formula:

$$S = (G_2 - G_0) \cdot 100 / (G_1 - G_0),$$

where  $G_1$  and  $G_2$  is mass of the crucible together with the specimen before and after roasting, g;

$G_0$  is mass of the empty roasted crucible, g.

### 2.3.7 Determination of apparent density of foam plastics.

Apparent density of foam plastics shall be determined on specimens of a regular geometric shape and of a volume at least equal to  $100 \text{ cm}^3$ .

Before conditioning in accordance

with 2.3.1.1, the specimens shall be dried at temperature of  $40 \pm 5$  °C to its constant mass.

The apparent density is determined as the ratio of the mass of the specimen to its volume, in  $\text{m}^3$ .

### 2.3.8 Determination of shrinkage of plastics at limiting temperature.

A specimen of  $(100 \pm 1) \times (100 \pm 1) \times (15 \pm 0.5)$  mm in size is conditioned at the appropriate temperature during 48 hours.

Shrinkage is determined as the ratio, in per cent, of linear deformation to the appropriate original size of the specimen.

### 2.3.9 Water absorption test

**2.3.9.1** Water absorption shall be determined having the dimensions  $(50 \pm 1) \times (50 \pm 1)$ , and thickness equal to the product thickness but not more than  $50 \pm 1$  mm.

Before testing, the specimens shall be dried to constant mass. Drying conditions are specified by relevant standards. After drying and weighing, the specimen are immersed into distilled water and kept at a temperature of  $23 \pm 2$  °C during 24 hours. Then, they are weighed again. Before the latter weighing, water shall be removed from the specimen surface.

Water absorption is obtained as a fraction of absorbed water related to the mass of the dry specimen.

Water absorption of foamed plastics is determined as mass of absorbed water related to the surface area of the specimen.

**2.3.9.2** A sample with dimensions depending on the required number and dimensions of specimens is immersed into fresh water with a temperature of  $23 \pm 2$  °C, to a depth of 1.25 m, and conditioned for 7 days.

Before testing, as well as a day and

7 days after immersion, the sample is weighed.

After conditioning test specimens are prepared from the sample for carrying out the required tests.

### 2.3.10 Ageing test.

**2.3.10.1** A sample, which dimensions are determined depending on the required number and dimensions of test specimens is conditioned in semi-immersed condition in the artificial sea water with a temperature  $23 \pm 2$  °C for 30 days. In the process of conditioning the sample shall be subjected every day to two-hour ultra-violet irradiation with 500 W lamp placed at a distance of 50 cm from it.

After conditioning test specimens are prepared from the sample for carrying out the required tests.

**2.3.10.2** Two samples, the size of which is determined proceeding from the number and size of specimens required are kept suspended during 7 days at ambient temperature  $70 \pm 1$  °C, one of the samples being suspended in a closed volume above water.

After that, the same number of test specimens is prepared out of each sample.

**2.3.10.3** The test for creasing and stability of shape after ageing is effected on square specimens with a side measuring  $100 \pm 5$  mm, which are folded in two directions, parallel to the edges and at right angles to each other, unfolded and then folded once more along the same folds, but in the opposite direction.

After each folding, the edge is smoothed down with fingers.

**2.3.10.4** A sample, which size is determined proceeding from the number and size of specimens required, is subjected to the ultra-violet irradiation by means of a lamp having a power of 500 W

from a distance of 50 cm during 30 hours for type 1 retro-reflective material and during 60 hours for type 2 material.

### 2.3.11 Petroleum products resistance test

**2.3.11.1** A disc-shaped specimen of  $70 \pm 5$  mm in diameter is inserted into a testing arrangement as shown in Fig. 2.3.11.

The testing arrangement is filled up to the level of 20 mm with oils mixture in the following proportion:

- 30 % of 2, 3, 4-trimethylethane;
- 50 % of toluene;
- 15 % of diisobutylene;
- 5 % of ethanol.

On agreement with the Register, other oil products may be used, such as diesel fuel, petrol etc.

The specimen is conditioned in oils during 22 hours at a temperature of  $20 \pm 2$  °C.

When the test specimen is extracted, it shall be dried a little bit, the wet surface folded in two and the halves pressed to each other. Wetted surfaces shall not stick to each other. When probing the surface with the finger, the latter shall not be stained.

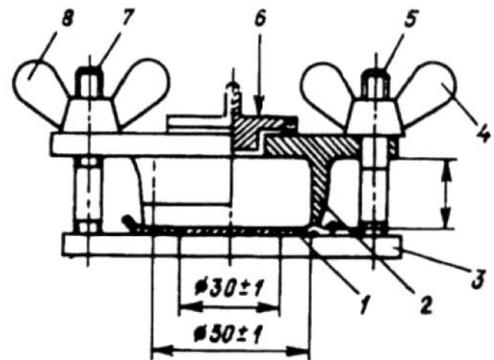


Fig. 2.3.11:

1 — sample; 2 — cylinder-shaped chamber;

- 3 — base with a 30 mm aperture;
- 4 and 8 — nuts;
- 5 and 7 — threaded cogs for chamber clamping with nuts;
- 6 — cover for liquid.

**2.3.11.2** A sample, which size is determined proceeding from the number and size of specimens required, is immersed in diesel oil having a temperature of  $23 \pm 2$  °C and conditioned there for 30 days.

After conditioning test specimens are prepared from the sample for carrying out the required tests.

**2.3.11.3** A sample, which size is determined proceeding from the number and size of specimens required, is immersed in diesel oil or high octane petrol having a temperature of  $23 \pm 2$  °C to a depth of 100 mm and conditioned there during 24 hours.

**2.3.11.4** Samples, which size is determined proceeding from the number and size of specimens required, are immersed in crude oil, fuel oil, diesel fuel, high octane petrol and kerosene having a temperature of  $23 \pm 2$  °C to a depth of 100 mm and conditioned there for 14 days.

After conditioning test specimens are prepared from the sample for carrying out the required tests.

### **2.3.12 Water resistance test.**

**2.3.12.1** A sample, which dimensions are determined depending on the required number and size of test specimens, is immersed in artificial sea water with a temperature of  $23 \pm 2$  °C and conditioned during 5 months.

After conditioning test specimens are prepared from the sample for carrying out the required tests.

**2.3.12.2** In the case of laminated

textiles, a sample measuring  $300 \times 200$  mm glued along the perimeter shall be conditioned in salty water with salt concentration 3.3-3.8 % during 4 hours at a temperature of  $40 \pm 1$  °C and at a depth of 500 mm.

**2.3.12.3** Specimens of retro-reflective material measuring  $(70 \pm 5) \times (150 \pm 5)$  mm, which are secured on an aluminium panel and have an X-shaped diagonal cut in them, are conditioned in artificial sea water at a temperature of  $23 \pm 2$  °C in semisubmersed condition during 16 hours in enclosed volume.

After conditioning, the salt residues on the specimen surface shall be washed off.

**2.3.12.4** Specimens of retro-reflective material measuring  $(70 \pm 5) \times (150 \pm 5)$  mm, which are secured on an aluminium panel, are sprayed with 5 % salt solution and conditioned at a temperature of  $35 \pm 2$  °C for two days.

During conditioning, the specimens are dried for 2 hours every 22 hours.

**2.3.12.5** Specimens of retro-reflective material manufactured and mounted in conformity with 2.3.2.7 are soaked in distilled and artificial sea water during 16 hours in enclosed volume.

### **2.3.13 Air permeability test.**

A disc-shaped specimen having a diameter of 350 mm is covered with wax in such a way that its centre, 290 mm in diameter, is left open, and then clamped between the flanges of the testing apparatus as shown in Fig. 2.3.13.

From below, a positive air pressure of 27.5 kPa acts upon the test specimen. In 10 to 15 minutes, the specimen is so immersed in water that its uppermost point is 13 mm below the surface. 1 minute later no air bubbles shall remain

on the specimen surface.

Within the following 5 minutes no bubbles shall rise to the surface.

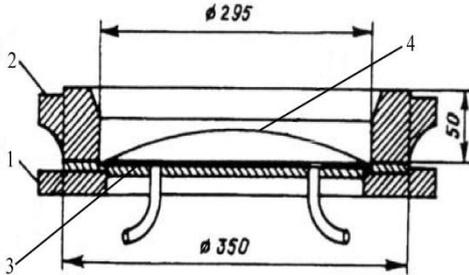


Fig. 2.3.13:

1 — lower part with air inflow; 2 — upper part which is subject to clamping; 3 — tested specimen; 4 — specimen surface during the test.

### 2.3.14 Cold resistance test.

The cold resistance test of laminated textiles is effected on rectangular specimens measuring  $(100 \pm 5) \times (50 \pm 5)$  mm.

After being conditioned at a temperature ranging from  $-30$  to  $-5$  °C during 1 hour, and from  $-60$  to  $-5$  °C during 10 minutes, the specimens shall be bent through an angle of  $90^\circ$ .

A sketch of testing apparatus is shown in Fig. 2.3.14.

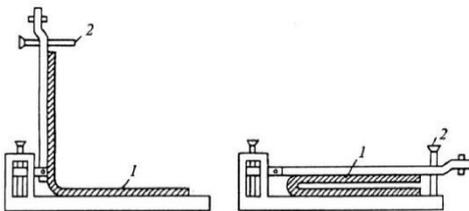


Fig. 2.3.14 Sketch of testing machine:

1 — specimen; 2 — regulating screw.

By the end of the test the distance between the parallel parts of the test specimen shall equal four times its

thickness.

### 2.3.15 Ozone resistance test.

A test specimen is bent through  $180^\circ$  round a mandrel equalling six times the specimen thickness in diameter and subjected during 1 hour to the influence of air with ozone concentration of 50 mmHg at a temperature of  $30 \pm 2$  °C and the relative humidity of 26 %.

2.3.16 A sample, the size of which is determined proceeding from the number and size of specimens required, is successively exposed to ambient air at a temperature of  $-40$  and  $+70$  °C at 8-hour intervals for foam plastics and at 24 hours intervals for retro-reflective materials.

### 2.3.17 Vibration load test.

A test specimen, the type and size of which are determined proceeding from the expected service of the product, is mounted on a vibration-testing machine and subjected to vibration loads having the following parameters:

oscillation amplitude — 2.5 mm;

frequency range — 5 to 500 Hz with a difference of frequency of 32 Hz and amplitude of vibration acceleration of 10 g.

### 2.3.18 Determining the retro-reflection factor of a material.

2.3.18.1 The retro-reflection factor is determined on square specimens measuring  $150 \pm 5$  mm. The entrance and observation angles are adopted in accordance with Table 6.7.2.2.

Measurements are taken at the turning angles of reference plane between  $0$  and  $180^\circ$  with the spacing not exceeding  $30^\circ$ .

2.3.18.2 The retro-reflection factor for a material staying under a film of water is determined on specimens measuring  $(150 \pm 5) \times (75 \pm 5)$  mm secured on a

vertical plane in the transverse direction.

During testing, the specimen stays under a continuously moving film of water. A sketch of the testing machine shall be found in Fig. 2.3.18.2.

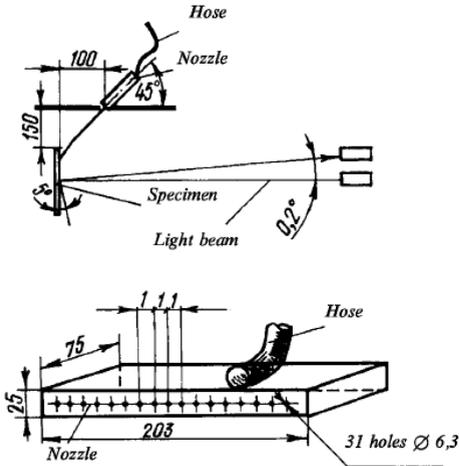


Fig. 2.3.18.2

Measurements are taken at the observation angle of  $0.2^\circ$  and entrance angle of  $5^\circ$ .

**2.3.19** The bend test of retro-reflective materials is made on specimens measuring  $(25 \pm 5) \times (150 \pm 5)$  mm after they have been conditioned, together with a metallic mandrel 3.2 mm in diameter, in a heating chamber at a temperature of  $30^\circ\text{C}$ . The specimens shall be wrapped on the mandrel by a slight touch of the finger.

Retro-reflective materials with an adhesive layer are tested after the removal of protective paper.

**2.3.20** The adhesion test of retro-reflective materials is made on square specimens measuring  $100 \pm 5$  mm.

Two specimens are fitted between glass plates 3 mm thick, with their retro-reflective surfaces facing each other and under a load, the mass of which is 18 kg,

and conditioned in the heating chamber at a temperature of  $65 \pm 2^\circ\text{C}$  during 8 hours.

After being conditioned, the specimens are cooled at a temperature of  $23 \pm 2^\circ\text{C}$  during 5 minutes.

**2.3.21** Retro-reflective materials are tested for fungus resistance using square specimens measuring  $75 \pm 2$  mm, which are secured on an aluminium panel.

The specimens are conditioned in the soil during two weeks.

After being conditioned, the specimens are wiped clean with a soft cloth wetted in the 70 % solution of ethanol alcohol and then conditioned in accordance with 2.3.1.1 during 48 hours.

The microbiological activity of the soil is determined on untreated cotton cloth. After being soil-conditioned for 5 days, the ultimate strength of the cloth with a density of 400 to  $475 \text{ g/m}^2$  shall not be less than 50 % of the initial value.

**2.3.22** The abrasion-resistance test of retro-reflective material is made on specimens measuring  $(150 \pm 5) \times (425 \pm 5)$  mm, which are secured on an aluminium panel.

The panel, which is fixed in the testing machine, is subjected to 1,000 cycles of the reciprocating action of bristles at a frequency of  $37 \pm 2$  cycles per minute.

For testing, trimmed black bristles of a pig are used arranged in clusters in 60 openings 4 mm in diameter on a block measuring  $(90 \pm 5) \times (40 \pm 5) \times (12.5 \pm 5)$  mm and having a total weight of  $450 \pm 15$  g. The bristles shall project above the block surface by not more than 20 mm.

**2.3.23** The contaminant-resistance test of retro-reflective material is made on square specimens measuring  $150 \pm 5$  mm,

which are secured on an aluminium panel.

The specimens are covered with a contaminant layer 0.075 mm thick, a laboratory glass is placed above, and so they remain for 24 hours.

After conditioning, the specimens are wiped clean of the contaminant with a soft cloth wetted in white spirit, washed with 1 % solution of a detergent and rinsed in water.

The contaminant used for testing shall have the following composition by weight: 8 parts of soot, 60 parts of mineral oil and 32 parts of white spirit.

## **2.4 WELDABILITY TEST**

**2.4.1** The Subsection contains general requirements for the weldability testing procedure of materials being approved.

The Register reserves the right to increase or reduce the number of such tests.

Among the products tested for weldability there are rolled steel, steel castings, steel forgings and aluminium alloys applied in welded ship structures.

The test is carried out under the supervision of the Register or in a laboratory recognized by that body.

**2.4.2** The weldability of a material shall be examined in the course of approval tests by using the same welding methods that would be applied when producing structures subject to survey by the Register. The welding methods are indicated in the approval documentation for the material.

**2.4.3** During the weldability test the following shall be determined:

- .1** chemical composition and mechanical properties of the base metal;
- .2** cold cracking resistance;

**.3** susceptibility to ageing according to 2.2.3.4;

**.4** properties of butt weld according to Section 4, Part XIV "Welding".

**2.4.4** The tests mentioned under 2.4.3 shall be made on plates or other products of maximum thickness taken from at least three different casts.

**2.4.5** For metallic materials other than steel the weldability in each particular case is determined proceeding from the results of tests made in conformity with the Register approved program or according to the standards approved by the Register.

## **2.5 TESTING OF ICE-RESISTANT COATINGS**

**2.5.1** Assessment of anticorrosive properties in sea water.

**2.5.1.1** Tests shall be carried out in compliance with ISO 12944-6 for a corrosivity category Im2 in compliance with ISO 12944-2.

The duration of testing shall be set for the coating lifetime more than 15 years.

**2.5.1.2** Preparation of test specimens.

Panels for testing shall be made of the steel of the grade used in practice.

The panel shall be dimensioned 150 × 70 mm as a minimum.

The panel thickness shall be least 2 mm, depending on the test.

The panel surface shall be worked by abrasive blasting to standard Sa 2½ or Sa 3 as per ISO 8501-1.

The surface roughness (profile) shall correspond to an average value (G) as per ISO 8503-1 and can be checked using a standard as per ISO 8503-2.

Three panels shall be prepared for each type of tests.

Paint shall be applied according to the manufacturer's instructions. It is recommended to apply paint on the panel by airless spraying method. Each layer shall be uniform in thickness and look homogeneous, have no runs, sags, holidays, gas bubbles, wrinkles, blushing changes, paint lack, hard particle inclusions, dried top skin and blisters.

The thickness of a dry film as per ISO 2808 shall not exceed the nominal value by more than 20 %.

Prior to testing, the painted test panels shall be conditioned during three weeks at normal temperature  $23 \pm 2$  °C and a relative humidity  $50 \pm 5$  % or at temperature  $20 \pm 2$  °C and a relative humidity  $65 \pm 5$  %.

The panel edges and back side shall be properly protected.

In order to confirm a large lifetime in sea water, the tests shall be carried out according to the following:

ISO 7253 (neutral salt spray) during 1,440 hours;

ISO 2812-2 (immersion in water) during 3,000 hours.

**2.5.1.3** Assessment of the coating system before artificial ageing in the salt spray and when immersed in water.

Prior to testing, the adhesion assessed by the crosscut method as per ISO 2409 shall be classed 0 or 1.

For the coating system over 250 µm thick, the test as per ISO 4624 shall be carried out instead of the test as per ISO 2409.

The coating is considered to have passed the test if the substrate (A/B) adhesion is retained intact at a pull-off force of less than 5 MPa.

#### **2.5.1.4** Salt spray tests.

The specimens to be tested in a salt spray chamber shall be notched to a substrate with length of 50 mm and at a distance of at least 20 mm from the test specimen edge.

The method principle consists in conditioning the painted specimens in the salt spray chamber with the following assessment of the extent of the paint coating destruction.

The test specimens shall be placed in the chamber facing upwards at an angle of  $25 \pm 5^\circ$  to the vertical.

The specimens shall be placed in such a way as to avoid the contact with each other or the chamber, and the solution shall be freely sprayed on the surface exposed.

The specimens shall be placed at the same level, so that the solution drops may not drain off the plates or their supports onto the other specimens placed below.

The temperature inside the chamber shall be within  $35 \pm 2$  °C.

In every 24 hours, as a minimum, the average rate of solution accumulation in each collector for a horizontal collecting area of 80 cm<sup>2</sup> (a funnel of 100 mm in diameter) shall be measured and be equal to 1-2.5 ml/h. The sodium chloride concentration in each collector shall be  $50 \pm 10$  g/l, pH = 6.5-7.2.

The specimens shall be periodically visually examined as per Parts 2-5, ISO 4628, leaving therewith the surfaces under test undamaged.

The examination time shall not exceed 30 min.

The examinations shall be performed once in 24 hours at the most and at the same time of a day. The specimens shall not fully dry out during the examination and, following the latter, shall be

immediately returned into the test chamber.

**2.5.1.5** Water immersion test as per ISO 2812-2.

The tests shall be carried out in a properly dimensioned tank (recommended dimensions are  $700 \times 400 \times 400$  mm).

The tank shall have closing appliances, be heat-resistant

and be provided with a water solution circulation and aeration system. The solution concentration shall be maintained at the level of 50 g of NaCl per  $1 \text{ dm}^3$  of water.

The temperature of water in the tank shall be  $40 \pm 1$  °C.

The specimens shall be immersed in the tank to  $\frac{3}{4}$  of their length at a distance of 30 mm from one another, the tank sides and bottom. The specimen holders shall be positioned so that the specimens are inclined at an angle of 15-20° to the vertical, and the surface under study shall therewith be at the top and parallel to the direction of a water flow in the tank.

The specimen positions shall be periodically interchanged.

The intermediate examinations of specimens shall be carried out in 1, 3 and 5 weeks and every 250 hours of the test.

During the intermediate examinations each specimen shall be taken out of the tank, blotted with a filter paper and the extent of its coating destruction shall be assessed as per Parts 1-5, ISO 4628 during 1 minute. Following that, the specimen shall be immediately returned into the tank.

**2.5.1.6** Assessment after artificial ageing test during the set time.

After the artificial ageing test in compliance with ISO 7253, any substrate corrosion due to a scratch shall not exceed 1 mm if determined by Formula (2.5.1.6.2).

Any defects within 1 cm from the panel edges shall be ignored.

**2.5.1.6.1** Scratching.

An engraving machine is recommended for use to get reproducible results. Where it is impracticable, the device for scratching shall correspond to the description in 4.1.1, ISO 2409:1992 (a single-bladed cutting tool).

The scratch may be horizontal, vertical or diagonal. It shall be at least 50 mm long, besides it shall be at least 20 mm away from each edge and shall extend to the very surface of the metal at any point of its length.

*Table 2.5.1.6.1 Requirements for coating condition set-time artificial ageing test during the set time*

Ser. No.	Assessment method	Requirements
1	Standard ISO 4628-2	Blistering 0(S0), (assessed without delay)
2	Standard ISO 4628-3	Rusting Ri0, (without delay)
3	Standard ISO 4628-4	Cracking 0(S0), (without delay)
4	Standard ISO 4628-5	Flaking 0(S0), (without delay)

**2.5.1.6.2** Assessment of corrosion lengthwise of scratch.

After salt spray test, the maximum width  $C$ , in mm, of corrosion across the scratch shall be measured. The substrate corrosion  $M$  caused by the scratch is determined by the formula:

$$M = (C - W)/2, \text{ (2.5.1.6.2),}$$

where  $W$  is the initial width of the scratch, in mm.

#### **2.5.1.7 Other assessment methods. Requirements.**

The adhesion assessed (in 24 hours after conditioning) by the crosscut test method as per ISO 2409 shall be classed 0 or 1.

Where the thickness of the dry film of a paint coating system exceeds  $250\ \mu\text{m}$ , the pull-off test for adhesion as per ISO 4624 instead of using the crosscut test method as per ISO 2409 shall be carried out.

No defects are allowed for adhesion with the substrate (A/B) at a pull-off force of less than 5 MPa (assessment shall be performed after 24 hours of conditioning).

### **2.5.2 Assessment of resistance to low temperature.**

#### **2.5.2.1 Preparation of test specimens.**

Panels for tests shall be made of the steel of the grade used in practice.

The recommended specimen dimensions:  $150 \times 70\ \text{mm}$  or  $150 \times 100\ \text{mm}$ .

The thickness of unpainted plate shall be at least 2 mm.

The panel surface shall be worked by abrasive blasting to standard Sa 2½ or Sa 3 as per ISO 8501-1.

The surface roughness (profile) shall correspond to an average value (G) as per ISO 8503-1 and can be checked using a standard as per ISO 8503-2.

Four panels shall be prepared: 3 panels for testing and 1 check panel.

It is recommended to apply paint to the panel by airless spraying method. Each layer shall be uniform in thickness and look homogeneous. The thickness of a dry film as per ISO 2808 shall not exceed the

nominal value by more than 20 % (refer to 2.5.1.2).

Prior to test the painted test panels shall be conditioned during three weeks at a normal temperature  $23 \pm 2\ ^\circ\text{C}$  and a relative humidity  $50 \pm 5\ \%$  or at temperature  $20 \pm 2\ ^\circ\text{C}$  and a relative humidity  $65 \pm 5\ \%$ .

#### **2.5.2.2 Test procedure.**

Specimens shall be placed in a freezing chamber and conditioned at a temperature  $-60 \pm 3\ ^\circ\text{C}$  during 2 hours followed by the adhesion assessment within 20-25 seconds using the crosscut test method as per ISO 2409.

Where the thickness of the dry film of a paint coating system exceeds  $250\ \mu\text{m}$ , the X-cut test method as per ISO 16276-2 instead of using the crosscut test method as per ISO 2409 shall be carried out.

#### **2.5.2.3 Assessment of test results.**

Coatings are considered to have passed the tests if adhesion on two of three specimens is classed below 3 as per ISO 2409 and ISO 12276-2.

### **2.5.3 Determination of adhesion strength.**

The adhesion strength is determined using the pull-off test as per ISO 4624.

The test provides for measuring the force required to break the coating bond.

#### **2.5.3.1 Preparation of test specimens.**

The coating system to be tested is applied to the metal specimens of the same thickness (at least 3 mm) and surface texture.

The surface preparation and coating application shall be carried out in accordance with a process instruction for the coating system to be tested.

Prior to test the painted specimens shall be conditioned at a normal temperature  $23 \pm 2\ ^\circ\text{C}$  and a relative

humidity  $50 \pm 5\%$  during at least 16 hours.

#### 2.5.3.2 Preparation for tests.

After specimens drying and conditioning, dollies shall be bonded thereon.

When selecting an adhesive, its unmixed components shall not cause the visible coating changes within the time of the adhesive curing.

Adhesives, which give the highest results, are preferred.

In most cases, cyanoacrylate, two-component solventless epoxide and peroxide-catalyzed polyester adhesives shall be used.

The adhesives shall be prepared and applied according to the manufacturer's instructions. To secure a tight, continuous and uniform bond between the dolly and coating, the minimal amount of adhesive shall be applied.

After the adhesive curing (generally 24 hours), the adhesive and paint shall be cut about the dolly circumference penetrating through to the metal plate surface.

To reduce the deformation of the painted specimen during pulling off, a rigid metal ring shall be placed around the dolly.

#### 2.5.3.3 Test procedure.

During the test a tensile force shall be uniform across the entire tension area and be applied normally to the painted surface without any bending moment.

The tension stress rate shall not exceed 1 MPa/s and be perpendicular to the painted coating.

The test specimen shall fail within 90 seconds since tensioning.

To assess the adhesion strength, at least 6 determinations shall be carried out

at a temperature  $23 \pm 2^\circ\text{C}$  and a relative humidity  $50 \pm 5\%$ .

#### 2.5.3.4 Assessment of test results.

After six tests, the mean value of the adhesion strength shall be determined. The result shall be presented as the mean value and the range. The assessment of the mean percentage of the fracture area and the fracture type in the system being tested shall also be provided.

The fracture nature is presented as follows:

*A/B* — adhesive failure between substrate and the first coating layer;

*B* — cohesive failure of the first coating layer;

*B/C* — adhesive failure between the first and the second coating layers;

*n* — cohesive failure of the *n*-th layer of a multilayer coating system;

*n/m* — adhesive failure between the *n*-th layer and the *m*-th layer of a multilayer coating system;

*-Y* — adhesive failure between the final layer and adhesive;

*Y* — cohesive failure of adhesive;

*Y/Z* — adhesive failure between adhesive and dolly.

The area of fracture shall be estimated as a percentage to the nearest 10% for each type of fracture.

Where the failure is mainly associated with the adhesive, the test shall be repeated using another adhesive or, in order to reduce roughness, the surfaces of the coating and the test dolly may be abraded.

#### 2.5.4 Determination of abrasion resistance.

The method concept is determination of abrasion resistance of the coatings applied on a metal substrate with the Taber's abrader.

**2.5.4.1** Preparation of test specimens.

Metal specimens dimensioned  $100 \times 100 \times 3$  ( $\pm 0.5$ ) mm with a hole 8 mm in diameter at the specimen centre shall be prepared for testing.

The specimen surface preparation and coating application shall be carried out in accordance with the requirements of a process instruction for the coating system being tested.

If the coating is applied at a temperature 20-30 °C, abrasibility shall be determined at the earliest in three weeks after applying the last coating layer.

**2.5.4.2** Test procedure.

The abrasive wheel CS-17 at a 1,000 g loading shall be used in testing.

Coated specimens shall be weighed to accuracy 0.1 mg, and the coating thickness shall be measured at some points within the area to be tested for abrasion.

The coated specimen is placed and secured on a rotating platform. The abrasive wheels are lowered onto the specimen.

The nozzle of a vacuum pump is positioned at a distance of 1 mm above the abrasive disc. A counter is set to "0", and a suction level, to "50". Where the more efficient removal of abrasive dust is needed, the suction level may be increased up to "90". The number of cycles is set to "1,000": one cycle of abrasion corresponds to one revolution of the rotating platform.

The vacuum pump and rotating platform are started.

One more specimen, as a minimum, shall be tested.

After testing, the specimen is dismantled, the remains of abrasive dust

are removed and the specimen shall thereafter be weighed with to accuracy 0.1 mg.

**2.5.5 Determination of impact resistance in falling-weight testing.**

Testing shall be carried put according to ISO 6272.

The method concept is evaluation of resistance of a dry film of paint coating to cracking or peeling from a substrate when it is subjected to a deformation caused by a falling weight.

The tests shall be carried out using the special apparatus (e.g. of Y-2M type), which meets the requirements in ISO 6272, with the primary and secondary weights, and a die.

**2.5.5.1** Preparation of test specimens.

Test specimens shall be made of steel (e.g. of grade 08 as per GOST 9045-80) at least 0.25 mm thick (0.8 mm is preferred) and dimensioned  $70 \times 220$  mm to allow the test to be carried out at least at five positions spaced no less than 40 mm apart and at a distance of no less than 20 mm from the panel edge.

Each panel shall be prepared in accordance with ISO 1514 by cleaning it with a solvent (xylene, toluene or P-4) and wiping with a filter paper. The cleaning is considered satisfactory if no stains are visible on the paper.

Each coat of the coating system is applied separately on the prepared panels, i.e. impact resistance is checked separately for each paint coating.

The layer thickness and the time of coating drying shall comply with a specification.

After drying, the coating thickness shall be measured as per ISO 2808. The measurements shall be made at, or as near

as possible to, the positions where the test shall be carried out.

Immediately before the testing, the panel shall be conditioned at a temperature  $23 \pm 2$  °C and a relative air humidity  $50 \pm 5$  % during at least 16 hours.

#### 2.5.5.2 Test procedure.

The tests shall be carried out at a temperature  $23 \pm 2$  °C and a relative air humidity  $50 \pm 5$  %.

It shall be checked that the guide tube is vertical and the secondary weight is attached, if required, to the primary weight in order to achieve the required loading.

The height of the weight to the required release point (using the graduations on the guide tube) shall be adjusted and the weight shall be locked in position.

The test panel shall be placed on the die with the coated face up, the weight shall be released and allowed to fall on to the test panel.

#### 2.5.5.3 Assessment of test results.

The coating shall be examined with a magnifying glass with 10x magnification. The presence of cracking on the coating of the test panel or peeling from the substrate shall be reported.

The test shall be repeated four times at different positions, giving a total of five drops.

The coating is considered satisfactory if at least four test positions show no cracking or peeling from the substrate.

### 2.5.6 Determination of resistance to cathodic disbondment.

#### 2.5.6.1 Devices and apparatus.

The container of glass or another inert material not affecting the electrolyte pH shall be used for testing.

The container shall be at least 700 mm in diameter or have a side of at least 700 mm, be at least 200 mm high.

The container shall be provided with a system for electrolyte aeration.

The anode shall be made of graphite and be, as a minimum, 200 mm long or in diameter 10 mm, or be made of platinum wire, or platinum grid, or platinized titanium, or other material, which demonstrates the sufficient resistance to anodic polarization in sea water.

Calomel or chlorine-silver reference electrodes shall be used.

A voltmeter with the minimum resistance of 10 MOhm shall provide the measurements within 0-2 V to accuracy 1 mV.

A cathode protective circuit supplied from a DC source and being able to maintain an electrode potential of  $1050 \pm 5$  mV on a test specimen with respect to a saturated calomel reference electrode shall be used.

It is preferable to use potentiostatic control, but a galvanostat is also acceptable.

Representative cathode circuits are shown in Figs 2.5.6.1 and 2.5.6.2.

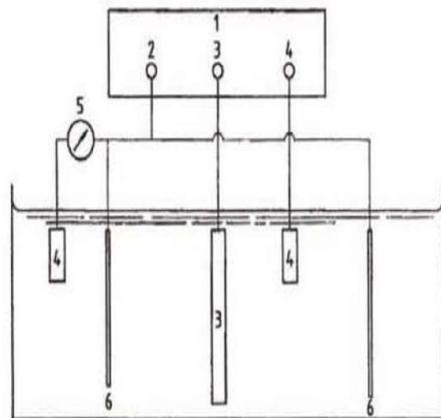


Fig. 2.5.6.1-1 Cathode protection circuit with potentiostatic control:

1 — potentiostat; 2 — work electrode; 3 — anode; 4 — reference electrode; 5 — voltmeter; 6 — test specimen.

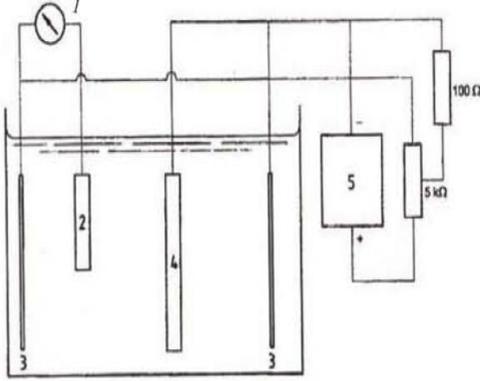


Fig. 2.5.6.1-2 Cathode protection circuit with galvanostatic control:

1 — voltmeter; 2 — reference electrode; 3 — test specimen; 4 — anode; 5 — DC source.

### 2.5.6.2 Preparation of test specimens.

Plates for testing shall be made of the steel of the grade used in practice.

The recommended specimen dimensions: 150 × 70 × 2 mm.

Each panel shall have an insulated conductor with a reliable electrical contact not subjected to corrosion.

The specimen surface preparation and coating application shall be carried out in accordance with the requirements of a process instruction for the coating system being tested.

If the requirements are not specified, the panels shall be worked by abrasive blasting according to ISO 1514. Thereupon, the panels shall be painted as per the specification for the coating system.

It is recommended to apply the same coating system on the panel backside and

edges. To prevent edge effect, a thicker film shall be applied on the edges.

All the unpainted surfaces of test specimens and the connections of insulated conductors shall be protected with a coating or paraffin melted at a temperature of 70 °C, or solvent-free epoxyresin, or another suitable coating with the better protective properties than the material under test.

Three check panels, which will not be connected to the cathode controlled system, shall also be prepared.

Thickness of specimens coating shall be measured as per ISO 2808.

Prior to the commencement of testing, a hole  $10 \pm 1$  mm in diameter shall be made in the coating of each test specimen at a distance of more than 30 mm from the panel edge in any suitable manner but preferably by means of an abrasive jet.

Then the test panels shall be checked for the presence of random pores at a voltage of 10 kV using a continuity detector.

Three panels shall be used in cathode disbondment testing.

### 2.5.6.3 Preparation for tests.

The anode shall be placed at the centre of a tank and connected to the positive pole of the cathode protective circuit.

Each panel shall be numbered by a suitable material, which will remain intact in testing.

Each panel in the tank shall be placed away from the anode and the tank bottom by more than 300 mm and 50 mm, respectively, and completely immersed in electrolyte after filling the tank.

The electrolyte composition is given in Table 2.5.6.3. Make sure that the panels do not touch one another and the tank sides, and that the side of the panel with a

holed coating is not screened from the anode with anything including other panels, and also that nothing interferes with the electrolyte flow around, and between the panels.

Each plate with a negative pole shall be connected to the cathode protective circuit with an insulated conductor.

The check panels shall be similarly placed in an equivalent tank having no anode and cathode protective circuit.

The tank shall be filled with electrolyte to the level of at least 200 mm. Electrolyte temperature shall be maintained at a level of  $23 \pm 2$  °C.

**Table 2.5.6.3 Electrolyte composition (artificial sea water)**

Component	Concentration, g/l
Sodium chloride	23
Magnesium chloride hexahydrate	9.8
Sodium sulfate decahydrate	8.9
Calcium chloride	1.2

#### 2.5.6.4 Test procedure.

The continuous flow of electrolyte in the tank shall be maintained.

Electrolyte in the vessel shall be fully replaced within 3 days at most.

It is allowed to replace the electrolyte each 7 days, but not less frequently.

Electrode potential shall be  $1050 \pm 5$  mV relative to the reference electrode.

Potential shall be controlled once per 24 hours or more frequently, if necessary.

Test duration is 26 weeks.

#### 2.5.6.5 Assessment of the results.

Test and reference plates shall be subject to non-destructive testing.

At intermediate examinations, the panels shall be quickly disconnected from the circuit, removed from the tank and washed with the tap water avoiding damages to the coating and removing the cathode sediment at the coating hole.

The plated shall remain wet during examinations.

The blisters appeared shall be assessed according to ISO 4628-2, considering the distance from the blisters to the hole.

The results obtained on test and check specimens shall be compared.

Occurrences of coating flaking off the base metal of the hole shall be recorded.

After testing, the panels shall be washed in the tap water avoiding damages to the coating.

The coating shall be fully examined and assessed according to ISO 4628-2, considering the blisters and hole spacing.

The blisters shall be divided into groups: related to the hole and remote from it.

The blisters developed in the areas with the film thickness less than required shall be ignored during the assessment.

The adhesion failure is determined as follows:

- two cuts crossing the hole shall be made with a sharp knife on the coating penetrating it to the substrate.

The coating around the hole is separated from the substrate with a knife tip;

- an approximate distance, in mm, for which the coating may be separated from the substrate as compared with the check specimens, shall be reported.

The results obtained on test and check specimens shall be compared.

#### 2.5.7 Determination of a wetting interfacial angle.

**2.5.7.1** The wetting angle is the angle formed by tangent planes to the interphase surfaces, which restrict the wetting liquid, and an angular point is aligned with the boundary line of three phases (refer to Fig. 2.5.7.1).

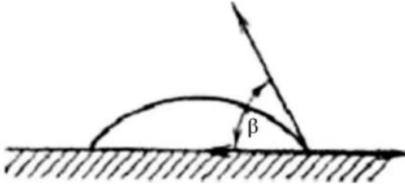


Fig. 2.5.7.1 Wettability of a solid body with liquid:

$\beta$  — wetting interfacial angle.

The wetting angle is determined by projecting a drop on a screen.

**2.5.7.2** Description of a device recommended for determination of a contact wetting angle (refer to Fig. 2.5.7.2).

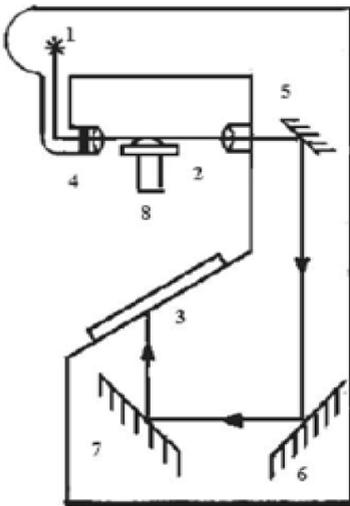


Fig. 2.5.7.2 Device recommended for determining the wetting interfacial angle:

1 — lamp; 2 — lens; 3 — screen glass; 4 — heat filter; 5, 6, 7 — mirrors; 8 — holder of the surface with a drop.

The device is arranged as follows.

The lamp 1 illuminates the surface under study placed on a holder 8, with a drop being projected with an objective lens 2 onto the frosted glass of a screen 3. Light beams pass through a heat filter 4, and are reflected by mirrors 5, 6 and 7 placed in a device case.

The size of the drop image on the screen may be changed with interchangeable lenses (with a different focal distance). A gadget for measuring a wetting angle is fastened to the plotting board of the screen.

**2.5.7.3** Measurements shall be carried out with a protractor.

The angle between the contour of the panel surface and the tangent to the drop contour at the point of drop touching the panel surface shall be measured.

### 3. STEEL AND CAST IRON

#### 3.1 GENERAL

**3.1.1** These requirements are

applicable to hull structural steel, steel for boilers, heat exchangers and pressure

vessels, steel pipes, steel for structures operated at low temperatures, chain cables, steel forgings, steel and iron castings and steel wire ropes.

In accordance with 1.1.4, all materials, semi-finished products and other products specified in this chapter shall be manufactured by firms which are recognized in accordance with 1.3.1.4.

A recognition procedure for manufacturers of hull structural steel, which is given in 1.3.5, is equally applicable to works manufacturing the following goods:

**.1** steel for boilers, heat exchangers and pressure vessels (refer to Subsection 3.3);

**.2** steel for structures operating at low temperatures (refer to Subsection 3.5);

**.3** high strength steel for welded structures (refer to Subsection 3.13);

**.4** Z-steel (refer to Subsection 3.14).

At the same time, provisions of a works recognition procedure stated in 1.3.5, which concern rolling modes, scope of tests, sampling, types and procedures of tests, as well as requirements to test results, shall be specified and agreed in the course of test programs consideration.

**3.1.2** semi-finished products manufactured according to standards or other technical requirements may be used if it has been proved that the above mentioned requirements are equivalent to those established by the Rules.

**3.1.3** Steel shall be melted in oxygen steel-making convertors, electric or open-hearth furnaces, and cast iron shall be melted in cupolas or electric furnaces. Steel is deoxidated as per requirements of Tables 3.2.2-1 and 3.2.2-2. The conditions of steel supply shall meet the requirements of Tables 3.2.4-1 and 3.2.4-2.

Use of other methods of steel and cast iron making shall be agreed with the Register.

When steel is not produced at the works where it is rolled, forged or drawn, a certificate shall be supplied to the Surveyor at the mill engaged in further processing of the steel stating the steel works, process of manufacture, number of cast and chemical composition of steel.

The surveyor shall have access to steel melting works and steel rolling works.

## **3.2 HULL STRUCTURAL STEEL**

### **3.2.1 General.**

**3.2.1.1** The requirements of this subsection are applicable to hot-rolled steel used for plates, strips, sections and bars, and intended for hull structures and components being subject to the Register survey during their manufacture.

Hull structural steel is conventionally divided into normal strength steel (with a minimum yield stress of 235 MPa) and higher strength steel (three strength levels, with minimum yield stresses of 315, 355 and 390 MPa respectively). The requirements to high strength steel (with minimum yield stress of 420 MPa) are specified in Subsection 3.13.

The steel is subdivided into grades as shown in Tables 3.2.2-1 (for normal strength steel), 3.2.2-2, 3.2.3 and 3.5.2.3 (for higher strength steel) depending on the values and conditions required for the performance of impact testing.

In Table 3.13.3-1, respective values for high strength steel are specified.

Requirements of this Subsection, depending on rolled steel thickness, are applicable to steel of the following types:

*steel plates and strips* of all grades, up to 100 mm thick;

*steel sections and bars* of all grades, up to 50 mm thick.

The requirements for steel rolled products of a larger thickness than specified above may be different from the stated ones, but shall be considered in each particular case and agreed with the Register.

Steel, which does not fully meet the requirements stated in the present Subsection, differs in chemical composition, deoxidation practice and alloying as well as in mechanical properties (e.g. intermediate upper yield stress level, as compared to that required in 3.2.3, and other respective characteristics) may be accepted by the Register upon special consideration.

Such steel shall be given a special designation, the letter S may be added to the grade symbol.

**3.2.1.2** The recognition of steel rolled products manufacturers by the Register shall be carried out in accordance with 1.3.5 for each steel grade stated by the manufacturer, for the semi-finished product type and condition of supply.

Where different steel production technologies are used at the works, materials approval is carried out individually for each of them.

The weldability of each steel grade and its suitability for bending shall be confirmed by the manufacturer during the initial recognition of steel rolled products by the Register.

The survey and tests at the manufacturer's during its recognition by the Register are conducted in accordance with the program (chart) agreed with the Register.

**3.2.1.3** Responsibility of the manufacturer, which is defined in his specification, guarantees that required production processes, control systems and methods are used.

If control system detects cases of product quality degradation, the manufacturer shall identify the cause and take all measure to prevent its recurrence. A report on investigations performed and respective actions taken shall be submitted to the Register representative. Products with abovementioned deviations may be allowed to use for the intended purpose, if test results are positive.

In order to recover confidence in products quality level and obtained results stability, scope and frequency of tests may be increased on the discretion of the Register.

**3.2.1.4** Rolling procedures for normal and higher strength steel, which are employed by the manufacturer, shall comply with the conditions of supply specified in 3.2.4, of higher strength Grade F steel — with the conditions of supply specified in 3.5.2.4, and of high strength steel — with the conditions of supply specified in 3.13.4.

The applicable rolling procedures are presented in Table 3.2.1.4 in the form of diagrams, and their definitions are given below.

(AR), a s - r o l l e d, is the procedure, which involves the rolling of steel at high temperature followed by air cooling. The rolling and finishing temperatures are typically in the austenite recrystallization region and above the normalising temperature.

The strength and toughness properties of steel produced by the process are generally less than those of steel after

heat treatment or thermo-mechanical treatment.

(N), normalising, is the procedure, which involves heating of rolled steel above the critical temperature  $A_{C3}$  and in the lower end of the austenite recrystallization region followed by air cooling. The process improves the mechanical properties of as-rolled steel by refining the grain size.

(CR) controlled rolling (normalising rolling, NR) is the rolling procedure, in which the final deformation is carried out in the normalising temperature range, resulting in a material condition generally equivalent to that obtained by normalising.

(TM) thermo-mechanical rolling (termomechanical controlled rolling, TMCP) is a procedure, which involves the strict control of both the steel temperature and the rolling reduction. Metal is mostly deformed at temperatures close to  $A_{r3}$  temperature; deformation may be finished in dual-phase temperature region.

Unlike controlled rolling (normalised rolling), properties obtained after thermo-mechanical treatment cannot be

reproduced by normalising or other types of heat treatment.

The use of accelerated cooling on completion of thermo-mechanical rolling, as well as tempering after thermo-mechanical rolling is a subject of a special consideration by and agreement with the Register.

(AcC) accelerated cooling is a process which provides steel properties improvement due to steel controlled cooling with rate higher than air cooling. This process is performed immediately after deformation by thermo-mechanical rolling is finished.

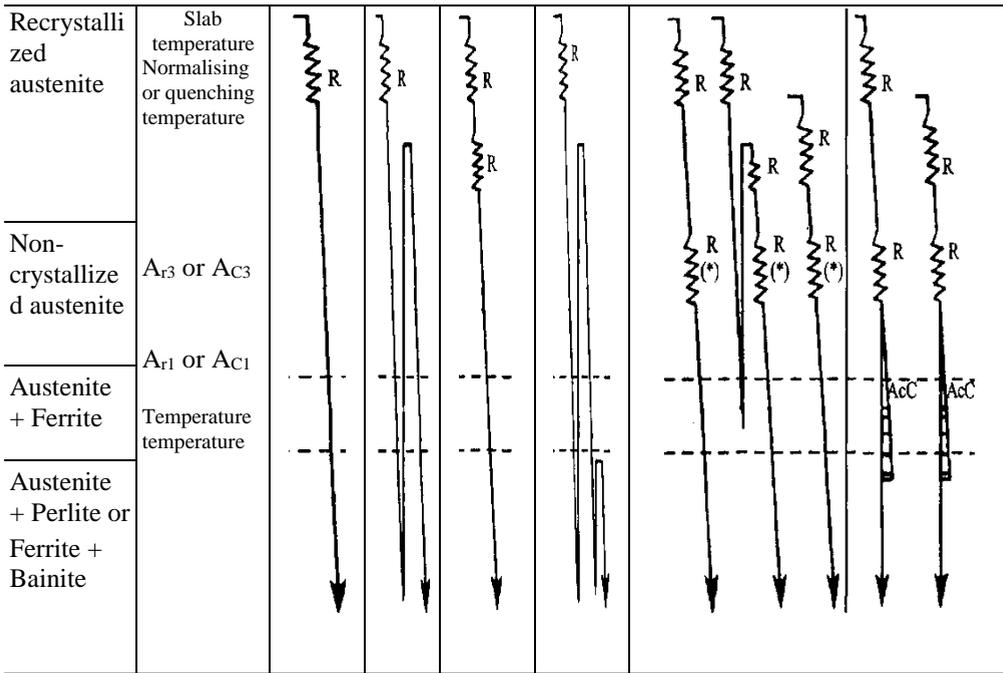
This definition is not applicable to direct quenching.

Properties obtained after TM and AcC rolling cannot be reproduced by normalising or other types of thermal treatment.

(QT) quenching and tempering is a process which includes heating above  $A_{C3}$  temperature with subsequent cooling at a determined rate, which allows obtaining of strengthened microstructure. Tempering which correspond to quenching is a process of repeated heating to a temperature which not exceeds  $A_{C1}$ , in order to improve microstructure and recover steel impact energy (KV).

Table 3.2.1.4 Diagrams of steel processing procedures

Steel structure	Temperature	Process type				
		Conventional types of steel				Thermo-mechanical rolling
		AR	N	CR (NR)	QT	TM



Symbols:

R — reduction;

(\*) — temperature of the dual-phase region of austenite and ferrite;

CR(NR) — Controlled Rolling (Normalising Rolling);

TM — Thermo-Mechanical Rolling (Thermo-Mechanical Controlled Process);

AR — as rolling procedure corresponding to hot-rolled steel making (As-Rolled);

AcC — Accelerated Cooling;

N — Normalising;

QT — Quenching and Tempering.

**3.2.1.5** During works survey, the Register representative shall be provided on his demand with documentation, which regulates rolling and thermal treatment modes (CR, TM or TM with AcC, normalising, quenching with tempering etc.).

In accordance with the requirements of 3.2.1.3, the manufacturer is responsible for observance all specified rolling and heat treatment schedules in the process of steel manufacture.

The appropriate records shall be verified by the manufacturer and submitted to the Register representative when performing his duties.

Where deviations from the programmed rolling schedules or heat treatment procedures exist, the products may be accepted for use on conditions set forth in 3.2.1.3.

The attention of the users shall be drawn to the fact that when fatigue loading is present, the effective fatigue strength of a welded joint of higher

strength steel may not be greater than that of a welded joint in normal strength steels.

Before subjecting steels produced by thermo-mechanical rolling to further heating for forming or stress relieving, or using high heat-input welding, special consideration shall be given to the possibility of a consequent reduction in mechanical properties.

### 3.2.2 Chemical composition.

Steel chemical composition shall be determined by the manufacturer from the results of analysis of samples taken from each ladle of each cast. Analysis performed by the manufacturer is subject to periodical check on demand of the Register.

Chemical composition of normal strength steel shall comply with the requirements of Table 3.2.2-1, and of higher strength steel — of Table 3.2.2-2.

For steel plates and wide flats over 50 mm thick, slight deviations in the chemical composition may be allowed as approved by the Register.

Results of chemical analysis applied by the manufacturer may be subject to periodic check on demand of the Register.

In the end of the text, the clause is complemented with a paragraph of a following meaning:

“Austenite grain size in the steel shall be equal or more than 5 points (ASTM E 112, GOST 5639)”

In Tables 3.2.2-1 and 3.2.2-2 the content of acid soluble aluminium is included. The total aluminium content shall be not less than 0.020 %.

The Register may also require for determination of content of elements not specified in Tables 3.2.2-1 and 3.2.2-2. At

the same time, chromium, nickel and copper content in normal strength steel shall not exceed 0.3 % for each element.

For normal strength carbon steel, total carbon content plus 1/2 of manganese content shall not exceed 0.4 %. For higher strength steel, carbon equivalent (in per cent) is determined during acceptance tests from the data of ladle analysis, and is calculated using the formula:

$$C_{eq} = C + \frac{Mn}{6} + \frac{Cr + Mo + V}{5} + \frac{Ni + Cu}{15}.$$

Arsenic content in steel of all grades shall not exceed 0.08 %.

Steel may contain aluminium, vanadium, columbium or other grain refining elements, separately or in combination.

If the above elements are introduced separately, their content shall comply with Tables 3.2.2-1 and 3.2.2-2.

If these elements are used in a combination, their minimum content in steel is not regulated.

If minimum content of aluminium or other grain refining elements is lower than required, the Register may require for determination of austenite grain size, which shall not be greater than grain size No. 5.

For higher strength steel which is subject to thermo-mechanical processing (TMCP), carbon equivalent shall comply with the requirements of Table 3.2.2-3.

Instead of the carbon equivalent the factor estimating the steel susceptibility to cold cracking may be determined according to the formula:

$$P_{CM} = C + \frac{Si}{30} + \frac{Mn}{20} + \frac{Cu}{20} + \frac{Ni}{60} + \frac{Cr}{20} + \frac{Mo}{15} + \frac{V}{10} + 5B.$$

Maximum values of carbon

equivalent or  $P_{CM}$  are subject to agreement with the Register and shall be included into technical documentation for

steel which is applied for approval.

Actual values of  $C_{eq}$  or  $P_{CM}$  may be also specified in certificates for supplied steel.

**Table 3.2.2-1 Chemical composition and mechanical properties of normal strength hull structural steel**

Grade		A			B			D			E		
Deoxidation		Killed or semi-killed			Killed or semi-killed			Killed			Killed, fine-grained, aluminium-treated		
Condition of supply		As per Table 3.2.4-1											
Chemical composition (ladle analysis), %	$C_{\max}$	0.21			0.21			0.21			0.18		
	$Mn_{\min}$	$2.5 \times C$			0.80			0.60			0.70		
	$Si_{\max}$	0.50			0.35			0.35			0.35		
	$P_{\max}$	0.035			0.035			0.035			0.035		
	$S_{\max}$	0.035			0.035			0.035			0.035		
	$Al_{\min}$	–			–			0.015			0.015		
Tensile properties	Tensile strength $R_m$ , MPa	400-520											
	Yield stress $R_e$ , MPa, min	235											
	Elongation $A_5$ , %, min	22											
Impact test	Test temperature, °C	+20			0			–20			–40		
	Plate thickness $t$ , mm	$\leq 50$	$> 50$ $\leq 70$	$> 70$ $\leq 100$	$\leq 50$	$> 50$ $\leq 70$	$> 70$ $\leq 100$	$\leq 50$	$> 50$ $\leq 70$	$> 70$ $\leq 100$	$\leq 50$	$> 50$ $\leq 70$	$> 70$ $\leq 100$
	Impact energy, J, min, for longitudinal specimens, $KV_L$	–	34	41	27	34	41	27	34	41	27	34	41
	Impact energy, J, min, for transverse specimens, $KV_T$	–	24	27	20	24	27	20	24	27	20	24	27

Notes: 1. For Grade A sections, up to 12.5 mm thick, rimmed steel may be used.

2. For Grade A sections, allowable carbon content is up to 0.23 %.

3. For Grade A sections of any thickness, upper limit if instantaneous strength may be increased, upon agreement with the Register.

4. For steel which can be supplied without impact testing, these tests may be performed on a selective basis, upon agreement with the Register. The results shall meet the respective requirements of the table, and for grade A steel up to 50 mm thick, they shall be as follows:  $KV_L > 27$  J at 20 °C.

5. Upon agreement with the Register, manganese content in Grade B steel which is subject to impact test may be reduced to 0.60 %.

6. For Grade D steel of more than 25 mm thick and for Grade E steel, total content of aluminium may be determined instead of acid soluble aluminium. In such cases, total content shall be equal to at least 0.020 %. Maximum aluminium content can be also specified by the Register. Other grain refining elements may be used on a special agreement with the Register.

7. When supplying steel of any grade which has been subject to thermo-mechanical processing, slight deviations from established chemical composition may be allowed or required by the Register.

8. For Grade D steel of up to 25 mm thick, aluminium content other than specified in the table is allowed.

9. The Register may restrict content of residual elements which may have an adverse influence on steel processing and operation (for example, copper and stannum).

10. If steel contains additional elements which are substantiated by the practice of steel manufacturing on this works, their content shall be specified and agreed with the Register.

11. Impact testing — refer to 3.2.3, 3.2.6.

12. When supplying Grade B steel of up to 25 mm thick, impact testing is not required.

13. When supplying normalised Grade A steel of more than 50 mm thick, impact test is not required, if grain refining elements have been applied.

14. During tensile testing of standard full-thickness specimens with gauge length of 200 mm, minimum elongation shall correspond to the following values:

Thickness, mm	$t \leq 5$	$5 < t \leq 10$	$10 < t \leq 15$	$15 < t \leq 20$	$20 < t \leq 25$	$25 < t \leq 30$	$30 < t \leq 40$	$40 < t \leq 50$
Elongation, %	14	16	17	18	19	20	21	22

**Table 3.2.2-2 Chemical composition and mechanical properties of higher strength hull structural steel**

Grade		A32	D32	E32	A36	D36	E36	A40	D40	E40
Deoxidation		Killed								
Condition of supply		As per Table 3.2.4-2								
Chemical composition (ladle analysis), %	$C_{\max}$	0.18								
	Mn	0.9-1.6								
	$Si_{\max}$	0.5								
	$P_{\max}$	0.035								
	$S_{\max}$	0.035								
	$Cu_{\max}$	0.35								
	$Cr_{\max}$	0.20								
	$Ni_{\max}$	0.40								
	$Mo_{\max}$	0.08								
	$Al_{\min}$	0.015								
Tensile properties	Nb	0.02-0.05								
	V	0.05-0.10								
	$Ti_{\max}$	0.02								
	Tensile strength $R_m$ , MPa	440-570			490-630			510-660		
	Yield stress $R_{eH}$ , MPa	315			355			390		
Elongation $A_5$ , min, %	22			21			20			

Notes:

1. For steel up to 12.5 mm thick, manganese content may be reduced to 0.7 %.

2. Total aluminium content may be determined instead of the content of acid soluble aluminium. In such cases, total content shall be equal to at least 0.020 %.

3. During tensile tests on standard full-thickness specimens 25 mm wide and with rated length of 200 mm, relative elongation shall correspond to following minimum values.

4. Steel may contain aluminium, vanadium or other grain refining elements, separately or combined. If said elements are introduced separately, their content shall comply with Table 3.2.2-2. If the elements are used in combination, their content is not regulated.

5. When supplying higher strength steel of any grade, which has been subject to thermo-mechanical processing, slight deviations from the specified chemical content may be allowed or required by the Register.

6.  $C_{eq}$ ,  $P_{cm}$  — refer to 3.2.2, 3.2.6.

7. If steel contains additional elements which are substantiated by the practice of steel manufacturing on this works, their content shall be specified and agreed with the Register.

8. Impact test — refer to 3.2.3, 3.2.6.

9. For steels of Grades A32 and A36, upon a special agreement with the Register, number of impact tests may be reduced, if results of selective tests have been positive.

Steel grade	Thickness $t$ , mm							
	$t \leq 5$	$5 < t \leq 10$	$10 < t \leq 15$	$15 < t \leq 20$	$20 < t \leq 25$	$25 < t \leq 30$	$30 < t \leq 40$	$40 < t \leq 50$
A32 D32 E32	14	16	17	18	19	20	21	22
A36 D36 E36	13	15	16	17	18	19	20	21
A40 D40 E40	12	14	15	16	17	18	19	20

Table 3.2.2-3

Steel grade	Carbon equivalent, %, max	
	$t \leq 50$ mm	$50 \text{ mm} < t \leq 100$ mm
A32, D32, E32, F32	0.36	0.38
A36, D36, E36, F36	0.38	0.40
A40, D40, E40, F40	0.40	0.42

End of Table 3.2.2-3

Note: Carbon equivalent value shall be agreed by manufacturing works and ship yard in each case.

### 3.2.3 Mechanical properties.

The mechanical properties of normal strength steel shall comply with the requirements given in Table 3.2.2-1 while the mechanical properties of higher strength steel shall comply with Table 3.2.2-2.

When marking grade of higher strength steel, letter H may be added to the grade marking, for example DH36.

On agreement with the Register, the impact energy at impact testing may be determined either on longitudinal ( $KV_L$ ) or

transverse ( $KV_T$ ) specimens.

Requirements to impact energy for higher strength steel are given in Table 3.2.3.

Tests shall be performed as per requirements of Section 2.

In impact test tables, values are provided for standard specimens ( $10 \times 10$  mm). When applying rolled steel less than 10 mm thick, regulations stated in 2.2.3.1 shall be observed.

Impact tests of supplied steel are usually performed on longitudinal

specimens only (results of tests on transverse specimens shall be guaranteed by the manufacturer), unless otherwise stated by the consumer or by the Register.

If tests results have been unsatisfactory, retesting is performed in accordance with 1.3.4.2.

Table 3.2.3

Steel grade	Temperature $e, ^\circ\text{C}$	Average impact energy value, J, min					
		$t \leq 50$ mm		$50 \text{ mm} < t \leq 70$ mm		$70 \text{ mm} < t \leq 100$ mm	
		$KV_L$	$KV_T$	$KV_L$	$KV_T$	$KV_L$	$KV_T$
A32	0	31	22	38	26	46	31
D32	-20	31	22	38	26	46	31
E32	-40	31	22	38	26	46	31
A36	0	34	24	41	27	50	34
D36	-20	34	24	41	27	50	34
E36	-40	34	24	41	27	50	34
A40	0	39	26	46	31	55	37
D40	-20	39	26	46	31	55	37
E40	-40	39	26	46	31	55	37

### 3.2.4 Supply condition.

Steel supply condition shall meet the requirements of Tables 3.2.4-1 and 3.2.4-2 and shall be specified in a certificate and/or manufacturer's document on products quality.

### 3.2.5 Sampling.

Unless otherwise recommended, test samples shall be taken as follows:

the samples of plates and flats wider than 600 mm shall be taken from one end so that the sample axis is located midway between the longitudinal axis and the edge of the plate or flat (refer to Fig. 3.2.5-1);

the samples of flats 600 mm wide and less and of sections are taken from one end so that the sample axis lies  $\frac{1}{3}$  from the flat edge or from the outer edge of the section flange or, in the case of small sections, as near as possible to this position (refer to Figs 3.2.5-2, 3.2.5-3 and 3.2.5-4);

in the case of channels and beams the test samples may be alternatively taken from the position  $\frac{1}{4}$  from the web centre

line (refer to Fig. 3.2.5-3);

the samples of bars and similar semi-finished products are taken from one end so that the sample axis is parallel to the direction of rolling;

from rolled bars 50 to 100 mm thick, samples are taken  $\frac{1}{4}$  of the thickness dimension from the surface.

Semi-finished products of small cross-sections may be subject to tensile tests without prior mechanical processing.

In other cases, samples shall be taken so that their axes are positioned as follows:

for non-cylinder-shaped semi-finished product — at a distance of  $\frac{1}{3}$  of diagonal half from a vertex (refer to Fig. 3.2.5-5);

for cylindrical semi-finished products,  $\frac{1}{3}$  of the radius from the outside (refer to Fig. 3.2.5-6).

Pieces selected for the preparation of tensile and impact test specimens shall be the thickest (greatest in diameter) in each

batch with their longitudinal axes except in the case of sections, bars and transverse to the final direction of rolling, flats of 600 mm or less in width.

**Table 3.2.4-1 Condition of supply of normal strength steel<sup>1</sup>**

Grade	Thickness, mm	Condition of supply
A	$t \leq 50$	Any
	$50 < t \leq 100$	Normalized (N), controlled rolled (CR) or thermo-mechanically rolled (TM) <sup>3</sup>
B	$t \leq 50$	Any
	$50 < t \leq 100$	Normalized (N), controlled rolled (CR) or thermo-mechanically rolled (TM) <sup>3</sup>
D	$t \leq 35$	Any
	$35 < t \leq 100$	Normalized (N), controlled rolled (CR) or thermo-mechanically rolled (TM) <sup>2</sup>
E	$t \leq 100$	Normalized (N) or thermo-mechanically rolled (TM) <sup>2</sup>

<sup>1</sup> Scope of impact tests is established in accordance with 3.2.6.4-1.

<sup>2</sup> On a special agreement with the Register, Grade D steel sections may be supplied as-rolled, if results of impact tests have been satisfactory. Upon the same conditions, Grade E steel sections may be supplied as-rolled or controlled rolled.

<sup>3</sup> On a special agreement with the Register, Grade A and B steel plates may be supplied as-rolled.

**Table 3.2.4-2 Condition of supply of higher strength steel**

Grades	Grain refining elements	Thickness, mm	Condition of supply
A32, A36	Nb and/or V	$t \leq 12.5$	Any
		$12.5 < t \leq 100$	Normalized (N), controlled rolled (CR) or thermo-mechanically rolled (TM)
A32, A36	Al or Al + Ti	$t \leq 20$	Any
		$20 < t \leq 35$	Any, as-rolled supply (AR) — requires for special agreement
		$35 < t \leq 100$	Normalized (N), controlled rolled (CR) or thermo-mechanically rolled (TM)
A40	Any	$t \leq 12.5$	Any
		$12.5 < t \leq 50$	Normalized (N), controlled rolled (CR) or thermo-mechanically rolled (TM)
D32, D36	Nb and/or V	$t \leq 12.5$	Any
		$12.5 < t \leq 100$	Normalized (N), controlled rolled (CR) or thermo-mechanically rolled (TM)
D32, D36	Al or Al + Ti	$t \leq 20$	Any
		$20 < t \leq 25$	Any, as-rolled supply (AR) — requires for special agreement

Grades	Grain refining elements	Thickness, mm	Condition of supply
		$25 < t \leq 100$	Normalized (N), controlled rolled (CR) or thermo-mechanically rolled (TM)
D40	Any	$t \leq 50$	Normalized (N), controlled rolled (CR) or thermo-mechanically rolled (TM)
E32, E36	Any	$t \leq 50$	Normalized (N), controlled rolled (CR) or thermo-mechanically rolled (TM)
		$50 < t \leq 100$	Normalized (N), thermo-mechanically rolled (TM)
E40	Any	$t \leq 50$	Normalized (N), thermo-mechanically rolled (TM) or quenched and tempered (QT)

Note: On agreement with the Register, Grade A32, A36 and D36 steel sections may be supplied as-rolled if impact test results have been satisfactory; upon the same conditions, Grade E32 and E36 steel sections may be supplied as-rolled or controlled rolled. Scope of impact tests is established in accordance with

3.2.6.4-2.

Specimens, on which impact energy  $KV$  shall be determined, shall be prepared with their longitudinal axes either parallel or transverse to the final direction of rolling of the material unless required in special cases that the samples are taken with their longitudinal axes transverse to the final direction of rolling.

The notch shall be cut perpendicular to the rolled surface and not closer than 25 mm to the flame cut or sheared edge.

The impact test specimens shall be taken within 2 mm below the rolled surface and where the thickness of the rolled material exceeds 40 mm — within  $\frac{1}{4}$  of the thickness (the axis of the specimens shall be in a plane located at  $\frac{1}{4}$  of the thickness and parallel to the surface).

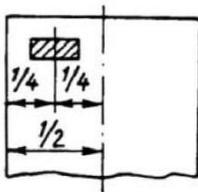


Fig. 3.2.5-1 Plate and flat

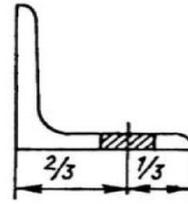


Fig. 3.2.5-2 Angle

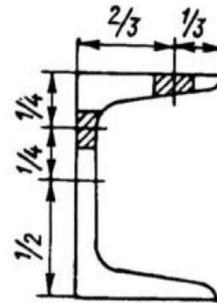


Fig. 3.2.5-3 Channel and beam

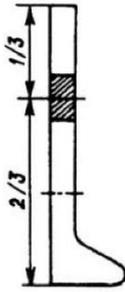


Fig. 3.2.5-4 Bulb bar

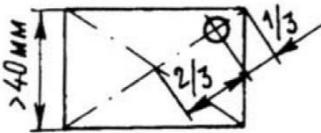


Fig. 3.2.5-5 Rectangular bar

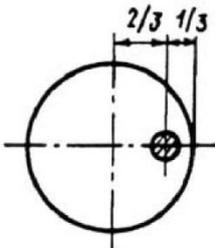


Fig. 3.2.5-6 Cylindrical bar

### 3.2.6 Number of tests.

**3.2.6.1** Rolled material is presented for tests in batches. A batch shall comprise rolled products of the same type, from the same cast and in the same condition of supply. Unless otherwise specified, one tensile test piece and one set of impact test pieces shall be tested from each batch presented with the mass not exceeding 50 t (except Grade E, E32, E36 and E40 steel).

Where the batch mass is in excess of 50 t, one extra tensile and impact test shall

be made for each 50 t or fraction thereof.

An additional test shall be made for every variation of more than 10 mm in the thickness of plates or for every variation of more than 10 mm in the thickness or diameter of sections and bars comprising the batch.

Samples for testing rolled material batches shall be taken from the thickest semi-finished product belonging to the batch concerned.

If steel, except for Grade A, is over 50 mm in thickness and is supplied in the controlled rolled condition, the frequency of impact tests shall be increased to one set from each batch of 25 t or fraction thereof.

Similarly Grade A steel over 50 mm in thickness may be supplied in the as rolled condition. In such case one set of three Charpy V-notch test specimens shall be taken from each batch of 50 t or fraction thereof.

The piece selected for the preparation of the test specimens shall be the thickest in each batch.

**3.2.6.2** When, subject to the special approval of the Register, material is supplied in the as-rolled condition, one set of impact test specimens shall be tested from each batch of 25 t or fraction thereof.

**3.2.6.3** The number of impact tests for Grade E, E32, E36 and E40 steel shall be as follows:

for plates and wide flats each piece shall be tested;

for sections and bars one set shall be tested from each batch of 25 t or fraction thereof.

When, subject to special agreement with the Register, sections other than Grades E40 and F40 are supplied in the as



A	Killed or semi-killed	Section	A(-)	Not applicable		
	< 50 killed or semi-killed > 50 killed	Plate	A(-)		N(-),TM(-) CR(50),AR*(50)	
Section		A(-)		Not applicable		
B	< 50 killed or semi-killed ≥ 50 killed	Plate	A(50)		N(50), TM(50) CR(25), AR*(25)	
		Section	A(-)	A(50)	Not applicable	
D	Killed	Plate, section	A(50)	Not applicable		
	Killed and fine-grained	Plate	A(50)	N(50) CR(50) TM(50)	N(50) TM(50) CR(25)	
		Section	A(50)	N(50) CR(50) TM(50) AR*(25)	Not applicable	
E	Killed and fine-grained	Plate	N (each piece, length as heat treated) TM (each piece, length as heat treated)			
		Section	N(25), TM(25), AR*(15),CR*(15)		Not applicable	

Symbols:

A — any; N — normalising; CR — controlled rolling; QT — quenching and tempering.

Note: AR\* as-rolled steel and CR\* controlled rolling specified in this table and in Table 3.2.6.4-2 may be applied only on agreement with the Register.

Table 3.2.6.4-2

Steel grade	Deoxidation	Grain refining elements	Type of rolled products	Supply condition (batch size for tests, KV)							
				Thickness, mm							
				10	12.5 100	20	25	30	35	40	50
1	2	3	4	5							
		Nb and/	Plate	A(50)	N(50), CR(50), TM(50)			N(50),CR(25),TM(50)			

A32, A36	or V	Section	A(50)	N(50), CR(50), TM(50), AR*(25)		Not applicable
		Al or Al + Ti	Plate	A(50)	AR*(25)	Not applicable
					N(50), CR(50), TM(50)	
Section	A(50)	N(50), CR(50) TM(50), AR*(25)		Not applicable		
A40	Any	Plate	A(50)	N(50) CR(50), TM(50)		N(50) TM(50) QT (each length as heat treated)
		Section	A(50)	N(50), CR(50), TM(50)		Not applicable
D32, D36	Nb or V	Plate	A(50)	N(50), CR(50), TM(50)		N(50),CR(25),TM(50)
		Section	A(50)	N(50), CR(50), TM(50), AR*(25)		Not applicable
	Al or Al + Ti	Plate	A(50)	AR*(25)	Not applicable	
				N(50), CR(50), TM(50)		N(50), CR25, TM(50)
Section	A(50)	N(50), CR(50), TM(50), AR*(25)		Not applicable		
D40	Any	Plate	N(50), CR(50), TM(50)			N(50), TM(50) QT (each length as heat treated)
		Section	N(50), CR(50), TM(50)			Not applicable
E32, E36	Any	Plate	N (each plate), TM (each plate)			
		Section	N(25), TM(25), AR*(15),CR*(15)		Not applicable	
E40	Any	Plate	N (each piece) TM (each piece) QT (each piece)			N (each piece) TM (each piece) QT (each length as heat treated)
		Section	N(25), TM(25), QT(25)			Not applicable
F32, F36	Any	Plate	N (each piece) TM (each piece) QT (each piece)			N (each piece) TM (each piece) QT (each length as heat treated)
		Section	N(25), TM(25), QT(25), CR*(15)			Not applicable
F40	Any	Plate	N (each piece) TM (each piece) QT (each piece)			N (each piece) TM (each piece) QT (each length as heat treated)
		Section	N(25), TM(25), QT(25)			Not applicable

Killed and fine-grained

The thickness tolerances for steel plates and wide flats below 5 mm shall be specially agreed with the Register.

These requirements do not apply to rolled steel products intended for the construction of boilers, heat exchangers,

pressure vessels, etc., as well as independent tanks for the transportation of liquefied gases or chemicals.

Note: Tolerances for length, width, flatness and over thickness may be taken from national or international standards.

Class C (ISO 7452) may be applied

in lieu of 3.2.8.3, in which case the requirements in 3.2.8.4 and 3.2.8.5 need not be applied.

If Class C (ISO 7452) is applied, the footnote of ISO 7452 Table 2, which reads: “Also a minus side of thickness of 0.3 mm is permitted,” is not applicable.

Additionally, if ISO 7254 is applied, it is required that the steel mill demonstrate to the satisfaction of the Classification Society that the number of measurements and measurement distribution is appropriate to establish that the mother plates produced are at or above the specified nominal thickness.

### 3.2.8.2 Responsibility.

The responsibility for verification and maintenance of the production within the required tolerances rests with the manufacturer. The surveyor to the Register may require to witness some measurements.

The responsibility for storage and maintenance of the delivered product(s) with acceptable level of surface conditions rests with the shipyard before the products are used in fabrication.

### 3.2.8.3 Thickness tolerances.

The tolerances on thickness of a given product are defined as:

**.1** minus tolerance is the lower limit of the acceptable range below the nominal thickness;

**.2** plus tolerance is the upper limit of the acceptable range above the nominal thickness.

**Note:** Nominal thickness is defined by the purchaser at the time of enquiry and order.

The minus tolerance on thickness of steel rolled products of normal and higher strength according to 3.2, of high strength according to 3.13, as well as steels supplied in accordance with the

requirements of 3.14 and Part XII “Materials” of the Rules for the Classification, Construction and Equipment of Mobile Offshore Drilling Units and Fixed Offshore Platforms shall be 0.3 mm irrespective of nominal thickness.

The minus tolerances on for products for machinery structures shall be in accordance with Table 3.2.8.3.

The tolerances on nominal thickness are not applicable to areas repaired by grinding

which shall be in accordance with a Register recognized standard. The requirements of 3.2.7 may be used for this purpose.

The plus tolerances on nominal thickness shall be in accordance with a recognized national or international standard.

Table 3.2.8.3

Thickness $t$ , mm	Tolerance, mm
$5 \leq t < 8$	-0.4
$8 \leq t < 15$	-0.5
$15 \leq t < 25$	-0.6
$25 \leq t < 40$	-0.8
$40 \leq t$	-1.0

### 3.2.8.4 Average thickness.

The average thickness of a product or products is defined as the arithmetic mean of the measurements made in accordance with 3.2.8.5.

The average thickness of steel rolled products of normal and higher strength according to 3.2, of high strength according to 3.13, as well as steels supplied in accordance with the requirements of 3.14 and Part XII “Materials” of the Rules for the Classification, Construction and

Equipment of Mobile Offshore Drilling Units and Fixed Offshore Platforms shall not be less than the nominal thickness.

**3.2.8.5 Thickness measurements.**

The thickness is to be measured at locations of a product or products as defined in Figs 3.2.8.5 and 3.2.8.5.1.

Automated method or manual method is applied to the thickness measurements.

The procedure and the records of measurements shall be made available to the surveyor to the Register and copies provided on request.

**3.2.8.5.1 Average thickness measuring locations.**

At least two lines among shown in Figs 3.2.8.5 and 3.2.8.5.1, shall be selected for the thickness measurements and at least three points on each selected line shall be selected for thickness measurement. If more than three points are taken on each line the number of points shall be equal on each line.

In case of automated measurement of rolled piece thickness on sides, measurement points shall be distanced by at least 10 mm and 300 mm at most from a longitudinal or transverse edge of the rolled piece.

In case of manual measurement of rolled piece thickness on sides, measurement points shall be distanced by at least 10 mm and 100 mm at most from a longitudinal or transverse edge of the rolled piece.

Note: The measurement locations apply to a product rolled directly from one slab or steel ingot even if the product shall be later cut by the manufacturer. Examples of the original measurements relative to later cut products are shown in Fig. 3.2.8.5.1. It shall be noted that the examples shown are not representative of all possible cutting scenarios.

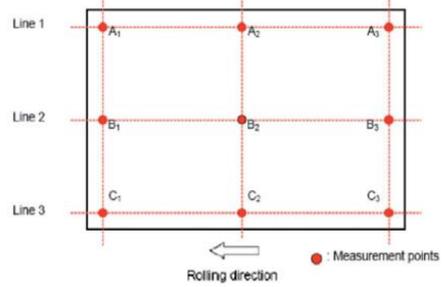


Fig. 3.2.8.5. Locations of thickness measuring points

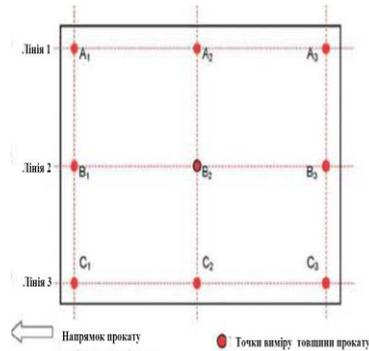
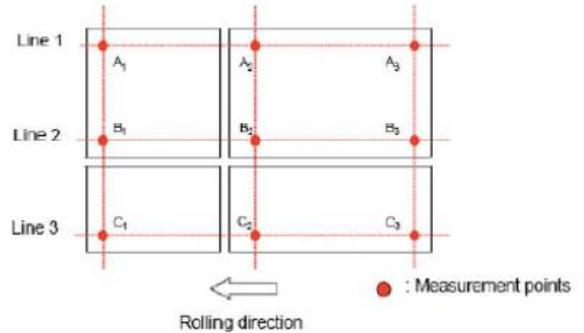


Fig. 3.2.8.5.1 Locations of thickness measuring points for the original steel plates

**3.2.9 Marking and documentation.**

Identification, marking and issued documentation — in accordance with the requirements of 1.4.

Every semi-finished product shall

have clearly visible stamp or brand of the Register marked by the specified method and in specified location.

Besides the mentioned above, the marking shall include the unified indication mark for grade of steel and strength level (e.g., A, D36, E450).

When required by the Register, material supplied in the thermo-mechanically controlled processed condition shall have index "TM" added after the identification mark, (e.g., E36TM).

Besides, the steel, supplied under the Register technical supervision may have index "PC" before the unified identification mark for grade of steel and strength level (e.g., PCE36TM).

In case of the Register approved supply of steel, which does not fully comply with the requirements of the Rules (refer to 3.2.1.1), index "S" may be added after the identification mark for grade of steel and strength level (e.g., PCE36STM or PCB36S).

Branding of rolled and section rolled steel products may be performed on a label. At that the manufacturer shall confirm the identification system of every rolled product in a bundle.

### **3.3 STEEL FOR BOILERS, HEAT EXCHANGERS AND PRESSURE VESSELS**

#### **3.3.1 General**

**3.3.1.1** The present requirements are applicable to rolled steel for marine boilers, heat exchangers and pressure vessels manufactured under the survey by the Register.

**3.3.1.2** The steel shall be manufactured at works recognized according to 1.3.1.4 in accordance with

standards or specifications agreed with the Register.

**3.3.1.3** Rolled steel which is manufactured and tested in accordance with these requirements is intended for operation at room or elevated temperatures.

#### **3.3.2 Chemical composition.**

**3.3.2.1** The chemical composition of steel shall be in accordance with standards proceeding from the required mechanical properties at room or elevated design temperatures and the content of base elements in per cent shall not exceed:

for carbon and carbon-manganese steels (ladle analysis), %:

carbon — 0.20, phosphor and sulphur — 0.04, silicon — 0.50, manganese — 1.60, chromium, nickel, copper — 0.30.

The use of steel with carbon content more than 0.20 % for welded structures shall be agreed with the Register on condition sufficient weldability is ensured;

for low-alloy steel (ladle analysis), %:

carbon — 0.18, phosphor — 0.04, silicon — 0.50, chromium — 2.50, manganese — 0.80, molybdenum — 1.10, sulphur — 0.04, vanadium — 0.35.

**3.3.2.2** The steel shall be killed.

Using of rimming steel is not permitted, and semi-killed steel is permitted on agreement with the Register.

On agreement with the Register, the steel may be treated with grain-refining elements.

Carbon and carbon-manganese steel intended to operate at temperatures over 400 °C shall not contain aluminium.

**3.3.2.3** On agreement with the Register, the use of steel, the base element

content of which exceeds the limits specified above, as well as steel of other compositions, may be accepted.

### **3.3.3 Mechanical properties.**

The mechanical properties of steel at room and elevated temperature shall be in accordance with standards.

The properties of steel shall be confirmed by the following tests:

tensile test (tensile strength, yield stress and elongation are determined);

bend test;

impact test (*KCU* or *KV*).

The tensile test at elevated temperature and the ageing test shall be carried out if required by the relevant parts of the Rules or by standards.

At the request of the Register the test results obtained at determining the average stress to produce rupture at elevated temperature shall be submitted.

### **3.3.4 Heat treatment.**

The steel shall be manufactured as normalized, normalized and tempered or quenched and tempered. The method of heat treatment shall be as stipulated by standards.

On agreement with the Register, the steel may be manufactured without heat treatment, provided the required properties are guaranteed, and controlled rolling may be accepted as a substitute for normalizing.

### **3.3.5 Sampling.**

Unless stated otherwise, sampling shall be carried out in accordance with 3.2.5.

Tensile test specimens and those for determining the impact toughness *KCU* shall be cut out transverse to, and those for determining the impact energy *KV* — parallel to the direction of the last rolling.

### **3.3.6 Number of tests.**

Each rolled steel plate shall be submitted for testing. In the case of rolled plates of carbon steel up to 12 mm thick, as well as rolled sections, it is permitted to take 10 % of the total number of the plates (rolled pieces) or sections for testing purposes, but not less than two and of the same thickness (diameter or shape), one and the same cast and identical heat treatment.

Unless stated otherwise, not less than one specimen for tensile and bend testing and not less than one set of specimens for impact testing shall be taken from the rolled piece intended for testing purposes.

The number of specimens for tensile testing and for the determining of long-term strength at elevated temperature shall be established on agreement with the Register.

From plates (rolled pieces) with a mass of more than 6 t or a length of more than 15 m the samples for test specimens shall be cut out on both ends.

### **3.3.7 Inspection.**

The rolled steel shall be free from defects prejudicial to the use of the material for the intended application.

Freedom from non-allowable defects shall be guaranteed by the manufacturer and may be confirmed by the results of non-destructive testing.

Surface defects involved by the manufacturing process are permitted in case their depth is not greater than the allowable under-thickness tolerances, considering from the nominal thickness.

Repair of surface defects by welding followed by post-weld heat treatment is permitted on agreement with the Register only.

### **3.3.8 Marking and documents.**

Identification, marking and issued documentation — in accordance with the requirements of 1.4.

Every semi-finished product shall have clearly visible stamp or brand of the Register marked by the specified method and in specified location.

Branding of rolled and section rolled steel products may be performed on a label. At that the manufacturer shall confirm the identification system of every rolled product in a bundle.

### 3.4 STEEL TUBES AND PIPES

#### 3.4.1 General.

**3.4.1.1** The present requirements apply to hot- and cold-formed steel pipes and tubes intended for boilers, heat exchangers, pressure vessels, ship systems and piping and subject to survey by of the Register during manufacture.

**3.4.1.2** The steel pipes and tubes shall be manufactured at works recognized according to 1.3.1.4 in accordance with standards or technical requirements agreed with the Register.

**3.4.1.3** The welded pipes and tubes may be manufactured by means of electric induction welding, pressure contact welding or fusion welding.

#### 3.4.2 Chemical composition.

**3.4.2.1** The chemical composition of the steel for pipes and tubes shall be chosen on the basis of standards proceeding from the required mechanical properties at room of elevated design temperature; the content of base elements in per cent shall not exceed the values stated below:

for carbon and carbon-manganese steels (ladle analysis), %:

sulphur and phosphor — 0.04, manganese — 1.50, chromium, nickel,

silicon — 0.50, copper — 0.30, carbon — 0.23;

for low-alloy steel (ladle analysis), %:

sulphur and phosphor — 0.035, manganese — 1.00, chromium — 2.50, silicon — 0.50, molybdenum — 1.20, carbon — 0.20, vanadium — 0.35.

**3.4.2.2** The steel shall be killed. Rimming steel is not permitted for manufacturing pipes and tubes and semi-killed steel is permitted on agreement with the Register.

On agreement with the Register, the steel may be treated with grain-refining elements.

Carbon and carbon-manganese steel intended for working temperatures above 400 °C shall not contain aluminium.

**3.4.2.3** The use of steel, in which the base elements content exceeds the above limits as well as steel containing other base alloying elements than those stated above, may be permitted on agreement with the Register.

**3.4.2.4** The chemical composition shall be determined from the heat analysis (ladle analysis); determination of chemical composition on a tubular billet is permitted.

#### 3.4.3 Mechanical and technological properties.

**3.4.3.1** At room and elevated design temperature the mechanical and technological properties of steel intended for pipes and tubes shall be in accordance with standards for pipes and tubes.

**3.4.3.2** In the process of manufacture the pipes and tubes shall undergo the following tests:

tensile test (tensile strength, yield stress and elongation being determined) according to 2.2.2;

tensile test at elevated temperature (proof stress being determined);

flattening test according to 2.2.5.2, or tensile test of rings according to 2.2.5.4;

expanding test according to 2.2.5.3.

Tensile test at elevated temperature, flattening test, tensile test of rings and expanding test shall be carried out when required by standards for pipes or by technical documentation approved by the Register on the basis of which the test results are estimated.

When required by the Register or provided for by the relevant parts of the Rules or by standards, the results of testing the steel intended for pipes and tubes for determining the average stress to produce rupture at elevated temperature shall be submitted.

#### **3.4.4 Heat treatment.**

The pipes and tubes shall be heat treated, when stipulated by the relevant parts of the Rules, by standards or technical design documentation approved by the Register.

The cold-formed and electrically welded pipes and tubes shall in any case be heat treated, normalized, normalized and tempered or quenched and tempered.

The method and conditions of heat treatment shall be chosen by the manufacturer, reported to the Register and stated in the certificate.

#### **3.4.5 Sampling.**

Unless stated otherwise, sampling for specimens shall be made from one end of not less than two pipes or tubes of the batch.

#### **3.4.6 Scope of testing.**

The pipes and tubes shall be tested by batches. A batch shall consist of pipes and tubes of the same size manufactured from steel of the same heat and heat treated

under similar conditions.

The number of pipes or tubes in a batch shall not exceed:

400 in the case of pipes or tubes with an outer diameter of 76 mm or less;

200 in the case of pipes or tubes with an outer diameter over 76 mm.

A rest of pipes or tubes, which is less than half the number stated, shall be included in a relevant batch and one which is half and over, — shall be considered a separate batch.

For testing purposes, out of each sample

1 specimen for the tensile test,

1 specimen for the flattening test or the tensile test of rings (when welded pipes and tubes are tested — 2 specimens, during the testing of one of the specimens the welded joint shall be in the tension zone),

1 specimen for the expanding test shall be cut.

All the pipes and tubes shall be tested by hydraulic pressure. The test pressure shall be in accordance with standards for pipes and tubes or with documentation agreed with the Register, but in any case it shall not be less than that stated in 21.2, Part VIII “Systems and Piping” and in 1.7, Part X “Boilers, Heat Exchangers and Pressure Vessels”.

On agreement with the Register, hydraulic tests may be omitted if all the pipes and tubes undergo ultrasonic or other equivalent testing.

All the welds in welded pipes and tubes shall undergo the ultrasonic testing.

#### **3.4.7 Inspection.**

All the pipes and tubes shall undergo visual testing.

The surface of the pipes and tubes shall be free from cracks, skins, fissures

and laps.

A certain number of minor nicks and dents, marks, thin layers of scale, traces of defects grinding and small skins are permitted if due to them the wall thickness would not exceed the allowable under-thickness tolerances.

#### **3.4.8 Marking and documentation.**

Identification, marking and issued documentation — in accordance with the requirements of 1.4.

Branding of pipes may be performed on a label. At that the manufacturer shall confirm the identification system of every rolled product in a bundle.

### **3.5 STEEL FOR STRUCTURES USED AT LOW TEMPERATURES**

#### **3.5.1 General.**

**3.5.1.1** The present requirements apply to steel plates, flats, sections and bars up to 100 mm thick, as well as to forgings and castings intended for ship's hull structures, equipment and machinery intended for use at design temperatures below  $-30\text{ }^{\circ}\text{C}$ .

Application of requirements for rolled products, forgings and castings intended for use at design temperatures below  $-50\text{ }^{\circ}\text{C}$  is subject to special consideration by the Register in each case.

The requirements for the manufacture, inspection, identification, marking and documentation for rolled products, forgings and castings are given in 3.2, 3.7 and 3.8 accordingly.

Rolled steel, forgings and castings shall be manufactured by works which are recognized by the Register in accordance with 1.3.1.4.

**3.5.1.2** The steel other than specified in this Section as to chemical composition, mechanical properties and

condition of supply may be allowed for use if specially agreed with the Register, with due regard to additional relevant requirements of part XII "Materials" of the Rules for the Classification, Construction and Equipment of MODU/FOP.

**3.5.1.3** Where provision is made for welding during the manufacture of forged or cast items, or where such items are intended for welding inside the ship's hull, the chemical composition of steel and the welding procedure shall ensure the welded joint resistance to cracking.

The mechanical properties and impact energy of weld metal at the specified temperature at impact test shall be not lower than those required for the base metal.

**3.5.1.4** The steel shall be tested in accordance with the requirements of Section 2.

The tests are carried at temperatures specified in standards which are approved by the Register and/or specifications agreed with the Register. Unless otherwise stated, impact test temperature shall be by at least  $5\text{ }^{\circ}\text{C}$  below the design temperature.

The percentage of fibrous component in specimens fractures resulting from impact testing is determined in accordance with relevant standards or procedures approved by the Register.

#### **3.5.2 Hull structural steel.**

##### **3.5.2.1. Manufacturing.**

The steel shall be melted in electric steel-making convertors or oxygen-lanced convertors. The use of other melting methods shall be agreed with the Register.

General.

The present requirements apply to Grade F steel plates, flats, sections and bars up to 100 mm thick.

The general requirements for steel are given in 3.2.1.

Unless otherwise specified, the rate of plastic deformation in rolling shall be 5:1 as a minimum.

### 3.5.2.2 Chemical composition.

Chemical composition of a particular steel grade is specified in standards and technical requirements and shall not exceed the ultimate values given in Table 3.5.2.2. Steel shall be fully killed and treated with grain-refining elements.

Table 3.5.2.2 Chemical composition of hull structural steel

Grade	Content of elements, %													
	C	Mn	Si	P	S	Al (acid-soluble), min	Nb	V	Ti	Cu	Cr	Ni	Mo	N
	Max		Max						Max					
F32	0.16	0.90-1.60	0.50	0.025	0.025	0.015	0.02-0.05	0.05-0.10	0.02	0.35	0.20	0.80	0.08	N <sup>1</sup>
F36	0.16	0.90-1.60	0.50	0.025	0.025	0.015	0.02-0.05	0.05-0.10	0.02	0.35	0.20	0.80	0.08	
F40	0.16	0.90-1.60	0.50	0.025	0.025	0.015	0.02-0.05	0.05-0.10	0.02	0.35	0.20	0.80	0.08	
							Total content							
							0.12 max							

<sup>1</sup> N = 0.009 (0.012 if Al is present)

Notes: 1. Instead of determination of the content of acid-dissolved aluminium, total content of aluminium may be determined. In this case, total content of aluminium shall be not less than 0.020 %.

2. Steel may be treated with aluminium, columbium, vanadium or other appropriate grain refining elements, separately or in any combination. In this case, if one element is introduced, its content shall comply with the table, and if treatment with combination of elements is used, content of at least one of them shall be in accordance with the table.

### 3.5.2.3 Mechanical properties.

Tensile and impact properties of the steel shall comply with the requirements of Table 3.5.2.3.

The mechanical properties of steel more than 50 mm thick shall be agreed with the Register. In every case, impact test results for such steel shall meet the

requirements of Table 3.5.2.3 for a respective steel grade.

3.5.2.4 Conditions of supply shall comply with the requirements of Table 3.2.6.4-2.

3.5.2.5 Unless otherwise stated, scope of testing shall comply with the requirements of 3.2.6.4.

Table 3.5.2.3 Mechanical properties of hull structural steel

Steel grade	Yield stress $R_{eH}$ , MPa, min	Tensile strength $R_m$ , MPa	Elongation $A_5$ , %, min	Impact test	
				Test temp	Average impact energy value KV, J, min

					t ≤ 50 mm		50 < t ≤ 70 mm		70 < t ≤ 100 mm	
					KV <sub>L</sub>	KV <sub>T</sub>	KV <sub>L</sub>	KV <sub>T</sub>	KV <sub>L</sub>	KV <sub>T</sub>
F32	315	440-590	22	-60	31	22	38	26	46	31
F36	355	490-620	21	-60	34	24	41	27	50	34
F40	390	510-650	19	-60	39	26	46	31	55	37

### 3.5.3 Steel forgings.

#### 3.5.3.1 Chemical composition.

The chemical composition of steel for forgings being part of hull structures is specified in the Register-recognized standards and/or approved specification and shall provide for the cold resistance characteristics as required, and shall comply with the requirements of 3.7.2. The sulphur and phosphorus content in carbon and carbon manganese steel shall not exceed 0.025 % and 0.030 % respectively, and in alloy steel, it shall not exceed 0.015 % for each member.

#### 3.5.3.2 Mechanical properties.

The mechanical properties of forged steel and impact test results shall meet the requirements of 3.7.3. In addition, steel forgings shall be subject to impact test at temperature determined as per 3.5.1.4. The required value of impact energy is established by standards or technical requirements, but shall be not be less than 27 J in any case.

The Register may require the percentage of fibrous component in the fracture of the specimen to be determined after impact testing which shall be not less than 50 %.

To approve steel for essential forgings used at -30 °C and below, the Register may require resistance to brittle fracture to be confirmed either by testing according to the NTD procedure (refer to 2.2.6) or by other test methods agreed

with the Register, e.g. crack resistance tests.

### 3.5.4 Steel castings.

#### 3.5.4.1 Chemical composition.

The chemical composition of steel for castings being part of hull structures is specified in the Register-recognized standards and/or approved specification and shall provide for the cold resistance characteristics as required, and shall comply with the requirements of 3.8.2. The sulphur and phosphorus content shall not exceed 0.025 % and 0.030 % respectively.

The sulphur and phosphorus content in alloy steel shall not exceed 0.015 % for each member.

#### 3.5.4.2 Mechanical properties.

The mechanical properties of cast steel and impact test results shall meet the requirements of 3.8.3.

In addition, cast forgings shall be subject to impact test at temperature determined as per 3.5.1.4. The required value of impact energy is established by standards or technical requirements, but shall be not be less than 27 J in any case.

The Register may require the percentage of fibrous component in the fracture of the specimen to be determined after impact testing which shall be not less than 50 %.

To approve steel for essential castings used at -30 °C and below, the Register may require resistance to brittle

fracture to be confirmed either by testing according to the NTD procedure (refer to 2.2.6) or by other test methods agreed with the Register, e.g. crack resistance tests.

### 3.6 STEEL FOR CHAIN CABLES AND ACCESSORIES

#### 3.6.1 General.

**3.6.1.1** The present requirements apply to steel rolled products, forgings and castings used for manufacture of chain cables and accessories.

Steel forgings shall generally meet the requirements of 3.7 and steel castings — the requirements of 3.8, unless otherwise stated.

**3.6.1.2** All materials used for the manufacture of chain cables and accessories shall be supplied by the manufacturers recognized in accordance with 1.3.1.4. Grade 1 rolled products may be used for the manufacture of chain cables with the Manufacturer's Certificates.

**3.6.1.3** The manufacturer shall submit the specification for material to the Register for approval.

Stated in the specification shall be the melting and deoxidation procedure, specified chemical composition and mechanical properties, and terms of rolled products' acceptance and delivery as well.

Melting and deoxidation procedure, chemical composition and condition of rolled products' delivery, which do not fully comply with the requirements of the Subsection, are subject to the special approval by the Register.

#### 3.6.2 Chemical composition.

**3.6.2.1** The chemical composition of steel is determined by ladle analysis.

The chemical composition of rolled

steel bars, based on ladle analysis for Grades 1 and 2 chain cables shall comply with Table 3.6.2.1.

**3.6.2.2** For chain cables of grades 3, R3, R3S and R4 the chemical composition of steel shall comply with the specification agreed with the manufacturer of a chain cable and approved by the Register.

In addition the steel for chain cables of grade R4 shall contain not less than 0.2 % of molybdenum.

Table 3.6.2.1

Chain cable grade	Content of elements					Al total <sup>1</sup> , min
	C, max	Si	Mn	P	S	
				Max		
1	0.20	0.15-0.35	Min 0.40	0.040	0.040	—
2 <sup>2</sup>	0.24	0.15-0.55	Max 1.60	0.035	0.035	0.020

<sup>1</sup> Aluminium may be replaced partly by other fine graining elements.

<sup>2</sup> If the Register agrees, additional alloying elements may be added.

**3.6.2.3** The rolled bars shall be made of killed steel, and the steel for chain cables of grades 2, 3, R3, R3S and R4 shall be deoxidized and fine grain treated.

**3.6.2.4** The chemical composition of forgings and castings shall be in accordance with the specification approved by the Register and be specified by the manufacturer for each heat.

#### 3.6.3 Mechanical properties.

The mechanical properties of steel for chain cables and accessories shall ensure the properties according to the requirements of Table 3.6.3.

#### 3.6.4 Condition of supply

**3.6.4.1** Rolled bars and round section forgings, unless otherwise stated, are supplied in as-

rolled condition.

The finished forgings and castings may be supplied after heat treatment appropriate to each chain cable grade as specified in Table 7.1.3.4. Forgings and

castings may be subjected to normalizing, normalizing and tempering, hardening and tempering. The type of heat treatment shall conform to the specification approved by the Register.

**Table 3.6.3 Mechanical properties of material of a ready-made chain**

Chain cable grade	Yield stress $R_{eH}^3$ , MPa, min	Tensile strength $R_m^3$ , MPa	Elongation $A_5$ , %	Reduction in area $Z^4$ , %	Impact test <sup>1,2</sup> KV		
			Min		Test temperature, °C	Base material	Welded joint
					Impact energy, J, min		
1	–	370-490	25	–	–	–	–
2	295	490-690	22	–	0	27	–
3	410	Min 690	17	40	0 (–20)	60 (35)	–
R3	410	Min 690	17	50	0 (–20)	60 (40)	50 (30)
R3S	490	Min 770	15	50	0 (–20)	65 (45)	53 (33)
R4	580	Min 860	12	50	–20	50	36

<sup>1</sup> Impact test of materials for grade 2 chain cables may be not waived, if the chain cable is supplied in a heat treated condition.

<sup>2</sup> On agreement with the Register, impact tests for chain cables of grades 3, R3, R3S and R4 may be carried out at the temperature –20 °C. In this case the impact energy minimum value required is shown in brackets.

<sup>3</sup> For chains cables of grades R3, R3S and R4  $R_{eH}/R_m \leq 0.92$ .

<sup>4</sup> For cast steel of grades R3 and R3S,  $Z \leq 40$  %, for grade R4,  $Z \leq 35$  %.

When the material susceptibility to hydrogen embrittlement resistance for chain cables of grades R3, R3S and R4 is determined,  $Z/Z' \geq 85$ , where  $Z$  and  $Z'/Z'$  are the sample reduction in area under tension before and after heating, respectively.

**3.6.4.2** When the rolled products manufacturer is recognized, the chain cables of grades 3, R3, R3S and R4 shall be subjected to control testing of material after heat treatment similar to the one of the chain cable manufacturer. For chain cables of grades 1 and 2 it may be demanded by the Register.

**3.6.5 Mechanical tests.**

**3.6.5.1** The rolled bars are submitted for testing in batches. A batch not more than 50 t in mass shall comprise bars of the same cast and supply condition with a tolerance of diameter within 4 mm.

**3.6.5.2** From each batch of rolled bars, a sample is taken, out of which a tensile test specimen and a set of test specimens for impact testing (KV) for chain cables of grades 2, 3, R3, R3S and R4 are machined.

Specimens shall be taken from the sample in the longitudinal direction according to Fig. 3.6.5.2.

The tests shall be carried out in accordance with the requirements of 2.2. Prior to the tests, the samples shall be heat-treated following the procedures corresponding to the heat treatment of finished chain cables in accordance with 7.1.3.4.

The method and regime of the heat treatment shall be indicated by the chain cable manufacturer.

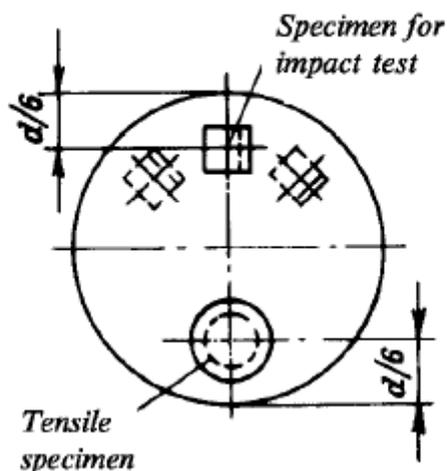


Fig. 3.6.5.2

**3.6.5.3** For chain cables of grades R3S and R4, tests of steel susceptibility to hydrogen embrittlement (reduction of ductility margin) shall be performed. For this purpose, two samples are taken from each cast:

- in the case of continuous casting — from metal corresponding to the beginning and the end of the cast section;
- in the case of ingot making — from metal corresponding to any two ingots.

Tensile test specimens shall be cut from each sample representing the central part of rolled product (the rolled steel products shall be heat treated in the same conditions and shall preferably belong to the same furnace charge). Two tensile test specimens taken from a heat of steel shall be 20 mm in diameter (on agreement with the Register it is permitted to use specimens 14 mm in diameter).

One of the two specimens shall be tested not less than 3 hours after production (for a specimen with a diameter of 14 mm, the time is 1.5 hours).

The other specimen shall be tested after being conditioned for 4 hours at 250 °C (for a specimen with a diameter of 14 mm, the time is 2 hours).

Throughout the test up to the fracture of the specimen, the strain rate (change of elongation in fractions of gage length of the specimen) shall be less than 0.0003 s<sup>-1</sup> (which amounts to approximately 10 minutes for a specimen of 20 mm in diameter).

Testing is carried out to determine the tensile strength, elongation and reduction in area. Test results shall comply with Table 3.6.3 (refer to Note 4 at the bottom of the Table).

When the obtained value  $Z/Z' < 0.85$ , the metal presented for testing may be degassed on agreement with the Register, after which all the above testing shall be performed.

**3.6.5.4** Mechanical tests results shall meet the requirements of Table 3.6.3.

Where the rest results are unsatisfactory, retests in accordance with 1.3.2.4 shall be carried out. In this case, the reheat treatment is allowed and the new tests may be performed on the metal taken from the material initially submitted for testing.

If the retest results are positive, those previously obtained may be disregarded.

**3.6.5.5** Recognizing the manufacturer of steel for chain cables of grades R3, R3S and R4 the steel resistance to strain ageing; temper brittleness and hydrogen embrittlement shall be confirmed by following procedures approved by the Register.

**3.6.6 Inspection.**

**3.6.6.1** The tolerances for rolled bars shall be within the limits specified in

Table 3.6.6.1.

*Table 3.6.6.1*

Nominal diameter, mm	Diameter tolerance, mm	Roundness tolerance, ( $d_{max} - d_{min}$ ), mm
< 25	-0 +1.0	0.6
25-35	-0 +1.2	0.8
36-50	-0 +1.6	1.1
51-80	-0 +2.0	1.5
81-100	-0 +2.6	1.95
101-120	-0 +3.0	2.25
121-160	-0 +4.0	3.00

**3.6.6.2** Rolled bars shall be free from shrinkage holes, cracks, flakes (hairlines), folds, laps and scale and also other internal and surface defects that might impair proper workability and use.

The lengthwise discontinuities, not more than 1 % of rolled bars diameter in depth, may be repaired by grinding with smooth transition to the surface.

**3.6.7 Non-destructive testing.**

100 % of rolled bars for chain cables of grades R3, R3S and R4 shall be subjected to ultrasonic testing and also to magnetic particle or eddy-current testing according to standards approved by the Register.

On agreement with the Register, the scope of non-destructive testing may be reduced if the quality stability of rolled bars manufacturing is confirmed.

**3.6.8 Marking and documentation.**

Generally, the marking shall be made in accordance with the requirements of 1.4.

The marking content shall allow the identification of the supplied product and may be prescribed by the manufacturer. In this case, as a minimum, the marking shall indicate the grade and heat the rolled products belong to.

Round bars up to and including 40 mm in diameter may be supplied in bundles with the marking allowed to be made on labels (refer to 1.4).

Each batch of steel for Grade 2 and 3 chain cables shall be accompanied by the Register certificate. In individual cases pre-agreed with the Register, the supply of products with manufacturer's certificates witnessed by the Register representative may be allowed.

The manufacturer's certificate shall contain the following data:

- Certificate number;
- order number;
- hull number of ship or floating facility;
- rolled products quantity and dimensions, batch weight;
- specification for steel, and chain cable grade;
- heat number;
- manufacturing methods;
- chemical composition;
- procedure for sample heat treatment.

If needed, the test reports may be attached to the certificate.

### **3.7 STEEL FORGINGS**

#### **3.7.1 General.**

**3.7.1.1** The present requirements are applicable to steel forgings intended for hull and machinery applications such as rudder stocks, pointless, propeller shafts, crankshafts, camshafts, connecting rods, piston rods, and other parts of machinery and gearing set forth in other parts of the Rules and having respective references to the present Subsection.

Where relevant, these requirements are also applicable to material for forging stock and to rolled bars intended to be

machined into components of simple shape.

**3.7.1.2** The requirements of the present Subsection are applicable only to steel forgings (or rolled steel when used instead of steel forgings as specified in 3.7.1.1) where the designation is determined depending on their properties at room temperature.

Additional requirements for the forgings intended for service at low or high temperatures shall be specially determined in each case.

**3.7.1.3** Alternatively to the manufacturing of steel forgings (or rolled steel when used instead of steel forgings as specified in 3.7.1.1), forgings, which comply with national or proprietary specifications, may be accepted by the Register. In this case, according to the procedure specified in 1.3.1.2, the equivalence of these alternative requirements or their justification for the given manufacture and/or application shall be proved to the Register.

**3.7.1.4** Steel forgings (or rolled steel when used instead of steel forgings as specified in 3.7.1.1) shall be made by the manufacturer recognized by the Register in accordance with 1.3.2. The steel used in the manufacture of the forgings shall be made by the process approved by the Register. Adequate top and bottom discards (of a rolled blank) shall be made to ensure freedom from piping and harmful segregations in the finished forgings.

**3.7.1.5** The plastic deformation (reduction ratio) shall be such as to ensure soundness, uniformity of structure and satisfactory mechanical properties after heat treatment.

The reduction ratio shall be calculated with reference to the average cross-sectional area of the cast material.

Where the cast material is initially upset, the plastic deformation reached during this operation may be considered.

Unless otherwise stipulated or agreed the total reduction ratio shall be at least:

for forgings made from ingot or from forged bloom or billet, using continuous casting plant — 3:1 if  $L > D$  and 1.5:1 if  $L \leq D$ ;

for forgings made from rolled products, 4:1 if  $L > D$  and 2:1 if  $L \leq D$ ;

for forgings made by upsetting, the length after upsetting shall be not more than one-third of the length before upsetting or, in the case of an initial forging reduction of at least 1.5:1, not more than one-half of the length before upsetting;

for rolled bars — 6:1,

where  $L$  and  $D$  are the length and diameter respectively of the part of the forging or its part.

**3.7.1.6** For crankshafts, where grain flow is required in the most favourable direction having regard to the mode of stressing in service, the proposed method of manufacture is subject to agreement by the Register. In such cases, the Register may require to perform structure and grain flow tests.

**3.7.1.7** The shaping of forgings or rolled slabs and billets by flame cutting, scarfing or arc-air gouging shall be carried out before the final heat treatment. Preheating shall be employed when necessitated by the composition and/or thickness of the steel.

For certain components, subsequent machining of all flame-cut surfaces may be required.

**3.7.1.8** When two or more forgings are joined by welding to form a composite component, the chemical composition and welding procedure shall be agreed by the Register; procedure qualification testing of welding joints may be required by the Register.

### **3.7.2 Chemical composition.**

**3.7.2.1** The chemical composition of steel for forgings shall be appropriate for the type of steel and the required mechanical and special properties of the forgings being manufactured.

The forgings shall be made from killed steel.

**3.7.2.2** The chemical composition of each heat shall be determined by the manufacturer on a sample taken preferably during the pouring of the heat.

When multiple heats are tapped into a common ladle, the ladle analysis shall apply.

**3.7.2.3** The chemical composition shall comply with the requirements of Table 3.7.2.3-1 (for hull steel forgings) and Table 3.7.2.3-2 (for machinery steel forgings) or with the requirements of the specification agreed by the Register.

**3.7.2.4** If not otherwise stated, grain refining elements such as aluminium, niobium or vanadium may be added at the discretion of the manufacturer. The content of such elements shall be reported in the results of the chemical analysis.

**3.7.2.5** Elements designated, on the agreement with the Register, as residual elements shall not be contained in steel in great quantity. The content of such elements shall be reported in the results of the chemical analysis.

### **3.7.3 Mechanical properties.**

**3.7.3.1** Tables 3.7.3.1-1 and 3.7.3.1-2 give the minimum requirements of the

Register for yield stress, elongation, reduction in area and impact test energy values corresponding to the different strength levels.

Where it is proposed to use a steel with a specified minimum tensile strength intermediate to those given, corresponding minimum values required

by the Register for the other properties specified in the above tables may be obtained by interpolation.

Forgings may be used where their properties are those established in the relevant standards recognized by the Register.

Table 3.7.2.3-1<sup>1</sup>

Type of steel	C	Si	Mn	P	S	Cr	Mo	Ni	Cu <sup>4</sup>	Total residuals
Carbon, carbon-manganese	0.23 <sup>2,3</sup>	0.45	0.3-15	0.035	0.035	0.30 <sup>4</sup>	0.15 <sup>4</sup>	0.40 <sup>4</sup>	0.30	0.85
Alloy <sup>5</sup>	–	0.45	–	0.035	0.035	–	–	–	0.30	–

<sup>1</sup> Composition in percentage mass by mass maximum unless shown as a range.

<sup>2</sup> The carbon content may be increased above this level, provided that the carbon equivalent ( $C_{eq}$ ) is not more than 0.41 %, calculated using the following formula:

$$C_{eq} (\%) = C + Mn/6 + (Cr + Mo + V) / 5 + (Ni + V) / 15.$$

<sup>3</sup> The carbon content of carbon and carbon-manganese steel forgings not intended for welded structures may be 0.65 % maximum.

<sup>4</sup> Element is considered as residual element.

<sup>5</sup> The content of C, Mn, Cr, Mo, Ni and the total content of residual elements shall be indicated in the specification to be submitted for agreement.

Note: Shaft and rudder stocks forgings shall be of weldable steel.

Table 3.7.2.3-2<sup>1</sup>

Type of steel	C	Si	Mn	P	S	Cr	Mo	Ni	Cu <sup>4</sup>	Total residuals
Carbon, carbon-manganese	0.65 <sup>2</sup>	0.45	0.3-1.5	0.035	0.035	0.30 <sup>3</sup>	0.15 <sup>3</sup>	0.40 <sup>3</sup>	0.30	0.85
Alloy <sup>4</sup>	0.45	0.45	0.3-1.0	0.035	0.035	Min 0.40 <sup>5</sup>	Min 0.15 <sup>5</sup>	Min 0.40 <sup>5</sup>	0.30	–

<sup>1</sup> Composition in percentage mass by mass maximum unless shown as a range or minimum value indicated.

<sup>2</sup> The carbon content of forgings intended for welded structures shall be 0.23 maximum.

The carbon content may be increased above the level given, provided that the carbon equivalent ( $C_{eq}$ ) is not more than 0.41 %, calculated using the formula  $C_{eq} (\%) = C + Mn/6 + (Cr + Mo + V) / 5 + (Ni + V) / 15$ .

<sup>3</sup> Element is considered as residual element.

<sup>4</sup> Where alloy steel is intended for welded structures, the proposed chemical composition shall be indicated in the specification to be submitted for agreement.

<sup>5</sup> The content of one or more of the specified elements shall comply with the minimum content.

### Table 3.7.3.1-1 Mechanical properties of steel forgings intended for ship construction

Type of steel	Tensile strength $R_m$ , min, MPa	Yield stress $R_e$ , min, MPa	Elongation $A_5$ , min, %		Reduction in area $Z$ , min, %	
			Lengthwise	Crosswise	Lengthwise	Crosswise
Carbon, carbon-manganese	400	200	26	19	50	35
	440	220	24	18	50	35
	480	240	22	16	45	30
	520	260	21	15	45	30
	560	280	20	14	40	27
	600	300	18	13	40	27
Alloy	550	350	20	14	50	35
	600	400	18	13	50	35
	650	450	17	12	50	35

Note: The tensile strength values obtained at tensile testing shall not exceed the specified values by more than:

120 MPa if  $R_m < 600$  MPa;

150 MPa if  $R_m \geq 600$  MPa.

**Table 3.7.3.1-2 Mechanical properties of steel forgings intended for ship machinery<sup>1</sup>**

Type of steel	Tensile <sup>2</sup> strength $R_m$ , min, MPa	Yield stress $R_e$ , min, MPa	Elongation $A_5$ , min, %		Reduction in area $Z$ , min, %		HB hardness <sup>3</sup>
			Lengthwise	Crosswise	Lengthwise	Crosswise	
Carbon, carbon-manganese	400	200	26	19	50	35	110-150
	440	220	24	18	50	35	125-160
	480	240	22	16	45	30	135-175
	520	260	21	15	45	30	150-185
	560	280	20	14	40	27	160-200
	600	300	18	13	40	27	175-215
	640	320	17	12	40	27	185-230
	680	340	16	12	35	24	200-240
	720	360	15	11	35	24	210-250
	760	380	14	10	35	24	225-265
Alloy steel	600	360	18	14	50	35	175-215
	700	420	16	12	45	30	205-245
	800	480	14	10	40	27	235-275
	900	630	13	9	40	27	260-320
	1000	700	12	8	35	24	290-365
	1100	770	11	7	35	24	320-385

Table 3.7.3.1-2 ended

<sup>1</sup> For propeller shaft forgings, except of ships with ice categories **Ice1** and **Ice2**, impact tests for all steel grades shall be carried out at  $-10\text{ }^{\circ}\text{C}$  and the minimum required average impact energy value ( $KV$ ) of 27 J (lengthwise specimen). No more than for one of three specimens the result may be by 30 % below than required.

<sup>2</sup> The following restrictions may be additionally specified:

the tensile strength values obtained at tensile testing shall not exceed the specified values by more than:

150 MPa if  $R_m < 900$  MPa;

200 MPa if  $R_m \geq 900$  MPa.

<sup>3</sup> The hardness values are given for information purposes only.

**3.7.3.2** Hardness tests may be required by the Register on the following:

**.1** for gear forgings after completion of heat treatment and prior to machining the gear teeth.

The hardness shall be determined at four positions equally spaced around the circumference of the surface where teeth will subsequently be cut.

Where the finished diameter of the toothed portion exceeds 2.5 m, the above number of test positions shall be increased to eight.

Where the width of a gear rim forging exceeds 1.25 m, the hardness shall be determined at eight positions at each end of the forging;

**.2** for small crankshaft and gear forgings, which have been batch-tested.

In such cases at least one hardness test shall be carried out on each forging.

The results of hardness tests shall be reported to the representative of the Register.

Corresponding Brinell hardness values are given in Table 3.7.3.1-2 for information purposes.

Hardness tests may also be required on forgings, which have been induction hardened, nitrided or carburized.

For gear forgings these tests shall be carried out on the teeth after, where applicable, they have been ground to the finished profile.

The results of such tests shall comply

with the documentation agreed and recognized by the Register (refer to 3.7.4.6).

**3.7.3.3** Where the test results are unsatisfactory retesting shall be conducted, in accordance with 1.3.2.4.

**3.7.4 Heat treatment (including surface hardening and straightening).**

**3.7.4.1** All the forgings shall be suitably heat treated to obtain the required mechanical properties and metal structure, and to refine the grain structure. The procedure of heat treatment shall be chosen by the manufacturer depending on the chemical composition of steel, the purpose and dimensions of the forging.

**3.7.4.2** Except as provided in 3.7.5.7 and 3.7.5.8 all forgings shall be supplied in one of the following conditions:

**.1** carbon and carbon-manganese steels:

completely annealed;

normalized;

normalized and tempered;

quenched and tempered;

**.2** alloyed steel:

quenched and tempered.

The tempering temperature shall not be less than  $550\text{ }^{\circ}\text{C}$ ;

Where forgings for gearing are not intended for surface hardening, lower tempering temperature may be allowed.

**3.7.4.3** Alloy steel forgings may be supplied in the normalized and tempered condition.

In each case the specifications for forgings shall be agreed by the Register and confirmed by the results of control tests when necessary.

**3.7.4.4** Heat treatment shall be carried out in properly equipped furnaces, which have adequate means for temperature recording. The furnace shall provide the required quality of operation and proper level of control over the process regardless of forging dimensions.

For large forgings in case of lack of the required equipment, methods of heat treatment will be specially considered by the Register on a separate request.

**3.7.4.5** If for any reason a forging is subsequently heated for further hot working, the heat treatment shall be repeated.

**3.7.4.6** Where it is intended to surface-harden forgings, the proposed procedure and specification shall be agreed by the Register. For this purpose the Register may require to carry out check tests to verify the uniformity and depth of surface layer (the verification of the required hardness and depth in the absence of soundness and change in the properties of the steel).

**3.7.4.7** Where induction hardening or nitriding shall be carried out, forgings shall be heat treated at an appropriate stage and condition suitable for this subsequent surface hardening.

**3.7.4.8** Where carburizing shall be carried out; forgings shall be heat treated at an appropriate stage (generally either by full annealing or by normalizing and tempering) and condition providing the required level of mechanical properties and hardening.

**3.7.4.9** If a forging is locally reheated

or any straightening operation is performed after the final heat treatment, it shall be heat treated to relieve the subsequent stress.

**3.7.4.10** The forge shall maintain records of heat treatment identifying conditions, the furnace used, furnace charge, time of charging, temperatures and time of conditioning. The records shall be presented to the Register on request.

### **3.7.5 Sampling.**

**3.7.5.1** The sample, sufficient for the required tests and for possible retest purposes, shall be provided with a cross-sectional area of not less than that part of the forging, which it represents.

This sample shall be integral with each forging except as provided in 3.7.6.1.10 and 3.7.6.1.13. Where batch testing is permitted according to 3.7.6.1.13, the sample may alternatively be a production part or separately forged.

Separately forged sample shall have dimensions not less than those of the forgings represented.

**3.7.5.2** Generally, a tensile test specimen and, when required, a set of impact tests specimens shall be cut from a sample.

**3.7.5.3** Test specimens shall normally be cut with their axes either mainly parallel (lengthwise specimen) or mainly tangential (crosswise specimen) to the principal axial direction of each product.

Unless otherwise agreed, lengthwise test specimens shall be cut the following way:

**.1** for thickness or diameter up to maximum 50 mm, the axis shall be at the mid-thickness or the centre of the cross section;

.2 for thickness or diameter greater than 50 mm, the axis shall be at one-quarter thickness ( $\frac{1}{4}$  of the diameter) or 80 mm, whichever is less, below any heat-treated surface.

### 3.7.6 Scope of testing.

3.7.6.1 Forgings shall be submitted for testing, individually or in batches.

Except as provided in 3.7.6.13, the number and direction of tests shall correspond to the listed below:

.1 *hull forgings (such as rudder stocks, pintles, etc.) and general machinery components (such as shafting, connecting rods, etc.):*

one sample shall be taken from the end of each forging in a lengthwise direction except that, at the discretion of the manufacturer the alternative directions or positions as shown in Fig. 3.7.6.1.1-1, 3.7.6.1.1-2 and 3.7.6.1.1-3 may be used.

where a forging exceeds both 4 t in mass and 3,000 mm in length, one sample shall be taken from each end. These limits refer to the "as forged" mass and length but excluding the sample material;

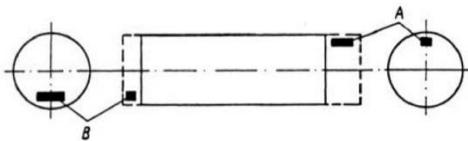


Fig. 3.7.6.1.1-1

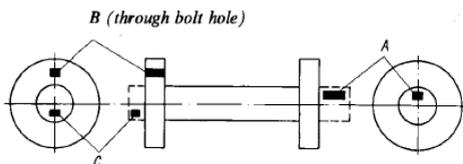


Fig. 3.7.6.1.1-2

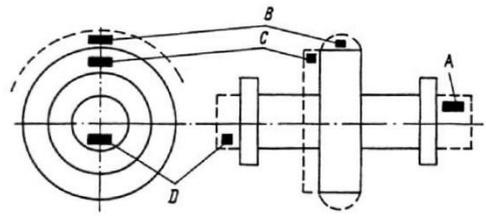


Fig. 3.7.6.1.1-3

### .2 pinion forgings:

where the diameter  $D$  of the toothed portion after machining exceeds 200 mm one sample shall be taken from each forging in a tangential direction adjacent to the toothed portion according to Fig. 3.7.6.1.2 (position B). Where the dimensions preclude sampling from position B, sample in a tangential direction shall be taken according to Fig. 3.7.6.1.2 (position C);

if however, the journal diameter is 200 mm or less, the sample shall be taken in a lengthwise direction according to Fig. 3.7.6.1.2 (position A);

where the finished length of the toothed portion exceeds 1,250 mm, one sample shall be taken from each end;

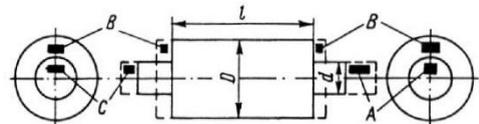


Fig. 3.7.6.1.2

### .3 small pinion forgings:

where the diameter of the toothed portion is 200 mm or less, one sample shall be taken in a lengthwise direction according to Fig. 3.7.6.1.2 (position A);

### .4 gear wheel forgings:

one sample shall be taken from each forging in a tangential direction according to Fig. 3.7.6.1.4 (position A or B);

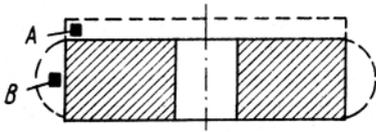


Fig. 3.7.6.1.4

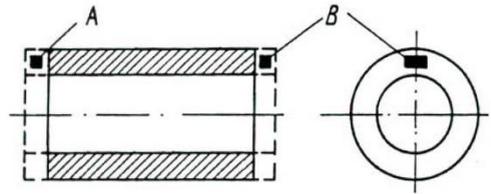


Fig. 3.7.6.1.6

**.5 gear wheel rim forgings made by expanding:**

one sample shall be taken from each forging in a tangential direction according to Fig. 3.7.6.1.5 (position A or B);

where the finished diameter exceeds 2,500 mm or the mass (as heat treated excluding test material) exceeds 3 t, two samples shall be taken from diametrically opposite positions according to Fig. 3.7.6.1.5 (positions A and B);

The mechanical properties may as well be determined on lengthwise test specimens;

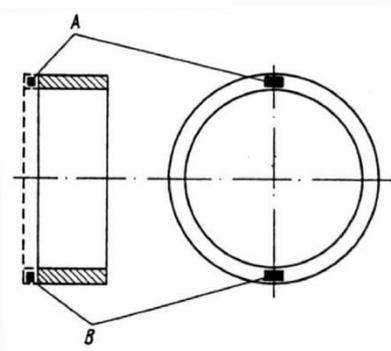


Fig. 3.7.6.1.5

**.7 crankweb forgings:**

one sample shall be taken from each forging in a tangential direction;

**.8 solid-forged crankshafts:**

one sample shall be taken in a lengthwise direction from the driving shaft end (from coupling) of each forging according to Fig. 3.7.6.1.8 (position A);

where the mass (as heat treated but excluding test material) exceeds 3 t, one sample in a lengthwise direction shall be taken from each end according to Fig. 3.7.6.1.8 (positions A and B);

where, however, the crankthrows are formed by machining or flame cutting, the second sample shall be taken in a tangential direction from material removed from the crankthrow at the end opposite the driving shaft end (from coupling) according to Fig. 3.7.6.1.8 (position C);

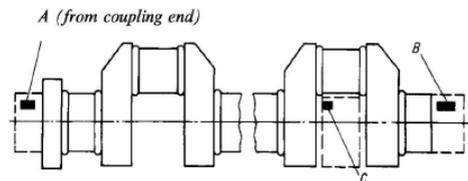


Fig. 3.7.6.1.8

**.6 pinion sleeve forgings:**

one sample shall be taken from each forging in a tangential direction according to Fig. 3.7.6.1.6 (position A or B);

where the finished length exceeds 1,250 mm, one sample shall be taken from each end (position A or B);

**.9 forgings with grain flow in the most favourable direction where the method of manufacture is subject to special approval by the Register in accordance with 3.7.1.6:**

the number and position of samples shall be agreed in the course of approval of respective procedure and recognition of the manufacturer by the Register;

**.10** *when a forging is subsequently divided into a number of components, all of which are heat treated together in the same furnace charge:*

for test purposes this may be regarded as one forging and the number of tests required shall be related to the total length and mass of the original forging;

**.11** *test samples:*

except for components, which shall be carburized, or for hollow forgings samples shall not be cut from a forging until all heat treatment has been completed;

**.12** *when forgings shall be carburized:*

the sample size shall provide for both preliminary tests (after the forge) and for final tests (after completion of carburizing).

For this purpose duplicate sample shall be taken from positions as detailed in 3.7.6.1, except that irrespective of the dimensions or mass of the forging, tests are required from one position only and, in the case of forgings with integral journals, shall be cut in the lengthwise direction.

Samples shall be machined to a diameter of  $D/4$  or 60 mm, whichever is less, where  $D$  is the finished diameter of the toothed portion.

For preliminary tests (after the forge) the samples shall be given a blank carburizing and heat treatment cycle simulating that which subsequently will be applied to the forging. For final acceptance tests, the rest of samples shall be blank-carburized and heat-treated

along with the forgings, which they represent.

At the discretion of the forge or gear manufacturer, test samples of larger cross section may either be carburized or blank-carburized, but these shall be machined to the required diameter prior to the final quenching and tempering heat treatment.

Alternative procedures for testing the forgings to be carburized are subject to special consideration by the Register.

**.13** *submission of forgings for testing:*

normalized forgings with a mass up to 1,000 kg each and quenched and tempered forgings with mass up to 500 kg each may be batch tested.

A batch shall consist of forgings of similar shape and dimensions, made from the same heat of steel, heat treated in the same furnace charge and with a total mass not exceeding 6 t for normalized forgings and 3 t for quenched and tempered forgings, respectively;

**.14** *submission of hot rolled bars for testing:*

a batch testing procedure may also be used for hot rolled bars. Batch quantity is determined proceeding from the following:

**.14.1** material from the same rolled ingot or bloom provided that these are all heat treated in the same furnace charge;

**.14.2** bars of the same diameter and heat, heat-treated in the same furnace charge and with a total mass not exceeding 2.5 t;

**.15** the preparation of test specimens and testing procedures shall comply with the relevant requirements of Section 2.

Unless otherwise agreed, all tests shall be carried out in the presence of the Register representative.

**3.7.7 Inspection.**

**3.7.7.1** All forgings shall be presented to the Register representative for visual testing including, where necessary, the examination of internal surfaces and bores. Unless otherwise agreed, the verification of dimensions is the responsibility of the Manufacturer.

The forgings shall be free from defects, which would be prejudicial to their proper application.

**3.7.7.2** When required by the relevant parts of the Rules or by the Register approved technical documentation, the forgings, including forged composite components, which shall be welded (refer to 3.7.1.8), appropriate non-destructive testing shall also be carried out.

The results shall be reported to the Register representative and included in a relevant quality document of the manufacturer on a forging or batch.

The scope of testing and acceptance criteria shall be agreed with the Register.

**3.7.7.3** When surface hardening of forgings is required (refer to 3.7.4.6), additional samples may be selected at the time of inspection.

These samples shall be subsequently sectioned in order to determine the hardness, shape, area and depth of the locally hardened zone and which shall comply with the requirements of the Register approved documentation.

**3.7.7.4** In the event of any forging proving defective in accordance with the Rules or Register approved documentation during subsequent machining or testing, it shall be rejected notwithstanding any available covering documents and certificates.

**3.7.7.5** It is permitted to remove surface defects by grinding or chipping and grinding within mechanical allowances.

The resulting grooves shall have a bottom radius of approximately three times the groove depth. Sharp contours are not permitted.

Complete elimination of defective material shall be verified by magnetic particle or penetrant testing.

**3.7.7.6** Repair welding of forgings except crankshaft forgings is in each case subject to consideration by the Register.

In such cases, procedure and location of the repair, subsequent heat treatment and inspection methods and criteria shall be approved by the Register.

**3.7.7.7** The forging manufacturer shall maintain records of repairs and subsequent inspections, which results shall be shown in a drawing or sketch of the forging.

Respective information shall be submitted to the Register representative at the latter's request.

**3.7.8 Identification and marking.**

**3.7.8.1** The manufacturer of forgings shall adopt a system of identification, which will enable all finished forgings, at the stage of being submitted to the Register, to be traced to the original cast, and the data pertinent to the process of a particular forging (batch) manufacture, which shall be recorded during the above process, including heat treatment and repair, shall be presented to the Register representative on request.

**3.7.8.2** All forgings shall be clearly marked in a specified place and in a specified manner with the Register stamp or brand to include at least the following particulars:

manufacturer's name or designation; identification number or other marking, which will enable the full history of the forging to be traced;

category or grade of steel.

**3.7.8.3** Where small forgings are manufactured in large numbers, modified arrangements for identification may be specially agreed by the Register.

**3.7.8.4** The manufacturer certificate to be submitted to the Register representative shall include the following particulars:

purchaser and order number;

category (grade) and description of forgings;

identification number;

steel melting process, cast number and chemical composition as per the ladle analysis;

mechanical test results;

non-destructive testing results, if necessary;

heat treatment type, including temperature and time of conditioning.

### **3.8 STEEL CASTINGS**

#### **3.8.1 General.**

**3.8.1.1** Steel castings subject to survey by the Register, when produced in conformity with the relevant parts of the Rules, shall be manufactured and tested in accordance with the requirements stated below.

**3.8.1.2** These requirements are applicable to carbon and carbon-manganese steel castings used in hull and ship machinery construction, the purpose of which shall be established proceeding from their properties determined at room temperature.

**3.8.1.3** The requirements for castings to be used at low or high temperature, as

well as for alloy steel castings with special properties (corrosion resistance, heat resistance, high temperature oxidation resistance, etc.) will be specially considered by the Register in each case. The documents submitted to the Register for approval shall contain detailed information on the chemical composition, mechanical and special properties, heat treatment procedures and scope of testing the castings.

**3.8.1.4** When two or more castings are joined by welding to form a composite item, the chemical composition of steel and the welding procedure are subject to approval by the Register. The Register may require technological tests of the welded joints to be carried out.

**3.8.1.5** The castings shall be manufactured at works recognized according to 1.3.1.4 in conformity with the procedure approved by the Register.

Use of surface hardening in the production process shall be also agreed with the Register.

#### **3.8.2 Chemical composition.**

**3.8.2.1** The chemical composition of a particular type of steel will be established proceeding from the mechanical and special properties required. The castings shall be made from killed steel.

**3.8.2.2** For carbon and carbon-manganese steel castings the chemical composition of ladle samples shall comply with the requirements of Table 3.8.2.2 and/or of the documents (specifications, standards, etc.) agreed with the Register.

**3.8.2.3** Unless otherwise required, suitable grain-refining elements may be used at the discretion of the manufacturer. The content of such elements shall be

reported in the ladle analysis.

### 3.8.3 Mechanical properties.

**3.8.3.1** The mechanical properties of steel castings shall meet the requirements of Table 3.8.3.1 and/or of documentation approved by the Register.

Table 3.8.3.1 gives minimum values of yield stress, elongation and reduction in area established depending on the required level of the tensile strength values for the steel castings.

**3.8.3.2** Where tensile test results are unsatisfactory, retesting shall be conducted in accordance with 3.8.6.4.

### 3.8.4 Heat treatment.

**3.8.4.1** To ensure the required structure and mechanical properties the castings shall undergo heat treatment. The procedure of heat treatment shall be chosen by the manufacturer proceeding from the chemical composition of steel, the purpose and shape of the castings. The following conditions shall be observed:

the tempering temperature shall not be less than 500 °C;

the stress relief heat treatment of castings for components such as crankshafts and engine bedplates where dimensional stability and freedom from internal stresses are important, shall be carried out at a temperature of not less than 550 °C followed by furnace cooling to 300 °C or lower;

if a casting is reheated or any straightening operation is performed after the final heat treatment, a subsequent stress relieving heat treatment may be required by the Register.

**3.8.4.2** As a rule, the steel castings shall be supplied in the following condition:

- completely annealed,
- after normalizing,
- after normalizing and tempering,
- after quenching and tempering.

All necessary data on the heat treatment process including procedures and appropriate instrument readings shall be submitted to the Register representative on his demand.

**Table 3.8.2.2 Chemical composition of carbon and carbon-manganese steel**

Type of steel	Type of structure	C, max %	Si, max %	Mn, max %	S, max %	P, max %	Residual elements, max %				Total number of residual elements, max %
							Cu	Cr	Ni	Mo	
Carbon, carbon-manganese	Non-welded	0.40	0.60	0.50-1.60	0.040	0.040	0.30	0.30	0.40	0.15	0.80
	Welded	0.23	0.60	1.60	0.040	0.040	0.30	0.30	0.40	0.15	0.80

**Table 3.8.3.1 Mechanical properties of castings**

Tensile strength $R_m$ , MPa min	Yield stress $R_{eH}$ or $R_{p0.2}$ , MPa	Elongation $A_5$ , %	Reduction in area $Z$ , %
400	200	25	40
440	220	22	30

480	240	20	27
520	260	18	25
560	300	15	20
600	320	13	20

Notes:1. Minimum yield stress value 250 MPa is allowed.

2. For intermediate tensile strength values, the minimum values of yield stress, elongation and reduction in area may be determined by linear interpolation.

**3.8.4.3** In case where steel casting after final heat treatment is subjected to local heating or to operations producing additional strain, heat treatment may be required to relieve residual stress.

### **3.8.5 Sampling.**

**3.8.5.1** Sampling may be effected directly from the casting or the test samples may be cast to it. They shall have a thickness not less than 30 mm.

The use of separately cast samples is permitted, in which case the dimensions of the sample shall correspond to the casting dimensions.

**3.8.5.2** Where two or more samples shall be provided for a casting they shall be cast at locations as widely separated as possible.

**3.8.5.3** The samples shall be heat treated together with the castings, which they represent.

**3.8.5.4** The size of samples shall be such as to ensure the performance of tests including re-tests, if required. All samples shall be identified.

### **3.8.6 Scope of testing.**

**3.8.6.1** At least one sample shall be provided for each casting. Where one casting is made from several casts (without mixing) the number of samples shall be equal to the number of casts involved. The condition of 3.8.5.2 shall be met in this case.

Where the casting is of complex design or where the finished mass exceeds 10 t, at least two samples shall be provided.

**3.8.6.2** A batch testing procedure may be adopted for castings. A batch shall consist of castings of approximately the same size and shape made from one cast and heat treated in the same furnace charge and having the total mass equal to or less than 1,000 kg.

Such batch may be represented by one of the castings considered as a sample or by a separately cast sample, the dimensions of which shall correspond to the castings comprising the batch.

**3.8.6.3** Unless otherwise specified, at least one tensile test specimen shall be taken from each sample.

Test specimens shall be prepared and the tests conducted in conformity with the requirements of Section 2. Unless otherwise stated, tests shall be conducted in presence of the Register representative.

**3.8.6.4** Where the tensile tests yield unsatisfactory results the tests shall be repeated on two additional specimens preferably cut out from the same sample. On agreement with the Register, specimens may be cut out from other sample or casting.

Where the tests carried out on two additional specimens yield satisfactory results, the casting and the batch if represented by the casting shall be accepted.

Where the test result on at least one of two additional specimens is unsatisfactory, the casting submitted shall be rejected. However, the remaining semi-finished products of the batch may be

accepted by the Register, provided that satisfactory test results are obtained on two more castings comprising the batch involved. Where unsatisfactory test results are obtained on one of two additionally selected castings, the entire batch shall be rejected.

At the manufacturer's discretion, the batch or casting rejected may be submitted to re-tests on the same conditions after repeated heat treatment.

**3.8.6.5** Where relevant requirements shall be found in other parts of the Rules, the castings shall be subjected to additional tests, such as pressure tests.

Where upon completion of all tests, owing to machining of the castings or as a result of any structural tests a defect is found, which interferes with the use of casting for its designated purpose, the batch shall be rejected irrespective of the availability of the relevant certificates.

### **3.8.7 Inspection.**

**3.8.7.1** The castings submitted for inspection and control testing shall be cleaned, de-gated, free of risers and burrs, etc.

The castings shall be free from defects, which would be prejudicial to their application in service.

Unless otherwise specified, the responsibility for fulfilment of the requirements for dimensions of the castings shall be imposed on the manufacturer of the castings.

**3.8.7.2** Where relevant requirements shall be found in other parts of the Rules or following the instructions of Register's representative the castings shall undergo non-destructive testing.

The testing procedure and the allowances for defects shall be in conformity with documentation approved

by the Register.

**3.8.7.3** Surface defects lying within machining allowances may be removed by machining.

**3.8.7.4** Defects may be repaired by welding in accordance with 2.6.3, Part XIV "Welding".

Prior to carrying out weld repairs of large-sized defects, alloy steel castings, castings for crankshafts and for other main components shall be pre-heated in accordance with 3.8.4; if required by the Register, the welded spots shall be subjected to non-destructive testing.

**3.8.7.5** The size, number of defects accepted uncorrected as well as of defects to be corrected shall be established on agreement with the Register.

The procedure of repair and subsequent inspection including, if necessary, welding is subject to agreement with the Register. All work shall be performed by the qualified personnel.

Repair welding shall be performed with the use of welding consumables recognized by the Register, which ensure properties of the deposited metal not inferior than those of the casting metal.

On completion of the repair welding, the castings shall be subjected to heat treatment to relieve residual stress at temperature not lower than 550 °C. The type and procedure of heat treatment depends on the type and nature of repair work performed previously as well as on the material and size of the castings. Refusal to carry out the above post-weld heat treatment is generally acceptable for small scopes of repair and is subject to special consideration of the Register in each case.

**3.8.7.6** Upon completion of the repair welding of the castings, the magnetic

particle or penetrant testing shall be carried out. Additional ultrasonic or radiographic testing may be required depending on the nature and size of surface defects detected.

Testing criteria are also subject to agreement with the Register.

**3.8.7.7** All repair works and their results shall be documented and available for the Register representative.

**3.8.8 Marking and documentation.**

**3.8.8.1** The manufacturer of the castings shall have an identification system, which enables to identify the casting with the ladle at a stage of submission to the Register, while upon the request of the Register representative, the manufacturer shall present the data, recorded in course of manufacture referred to the production process of a particular casting, or a batch, including thermal treatment and repair.

**3.8.8.2** Every casting shall have clearly visible stamp or brand of the Register marked by the specified method and in specified location, and, at least, shall contain the following data:

- manufacturer's name or designation;
- identification number or other marking, which will enable the full history of the forging to be traced;
- category or grade of steel.

**3.8.8.3** Where small castings are manufactured in large numbers the castings identification system may be agreed with the Register separately.

**3.8.8.4** Manufacturer certificate, submitted to the Register representative, shall contain the following data:

- purchaser and order number;
- steel category (grade) and description of casting;
- identification number;

- steel melting process, cast number and chemical composition as per the ladle analysis;

- mechanical test results;

- non-destructive testing results, if necessary;

- heat treatment type, including temperature and time of conditioning.

**3.9 SPHEROIDAL GRAPHITE IRON CASTINGS**

**3.9.1 General.**

**3.9.1.1** As defined in the relevant parts of the Rules, all spheroidal graphite iron castings subject to survey by the Register during their manufacture shall be manufactured and tested in accordance with the requirements of the following paragraphs.

If agreed with the Register and 3.1.2 is followed, castings may be manufactured according to national standards or works specifications.

**3.9.1.2** These requirements are applicable to spheroidal graphite iron castings used in hull and ship machinery construction. The purpose of the castings shall be established proceeding from their properties at room temperature.

**3.9.1.3** The requirements for castings intended for service at low or elevated temperatures will be specially considered by the Register in each case. In this case, detailed information on the chemical composition, mechanical and special properties, heat treatment, methods and scope of testing the castings shall be submitted to the Register.

**3.9.1.4** Where castings of the same type are regularly produced in quantity, alternative procedures for testing and scope of testing may be adopted subject to approval of the Register, provided that the

manufacturer verifies the continued efficiency of the manufacturing technique and the quality of castings.

**3.9.1.5** Castings subject to survey by the Register shall be manufactured at works recognized by the Register as mentioned in 1.3.1.4.

**3.9.1.6** For removal of risers and for castings grinding the relevant metal machining methods may be used.

The methods exerting a thermal effect on casting quality are not allowed with the exception of their use as preliminary before machining.

**3.9.1.7** When finished, castings shall be free of defects unfavourably affecting their use and shall be in full compliance with the approved documentation for

delivery.

### 3.9.2 Chemical composition.

**3.9.2.1** The chemical composition is left to the discretion of the manufacturer who shall ensure that it is suitable for obtaining the mechanical properties specified for the castings.

When required by the Register, the chemical composition of ladle analysis shall be reported.

### 3.9.3 Mechanical properties.

**3.9.3.1** The mechanical properties of the castings shall conform to Table 3.9.3.1.

While effecting the tensile test of the casting material the tensile strength and elongation shall be determined.

**Table 3.9.3.1 Mechanical properties and structure of spheroidal graphite iron**

Tensile strength <sup>1</sup> $R_m$ , MPa, <i>min</i>	Proof stress $R_{p0.2}$ , MPa, <i>min</i>	Elongation $A_5$ , %, <i>min</i>	HB hardness	Impact energy		Structure <sup>4</sup>	
				Test temperature, °C	$KV^2$ , J, <i>min</i>		
Normal quality	370	230	17	120-180	–	–	Ferrite
	400	250	15	140-200	–	–	Ferrite
	500	320	7	170-240	–	–	Ferrite/pearlite
	600	370	3	190-270	–	–	Ferrite/pearlite
	700	420	2	230-300	–	–	Pearlite
	800	480	2	250-350	–	–	Pearlite or tempered structure
Special quality	350	220	22 <sup>3</sup>	110-170	+20	17 (14)	Ferrite
	450	250	18 <sup>3</sup>	140-200	+20	14 (11)	Ferrite

<sup>1</sup> For intermediate tensile strength values the minimum values of elongation and upper yield stress may be determined by linear interpolation.

<sup>2</sup> The impact energy mean value is given for tests carried out on three V-notch type test specimens. It is allowed to lower the impact energy value for one of the three test specimens compared to the data given, but not less than given in brackets.

<sup>3</sup> When tensile tests are carried out on test specimens out of cast-on samples, the ultimate values of elongation may be lowered by 2 % of the given value.

<sup>4</sup> Data for information.

The minimum required tensile strength shall be stated in the agreed

technical documentation for the casting, but in no case shall it exceed the limits detailed in Table 3.9.3.1.

Additional requirements of the relevant parts of the Rules are also to be complied with.

Where mechanical test results are unsatisfactory, retesting shall be conducted in accordance with the requirements of 1.3.2.4.

**3.9.3.2** Where impact testing is required, the standards and type of specimen shall be approved by the Register.

**3.9.3.3** The micro-structure of the castings shall include not less than 90 % of spheroidal or graphite.

No flaked graphite is permitted.

**3.9.4 Heat treatment.**

**3.9.4.1** The castings shall be supplied in either as the cast or heat treated condition.

The necessity of heat treatment and the relevant procedure shall be determined by the manufacturer on the basis of chemical composition, purpose and shape of the castings.

For the purpose of structure refining and stress relieving, obligatory heat treatment may be required by the Register. The heat treatment for stress relieving shall follow the heat treatment for structure refining and to precede the machining.

Special quality castings having the tensile strength 350 and 400 MPa and the relevant necessary impact energy value shall undergo ferritizing.

**3.9.4.2** Where it is proposed to locally harden the surfaces of a casting, full details of the proposed procedure and specification shall be submitted to the Register for consideration.

**3.9.5 Sampling.**

**3.9.5.1** The samples may be either cast-on or separately cast. The dimensions of the samples, when cast separately, shall be in accordance with Figs 3.9.5.1-1, 3.9.5.1-2 and 3.9.5.1-3 (dimensions are given in mm); the sample length *l* shall be chosen proceeding from the type of the machine for tensile testing.

Subject to approval by the Register, the samples of alternative dimensions may be used, they may be taken directly from one of the castings.

Thickness of the mould surrounding a standard specimen shall not be less than 40 mm, and for alternative samples, not less than 40, 60 and 80 mm, respectively.

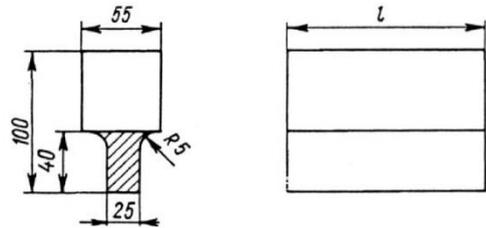


Fig. 3.9.5.1-1 Standard specimen and alternative specimens with dimensions:

Dimensions, mm			
Standard specimen*	Alternative specimens**		
25	12	50	75
55	40	90	125
40	30	60	65
100	80	150	165

*l* - to be selected depending on type of test machine.

\* — dimensions of a standard specimen given in Fig. 3.9.5.1-1.

\*\* — alternative dimensions corresponding to standard specimen.

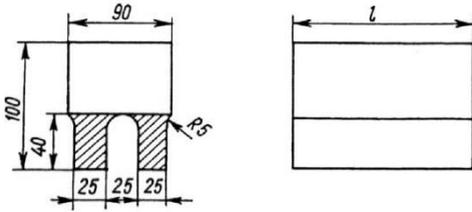


Fig. 3.9.5.1-2 Standard specimen (*l* to be selected depending on type of test machine).

Where separately cast samples are used, they shall be cast in moulds made from the same type of material as used for the castings and shall not be stripped from the moulds until the sample metal temperature is below 500 °C.

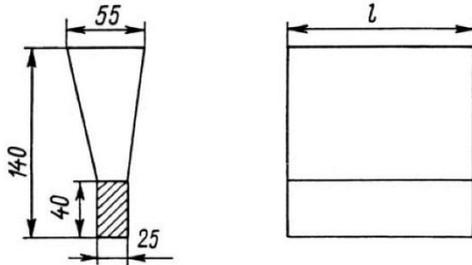


Fig. 3.9.5.1-3 Standard specimen and alternative specimens with dimensions:

Dimensions, mm			
Standard specimen*	Alternative specimens**		
25	12	50	75
55	40	90	125
40	30	50	65
140	135	150	175

*l* to be selected depending on type of test machine.

\* — dimensions of a standard specimen given in Fig. 3.9.5.1-3.

\*\* — alternative dimensions corresponding to standard specimen.

**3.9.5.2** When castings are supplied in the heat treated condition, the samples shall be heat treated together with the castings, which they represent.

**3.9.5.3** Samples for metallography examination may conveniently be taken

from the tensile test specimens, but separately cast samples may be prepared, provided that they are taken from the ladle towards the end of the casting period.

**3.9.6 Scope of testing.**

**3.9.6.1** At least one sample shall be taken from each casting.

If metal from several ladles is used for a castings one sample shall be taken from each ladle.

**3.9.6.2** A batch testing procedure may be adopted for castings with the fettled mass of 1 t or less.

All castings in the batch shall be of similar type and dimensions, and cast from the same ladle of metal. One separately cast sample shall be provided for each multiple of 2 t of fettled castings in the batch.

**3.9.6.3** At least one tensile test specimen, shall be prepared from each sample according to 2.2.2.3 and, where required, a set of V-notch type test specimens for impact tests according to 2.2.3.1.

**3.9.6.4** Where the castings are subject to pressure testing for tightness, both the working and test pressure shall be stated in the technical documentation.

**3.9.7 Inspection.**

**3.9.7.1** The castings shall be submitted for inspection and control testing in cleaned and de-gated condition, free from risers, etc.

The castings shall be free from defects, which would be prejudicial to their application in service. In general, repairing of defects by welding is not permitted. Subject to approval by the Register, surface imperfections may be removed by grinding.

Where there is reason to suspect the soundness of the castings non-destructive

testing are required.

Crankshafts shall undergo magnetic particle testing and metallography examination.

### **3.9.8 Marking and documentation.**

**3.9.8.1** Identification, marking and issued documentation — in accordance with the requirements of 3.8.8.

## **3.10 GREY IRON CASTINGS**

### **3.10.1 General.**

**3.10.1.1** All grey iron castings subject to survey by the Register, as defined in the relevant parts of the Rules, shall be manufactured and tested in accordance with the requirements of the following paragraphs.

**3.10.1.2** The present requirements apply to grey iron castings used in hull and ship machinery construction.

**3.10.1.3** Where castings of the same type are regularly produced in quantity, the manufacturer may adopt alternative procedures for, and scope of, testing subject to approval of the Register and provided that the continued efficiency of the manufacturing technique and the quality of castings is verified.

**3.10.1.4** If agreed with the Register and on condition that 3.1.2 is followed, castings may be manufactured in compliance with national standards and works specifications.

**3.10.1.5** Castings subject to the Register survey shall be manufactured at works recognized by the Register, as stated in 1.3.1.4.

### **3.10.2 Chemical composition.**

**3.10.2.1** The chemical composition is left to the discretion of the manufacturer, who shall ensure that it is suitable for obtaining the mechanical properties specified for the castings.

When required by the Register, the chemical composition of ladle analysis shall be reported.

### **3.10.3 Mechanical properties.**

**3.10.3.1** When carrying out the tensile test of the casting material (according to 2.2.2.4) the tensile strength shall be determined.

The specified minimum tensile strength shall be stated in the technical documentation for the casting, but in no case it shall be less than 200 MPa. Any additional requirements of the relevant parts of the Rules shall also be complied with.

Where tensile test results are unsatisfactory, retesting shall be conducted in compliance with the requirements of 1.3.4.2.

### **3.10.4 Heat treatment.**

**3.10.4.1** Castings may be supplied in either as the cast or heat treated condition.

The necessity of heat treatment and the relevant procedure shall be determined by the manufacturer on the basis of chemical composition, purpose and shape of the castings.

For the purpose of structure refining or stress relieving, obligatory heat treatment may be required by the Register. The heat treatment for stress relieving shall follow the heat treatment for structure refining and to precede the machining.

### **3.10.5 Sampling.**

**3.10.5.1** Unless otherwise agreed between the manufacturer and the Customer, cast samples shall have the form of cylindrical bars 30 mm in diameter (*D*) and of a suitable length.

They shall be cast from the same ladle as the castings in moulds of the same type of material as the moulds for the

castings.

The castings shall not be stripped from the moulds until the metal temperature is below 500 °C.

If two or more samples are cast in one mould at the same time, the rod diameter ( $D$ ) shall not be less than 50 mm and they shall be located as specified in Fig. 3.10.5.1 (dimensions are given in mm).

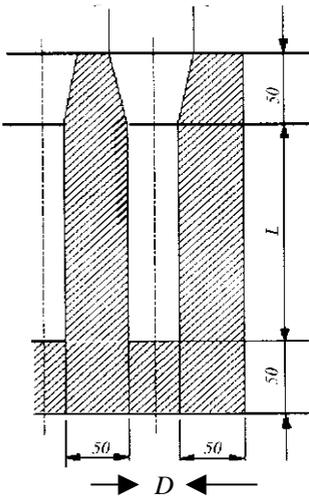


Fig. 3.10.5.1

Subject to approval by the Register, the samples of alternative dimensions may be used, they may be cast-on or taken directly from the castings.

As a rule, cast-on samples may be used if the casting wall thickness is over 20 mm and its mass exceeds 200 kg. In addition, the sample type and location shall ensure roughly the same cooling conditions similar to the base casting cooling and are subject to the manufacturer's agreement with a customer.

**3.10.5.2** Where castings are supplied in the heat treated condition, the samples

shall be heat treated together with the castings, which they represent.

**3.10.5.3** One tensile test specimen shall be prepared from each sample.

### 3.10.6 Scope of testing.

**3.10.6.1** From each casting at least one sample shall be taken.

Where metal from several ladles is used for a casting, one sample shall be taken from each ladle.

**3.10.6.2** All castings in the batch shall be of similar type and dimensions, and cast from the same ladle of metal. As rule, the batch mass shall not exceed 2 t of fettled castings; separate castings with a mass equal to or over 2 t also form a batch.

At continuous casting of iron of the very same grade and in large quantities, the batch mass may be limited by the metal cast within two hours.

The batch volume and number of samples taken are subject to an agreement with the Register.

**3.10.6.3** Where the castings are subject to pressure testing for tightness, both the working and test pressure shall be stated in the technical documentation.

### 3.10.7 Inspection.

**3.10.7.1** The castings shall be submitted for inspection and control testing in cleaned and de-gated condition, free from risers, etc.

The castings shall be free from defects, which would be prejudicial to their application in service. In general, repairing of defects by welding is not permitted. At the discretion of the Surveyor, small surface blemishes may be removed by local grinding. Where there is reason to suspect the soundness of the castings non-destructive testing may be required.

### **3.10.8 Marking and documentation.**

**3.10.8.1** Identification, marking and issued documentation for grey iron castings — in accordance with the requirements of 3.8.8.

## **3.11 MALLEABLE CAST IRON**

### **3.11.1 General.**

Malleable cast iron may be used for the manufacture of parts for hull and ship machinery construction that are subject to survey by the Register and are intended to operate at a temperature not exceeding 300 °C and the working pressure not exceeding 2 MPa.

The castings of malleable cast iron shall be produced by the manufacturers recognized by the Register in compliance with 1.1.4 and 1.3.1.4.

The request shall be supplemented with specifications for material, description of production, requirements for inspection and repairs.

### **3.11.2 Chemical composition and mechanical properties.**

The chemical composition, mechanical properties and scope of testing of items made of malleable cast iron shall be agreed with the Register in each case.

### **3.11.3 Marking and documentation.**

**3.11.3.1** Identification, marking and issued documentation for castings made of malleable cast iron — in accordance with the requirements of 3.8.8.

## **3.12 STEEL CASTINGS FOR PROPELLERS**

### **3.12.1 General.**

**3.12.1.1** The requirements of the present Subsection apply to steel castings for cast propellers, blades and bosses

during their manufacture. Subject to the special consideration by the Register, these requirements may also be applied in the repair of propellers damaged in service.

The use for propellers of steel according to national standards or other technical requirements, which is different in chemical composition, mechanical properties or heat treatment from, specified here is subject to the special consideration by the Register. In such cases, national standards shall be approved by the Register.

**3.12.1.2** Propeller castings shall be manufactured by the works recognized by the Register in accordance with 1.1.4 and 1.3.1.4.

Specifications for material, the description of a technological process, repair and inspection shall be attached to a request for material.

**3.12.1.3** Recognizing the works, tests are conducted in accordance with 1.3.5 on the basis of the survey and tests program approved by the Register. The tests shall confirm the compliance of castings material and their quality with these requirements.

**3.12.1.4** A foundry shall have available a properly equipped laboratory manned with experienced qualified personnel. The laboratory shall have at its disposal everything necessary for the performance of non-destructive testing. However, if the laboratory is unable to conduct tests and inspection, the data on an independent laboratory shall be submitted to the Register.

The laboratory shall be recognized by the competent national body and/or Register.

### **3.12.2 Chemical composition.**

The chemical composition of the steel for propellers shall meet the requirements of Table 3.12.2.

The alloys in the Table are subdivided into four main groups.

**Table 3.12.2 Chemical composition of steel for propeller castings<sup>1</sup>**

Steel grade and type	C, %, max	Mn, %, max	Cr, %	Mo, %, max	Ni, %
Martensite (12Cr1Ni)	0.15	2.0	11.5-17.0	0.5	Max 2.0
Martensite (13Cr4Ni)	0.06	2.0	11.5-17.0	1.0	3.5-5.0
Martensite (16Cr5Ni)	0.06	2.0	15.0-17.5	1.5	3.5-6.0
Austenite (19Cr11Ni)	0.12	1.6	16.0-21.0	4.0	8.0-13.0

<sup>1</sup> The minimum content of elements not specified in the Table shall meet the requirements of recognized national or international standards.

### 3.12.3 Mechanical properties and heat treatment.

**3.12.3.1** The mechanical properties of steel during the testing of specimens prepared from samples cast-on to the hub or blade shall meet the requirements of Table 3.12.3.1.

**3.12.3.2** The level of mechanical properties of the separately cast samples metal is subject to the special approval by the Register.

#### 3.12.3.3 Heat treatment.

Castings of martensite class steel shall be subjected to austenization and tempering.

Austenite class steels shall be subjected to solution treatment.

### 3.12.4 Sampling.

**3.12.4.1** Samples may be taken immediately from a casting or gated to it. Test specimens, where possible, are taken from the cast-on sample in the area within  $0.5R$  to  $0.6R$  (where  $R$  is a propeller radius).

The use of separately cast samples to machine specimens is subject to approval by the Register.

**3.12.4.2** Separately cast samples shall be taken from the same ladle as the casting as the metal presented and heat treated in the same furnace charge.

In the initial survey of a works in accordance with 3.12.1.2, tests may be conducted in the metal of both separately cast and cast-on samples or taken directly from a casting body.

**3.12.4.3** Samples shall not be taken from a casting prior to a final heat treatment. Samples are prepared in accordance with the standards recognized by the Register.

**3.12.4.4** Thermal methods shall not be used for sampling.

#### 3.12.5 Number of tests.

**3.12.5.1** At least one tensile test specimen (refer to Table 2.2.2.3) and one set of impact test specimens (refer to 2.2.3) shall be taken from each cast presented. In tensile tests, the tensile strength, proof stress, elongation and reduction in area are determined.

Tests are conducted in compliance with the requirements of 2.2.

**3.12.5.2** Test specimens shall generally be cut out from cast-on samples. If castings are roughly of the same size, less than 1 m in diameter made from metal of one cast and heat treated in one furnace charge, one set of specimens for each 5 castings may be taken from separately

cast samples of the relevant dimensions.

**Table 3.12.3.1 Mechanical properties of steel castings for propellers**

Steel grade and type	Proof stress $R_{p0.2}$ , MPa, max	Tensile strength $R_m$ , MPa, max	Elongation, $A_5$ , %, max	Reduction in area $Z$ , %, max	Impact energy, <sup>1</sup> J (KV), max
Martensite (12Cr1Ni)	440	590	15	30	20
Martensite (13Cr4Ni)	550	750	15	35	30
Martensite (16Cr5Ni)	540	760	15	35	30
Austenite (19Cr5Ni)	180 ( $R_{p1.0} = 205$ )	440	30	40	–

<sup>1</sup> The impact test is not required for the ships of **Ice1**, **Ice2** and **Ice3** categories; for all other ships with ice strengthening and for icebreakers, steel castings shall be impact-tested at  $-10\text{ }^{\circ}\text{C}$ .

### 3.12.6 Severity zones (repair zones).

**3.12.6.1** In order to define the criteria of assessment for propeller defects, the blade surface is divided into three zones designated *A*, *B* and *C* (refer to Figs 4.2.6.2.1 and 4.2.6.3).

The definitions of repair zones are given in 4.2.6.2 and 4.2.6.3.

**3.12.6.2** The definition of a skew angle — refer to 4.2.6.1 (Note) and Fig. 4.2.6.1.

### 3.12.7 Inspection.

**3.12.7.1** Propeller castings shall be visually tested at all the stages of their manufacture.

The castings shall be subjected to a thorough 100 % visual testing in the finished condition (the inspection is conducted by the Register representative). A surface shall be free from the defects, which may result in propeller damages during operation.

The Register representative can demand the performance of investigation of questionable surface sections including metal etching, particularly prior to repair

welding.

**3.12.7.2** Dimensions, dimensional and geometrical tolerances shall meet the requirements of the drawings approved by the Register and of order documentation. The above documents and the results of measurements and inspection drawn up in the form of a report or statement are produced to the Register representative during tests. The responsibility for the performance of measurements with an appropriate accuracy for their compliance with the requirements of the drawing and/or order rests with a manufacturer. The Register representative has a right to demand checking measurements.

Static balancing shall be carried out on all the propellers in accordance with the documentation approved by the Register.

Dynamic balancing is required for propellers running with a rotational speed of over 500 rpm.

### 3.12.8 Non-destructive testing.

**3.12.8.1** All the castings of propellers shall be subjected to non-destructive testing. A manufacturer shall have

available an appropriate system to record all the non-destructive testing results for each casting.

The Register representative shall be familiarized with that system and the results of the testing carried out.

The manufacturer duty shall confirm in the documentary form the true performance and the positive results of non-destructive testing methods.

### 3.12.8.2 Penetrant testing.

The penetrant testing shall be carried out in accordance with a standard or specification approved by the Register. The following definitions are recommended.

**Indication** is the presence of detectable bleed-out of the penetrant from the material discontinuities appearing at least 10 minutes after the developer has been applied.

**Linear indication** is the indication, in which the length is at least three times the width (refer to Fig. 4.2.7.3.1(2)).

**Non-linear indication** is the indication of a circular or elliptical shape with a length less than three times the width (refer to Fig. 4.2.7.3.1(1)).

**Aligned indication** is three or more indications in a line separated by 2 mm or less edge-to-edge — (refer to Fig. 4.2.7.3.1(3)).

**Threshold sensitivity** is the opening of a discontinuity like the isolated crack of a certain length detected with the

given probability according to the given geometrical and optical parameters of an indication. The indication, any dimension of which is over 1.5 mm, may be considered as the isolated indication taken into account.

**Reference area** is an area of 100 cm<sup>2</sup>, which may be square or rectangular with the major dimension not exceeding 250 mm. For evaluation of surface quality by penetrant testing method the entire surface to be inspected shall be divided into reference areas of 100 cm<sup>2</sup>. The area shall be taken in the most unfavourable locations relative to the indication being evaluated i.e. the shape and dimensions of each reference area are chosen so that they cover the maximum number of defects without their distribution to an adjacent reference area.

The indications detected in each of such areas, with respect to their size and number, shall meet the requirements given in Table 3.12.8.2.

### 3.12.8.3 Radiographic and ultrasonic testing.

Where serious doubts exist that castings are not free from internal defects, further radiographic and/or ultrasonic testing shall be carried out upon request of the Register representative. The evaluation and acceptance criteria shall be agreed between a manufacturer and the Register in accordance with the standards approved by the Register.

**Table 3.12.8.2 Allowable number and size of indications depending on severity zone**

Severity zone	Total number of indications, max	Indication type	Number of indications of each type, max	Indication size, mm, max
---------------	----------------------------------	-----------------	-----------------------------------------	--------------------------

A	7	Circular	5	4
		Linear	2	3
		Aligned	2	3
B	14	Circular	10	6
		Linear	4	6
		Aligned	4	6
C	20	Circular	14	8
		Linear	6	6
		Aligned	6	6

Notes: 1. Single non-linear indications less than 2 mm in zone A and less than 3 mm in other zones may be disregarded.

2. The total number of non-linear indications may be increased to the total allowable number of all type indications, represented by the absence of linear or aligned indications. The total number of non-linear indications may also be increased due to the partial lack of linear or aligned indications retaining the total allowable number of indications.

### 3.12.9 Repair of defects.

**3.12.9.1** Surface discontinuities, which impair propellers performance, shall be repaired by mechanical methods, e.g. by grinding, chipping and milling.

The use of welding to repair defects is allowed only in justified cases to be agreed with the Register representative.

The repair of defects shall be carried out after producing the documentation with the full description of works to be conducted, to the Register representative. The relevant repair zones, dimensions and location of defects, methods of their repair and inspection shall be specified.

After milling or chipping, grinding shall be applied for such defects, which shall not be welded. The grinding shall be carried out in such a manner that the contour of the ground depression is as smooth as possible to avoid stress concentration and/or minimize cavitation corrosion.

The metal for welding shall be properly selected and shall have the shape and dimensions needed for welding. Welding of areas less than 5 cm<sup>2</sup> shall be avoided.

#### 3.12.9.2 Repair of defects in zone A.

In zone A, repair welding is not allowed. Grinding in zone A may be carried out to the extent, which maintains the blade thickness of the drawing approved by the Register.

The possible repair of defects by methods not specified here shall be specially considered by the Register.

#### 3.12.9.3 Repair of defects in zone B.

The defects that are not deeper than  $t/40$  ( $t$  is minimum local thickness) or 2 mm (whichever is greater) may be removed by grinding.

The defects, which are deeper than allowable for removal by grinding, may be repaired by welding.

#### 3.12.9.4 Repair of defects in zone C.

In zone C, repair welds are generally permitted.

#### 3.12.9.5 Repair welding.

**3.12.9.5.1** The welding procedure and welding consumables used for defects repair shall be recognized by the Register in accordance with the requirements of Part XIV "Welding".

Prior to the beginning of works on the repair of defects by welding, it shall be

submitted the detailed specification of a welding procedure, which shall include data on the welding position, welding process parameters, welding consumables, preheating, follow-up heat treatment and inspection of welding operations conducted. Welding shall be conducted under controlled conditions, which prevent an adverse exposure to weather.

Defects shall be repaired by welders of a proper qualification, allowed by the Register to perform such works.

Slag, undercuts and other flaws shall be repaired prior to the following pass.

Martensite class steels after repair by welding are subject to annealing in a furnace.

The relief of local residual stresses with the minimum repair is subject to the special consideration by the Register.

Repaired surfaces after heat treatment shall be milled and ground. In all cases, the repair quality shall be checked by non-destructive testing methods.

A manufacturer shall maintain the system of defects recording, on which base the scope of a repair conducted, the type and schedules of heat treatment for any casting may be determined. The entire information on the casting being subject to the Register survey is produced to the Register representative.

The approval of a welding procedure shall be based on the welding of samples as shown in Fig. 3.12.8.5.1, having the thickness of 30 mm or more. Following welding, the samples are subject to penetrant testing.

The approval of a welding procedure is carried out in accordance with the requirements of Section 6, Part XIV

“Welding” following the Register-approved program, which shall include, as a minimum, the following tests.

*Macro-examination of a fusion line and heat-affected zone.*

Carried out on two macro-sections. Cracks, pores, slag inclusions and other weld flaws over 3 mm in size are not permitted.

*Tensile testing for determination of weld metal properties.*

Carried out on two transverse specimens, which thickness is equal to that of a sample, the width is 30 mm and the parallel test length is equal to the weld width plus 6 mm to each side (refer to 4.2.3.2.2, Part XIV “Welding”). Mechanical properties shall meet those required for the base metal.

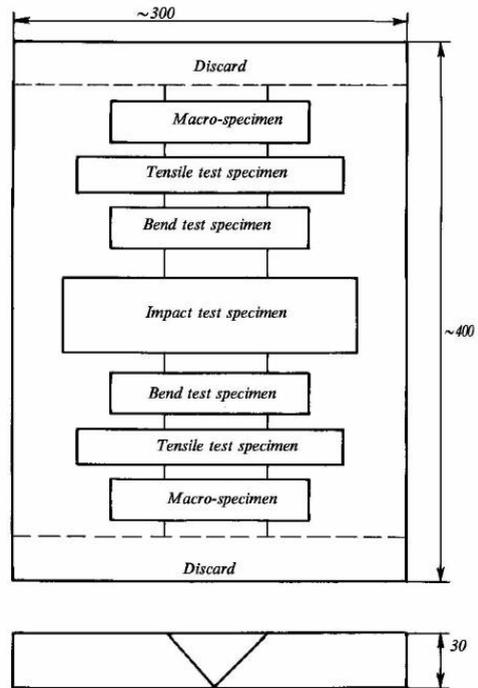


Fig. 3.12.8.5.1

The fracture area (weld metal, heat-

affected zone or base metal) shall be documented in the test report.

*Bend testing.*

Carried out on two transverse specimens made in accordance with the requirements of 2.2.5.1. The test is conducted on a mandrel four thickness in diameter excepting austenite steels, for which the mandrel diameter shall be equal to three times thickness. After the tests, the specimen surface shall be free from tension fractures and cracks of more than 2 mm long.

*Impact test.*

The tests are not generally required excepting the cases when a base metal was subjected to these tests. Where necessary, impact tests are conducted on specimens made in accordance with 2.2.3 and Fig. 2.2.3.1-2.

The tests shall be conducted on one batch of specimens notched in the weld centre and on another one notched in the fusion line. The temperature and results of the tests shall meet those required for the base metal.

*Hardness testing according to Vickers (HV5).*

Carried out on macro-sections as indicated in Fig. 6.3.1.10, Part XIV "Welding". Three measurements are, as a minimum, made on the weld metal, heat-affected zone, at both sides of a weld and in the base metal. The measurements are noted in a test report.

**3.12.10 Identification and marking.**

**3.12.10.1 Identification.**

A monitoring system enabling to check the castings manufacture at any stage since metal smelting shall be used at the works manufacturing propellers.

The confirmation of the availability

of such system at the manufacturer's shall be submitted to the Register representative on its demand.

**3.12.10.2 Marking.**

A casting shall be properly marked prior to its presentation in the finished condition to the Register representative. In addition to specified in 1.4, the marking shall include the following data:

casting number and other designations allowing tracing all the stages of manufacture;

number of the Register Certificate;

skew angle (for high-skew propellers);

ice class symbol, where applicable;

date of casting acceptance.

The Register stamp is put following the final survey and the acceptance of a casting by the Register representative.

**3.12.10.3 Manufacturer's Certificate of Quality.**

The Certificate of Quality for a casting shall be submitted to the Register representative simultaneously with the presentation of the casting in the finished condition or prior to that. The Certificate shall be verified by the quality service of a works and witnessed by the person authorized for this by the works. The Certificate shall contain the following data:

name of the enterprise and order number;

shipbuilding project number, if known;

description of the casting with drawing number;

propeller diameter, number of blades, pitch, direction of turning;

final weight;

grade and type of alloy, heat number and chemical composition;

identification number;  
 heat treatment procedure;  
 mechanical test results;  
 result of non-destructive testing  
 (satisfactory or unsatisfactory), if applied.

#### 3.12.10.4 The Register Certificate.

Each casting or the batch of small castings shall be accompanied with the Register Certificate.

In addition to the special number, the requisites of the Register representation or location, the place and date of issue, the Register Certificate is, as a minimum, to contain the following data:

name of the enterprise and order number;  
 shipbuilding project number, if known;  
 number of the certificate of quality of the casting manufacturer;  
 final weight;  
 identification number and casting number;  
 drawing number.

The Manufacturer's Certificate of Quality shall be the mandatory appendix to the Register Certificate. Test protocols witnessed by the Register representative may also be part of the appendix to the Register Certificate on the purchaser's demand.

### 3.13 HIGH STRENGTH STEEL FOR WELDED STRUCTURES

#### 3.13.1 General.

The present requirements apply to weldable plates and wide flats of high strength steel up to 70 mm thick subject to the survey by the Register during manufacture and intended for the manufacture of hull structures and other welded structures.

On agreement with the Register, the

requirements may be applied to rolled products more than 70 mm thick of shapes other than above (sections, structural pipes, etc.).

Proceeding from the minimum yield stress guaranteed the steel is subdivided into six strength levels: 420, 460, 500, 550, 620 and 690 MPa; depending on impact test temperature, four categories are determined for each strength level: A, D, E, F.

Steel with the mechanical properties, chemical composition, etc. differing from the requirements set forth below, is subject to special consideration by the Register.

High strength steel is manufactured at works recognized according to 1.3.1.4.

#### 3.13.2 Chemical composition.

The chemical composition of steel shall be determined by the manufacturer from each cast or ladle in an adequately equipped laboratory with competent staff.

The chemical composition of steel shall be in accordance with specification approved by the Register and the limiting values to be found in Table 3.13.2.

The steel shall be fully killed and fine grain treated.

The content of alloying and grain-refining elements shall be in accordance with specification approved by the Register.

To estimate the cold-cracking resistance of steel proceeding from the chemical composition of ladle analysis, a factor, which accounts for steel embrittlement as a result of structural transformations, shall be determined from the formula below

$$P_{CM} = C + Si/30 + Mn/20 + Cu/20 + Ni/60 + Cr/20 + Mo/15 + V/10 + 5B \%$$

The maximum value of  $P_{CM}$  shall be the Register-approved specification. agreed with the Register and included in

Table 3.13.2

Steel strength level, MPa	Steel grade	Content of elements, %, max					
		C	Si	Mn	P	S	N
420-690	A	0.21	0.55	1.70	0.035	0.035	0.020
	D, E	0.20	0.55	1.70	0.030	0.030	0.020
	F	0.18	0.55	1.60	0.025	0.025	0.020

### 3.13.3 Mechanical properties.

For the purpose of tensile and impact testing, the mechanical properties of steel shall be in accordance with Tables 3.13.3-1 and 3.13.3-2.

Where rolled products of other shapes (sections, construction pipes, etc.) are tested, the elongation required for lengthwise specimens shall exceed that stated in Tables 3.13.3-1 and 3.13.3-2 by 2 %.

### 3.13.4 Condition of supply.

The steel shall be quenched and tempered. For steels up to 50 mm thick, thermo-mechanically controlled processing (TMCP) may be permitted

by the Register after special consideration.

### 3.13.5 Sampling.

The axes of specimens to undergo the tensile test shall be perpendicular to the direction of the last rolling except for wide flats 600 mm or less wide, sections and bars, for which the orientation of specimen is determined on agreement with the Register. As a rule, flat tensile specimens shall be machined in such a way that the rolled surface is preserved on one side at least.

If tensile testing is effected on cylindrical specimens the axes of the latter shall be  $\frac{1}{4}$  of the thickness dimension from the surface or as close to that position as possible.

Table 3.13.3-1 Mechanical properties of rolled products with maximum thickness of 70 mm

Steel grade	Tensile test			Impact test		
	Yield stress $R_{eH}$ or $R_{p0.2}$ , MPa, min	Tensile strength $R_m$ , MPa	Elongation $A_5$ , % , min	Temperature, °C	Impact energy KV, J, min	
					Lengthwise specimen	Crosswise specimen
A420	420	530-680	18	0	42	28
D420				-20		
E420				-40		
F420				-60		
A460	460	570-720	17	0	46	31
D460				-20		
E460				-40		
F460				-60		
A500	500	610-770	16	0	50	33
D500				-20		
E500				-40		
F500				-60		

A550	550	670-830	16	0	55	37
D550				-20		
E550				-40		
F550				-60		
A620	620	720-890	15	0	62	41
D620				-20		
E620				-40		
F620				-60		
A690	690	770-940	14	0	69	46
D690				-20		
E690				-40		
F690				-60		

Notes: 1. The Register may require for a specific value of tensile strength to be established.

2. Where tensile tests are made on full-thickness specimens 25 mm wide and 200 mm long, the minimal elongation shall be in accordance with Table 3.13.3-2.

3. Based on satisfactory control test results and on agreement with the Register, the scope of impact testing may be reduced for Grade A steel.

**Table 3.13.3-2 Minimal elongation values for standard specimens of full thickness with design length of 200 mm, %**

Steel strength level, MPa	Thickness $t$ , mm						
	$\leq 10$	$> 10$ $\leq 15$	$> 15$ $\leq 20$	$> 20$ $\leq 25$	$> 25$ $\leq 40$	$> 40$ $\leq 50$	$> 50$ $\leq 70$
420	11	13	14	15	16	17	18
460	11	12	13	14	15	16	17
500	10	11	12	13	14	15	16
550	10	11	12	13	14	15	16
620	9	11	12	12	13	14	15
690	9	10	11	11	12	13	14

Unless otherwise agreed with the Register, the impact testing of steel plates and wide flats more than 600 mm in width shall be effected on specimens prepared in accordance with Table 2.2.3.1-2 and Fig. 2.2.3.1-2, the lengthwise axis of which is perpendicular to the direction of rolling (transverse specimens). Where rolled products of another cross-sectional shape are concerned the impact testing shall be effected on lengthwise specimens.

The specimens shall be dimensioned and tests shall be conducted in compliance with the requirements of 2.2. Where test results are unsatisfactory, retesting shall

be conducted in compliance with the requirements of 1.3.4.

### 3.13.6 Scope of testing.

Each plate (rolled length) shall undergo tensile and impact testing after heat treatment.

For rolled products quenched and tempered in continuous furnaces, the scope of testing, including the number of specimens and the direction of their cutting out, is determined on the basis of specification approved by the Register, after special consideration.

Out of each test sample, at least one tensile specimen and three impact test

specimens shall be prepared.

If required by the Register, tensile testing shall be made on specimens with their lengthwise axes perpendicular to the plate surface and the reduction in cross-sectional area shall be determined.

### **3.13.7 Inspection.**

Rolled products shall be in accordance with all the requirements of 3.2.7 taking the provisions below into consideration.

When surface defects are eliminated by grinding, the thickness of the rolled products at the ground spot shall not exceed permitted tolerances.

When required by the Rules, the rolled products shall undergo the ultrasonic testing in conformity with standards approved by the Register.

### **3.13.8 Marking and documentation.**

Identification, marking and issued documentation — in accordance with the requirements of 3.2.8.

## **3.14 Z-STEEL**

### **3.14.1 General.**

The present requirements apply to steel of normal, higher (refer to 3.2 and 3.5), high strength (refer to 3.13) having thickness equal to or more than 15 mm.

On agreement with the Register, application of the requirements set forth is possible also for rolled steel with thickness less than 15 mm.

Z-steel is recommended for use for welded structures taking up considerable stresses perpendicular to rolled surface.

The present requirements define two levels of Z-properties for steel. Two relevant notations: Z25 and Z35 are introduced.

Rolled products shall be manufactured by works recognized by the Register (refer to 1.3.1.4). The Manufacturer shall prove that the manufacturing process provides guaranteed plastic properties in the through rolling thickness direction.

At appropriate guarantees of the manufacturer a supply of steel with determination of the reduction in area ( $Z_z$ ) of the rolled products with a thickness specified in the documentation agreed with the Register is permitted.

Provision is made for calcium treatment, vacuum degassing, argon stirring, sulphur segregation control, etc.

### **3.14.2 Chemical composition.**

**3.14.2.1** Z-steel shall be fully killed and fine grain treated.

The contents of elements shall comply with the national or international standards recognized by the Register.

The content of sulphur (ladle analysis) in Z-steel shall not exceed 0.008 %.

### **3.14.3 Mechanical properties.**

**3.14.3.1** The mechanical properties of the steel, unless otherwise specified, shall meet the requirements of 3.2, 3.5 and 3.13.

For the appropriate level of Z-properties, the average value of the reduction in area  $Z_z$  obtained upon tension of three specimens, the lengthwise centreline of which is perpendicular to rolled surface, shall comply with Table 3.14.3-1. Table 3.14.3-1 gives for each level of Z-properties the value of the reduction in area to which the area is allowed to reduce on one of the specimens.

The need for retest on additional set of three specimens cut out from the same rolled product (refer to 2.2.2.5) and

acceptance of test results including also retest results as satisfactory is shown in Table 3.14.3-2.

Table 3.14.3-1

Level of Z-properties	Z25, %	Z35, %
Minimum average value of reduction in area	25	35
Minimum allowable value of reduction in area for one specimen	15	25

The Table 3.14.3-2 gives boundary cases taken into account by the Rules:

- case of satisfactory tests on three specimens;
- three cases where retest is permitted;

case of retest of six specimens (three completed plus three additional).

The retest results are considered to be satisfactory and the rolled product/batch is accepted for supply, provided that:

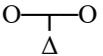
the average value of the reduction in area **Zz**, obtained as a result of testing six specimens exceeds the required minimum average value (refer to Table 3.14.3-2);

the results less than the mentioned required value have been obtained on not more than two specimens out of six.

Where the retest results are unsatisfactory the rolled product/batch submitted shall be rejected.

Additional tests (on the same conditions) are permitted for each rolled product (other than that already tested) out of the batch rejected.

Table 3.14.3-2

	Test		Retest
	Satisfactory result	Unsatisfactory result. Retest is required	Satisfactory result
Minimum required value of reduction in area			
Minimum allowable value of reduction in area for one specimen			

Symbols:  
 O — individual result for one specimen;  
 Δ — average test result.

### 3.14.4 Sampling and scope of testing.

The scope of testing depends on the type of rolled product and content of sulphur (ladle analysis).

The scope of testing shall be determined in accordance with Table 3.14.4.

Samples shall be taken from one end of the semi-finished product submitted for tests, as indicated in 2.2.2.5.

### 3.14.5 Inspection.

Besides fulfilment of the requirements of 3.2.7, all the rolled products shall be subject to ultrasonic testing at the final stage of manufacture.

Table 3.14.4

Type of rolled products	Sulphur content, %	
	S > 0.005	S ≤ 0.005
Plate	Each plate	One plate out of maximum 50 t of products of the same heat number, thickness and heat treatment
Wide flats of thickness t ≤ 25 mm	Maximum 10 t of products (semi-finished products of the same heat number, thickness and heat treatment)	Maximum 50 t of products (semi-finished products of the same heat number, thickness and heat treatment)
Wide flats of thickness t > 25 mm	Maximum 20 t of products (semi-finished products of the same heat number, thickness and heat treatment)	Maximum 50 t of products (semi-finished products of the same heat number, thickness and heat treatment)

## 3.15 STEEL WIRE ROPES

### 3.15.1 General.

3.15.1.1 The present requirements apply to ropes, subject to the Register survey, which are intended for cargo-handling gear, life-saving appliances and other ship appliances.

3.15.1.2 The ropes shall be manufactured and tested in conformity with standards approved by the Register and by works recognized by that body

The ultrasonic testing shall be carried out in accordance with the requirements of EN 10160 (level S2/E1) or ASTM A578 (level C at 4 MHz) or in accordance with the Register-approved national standards.

### 3.14.6 Marking and documentation.

Identification, marking and issued documentation — in accordance with the requirements of 3.2.8.

Besides, Z25 or Z35 shall be added to the steel designation mentioned (e.g., DH36Z25).

according to 1.3.1.4.

### 3.15.2 Manufacture.

3.15.2.1 For the manufacture of ropes, wire of round cross-section shall be used with a coating to protect it from corrosion and a tensile strength not less than 1180 to 1770 MPa.

3.15.2.2 The organic fibre core of ropes shall be manila, sisal, hemp or synthetic fibre. Ropes with the diameter more than 12 mm shall have

a core of three strands.

**3.15.2.3** Wires shall be coated with oil.

The organic fibre cores shall be impregnated or lubricated with corrosion preventive and anti-rot substances insoluble in sea water and containing no acids or alkalis. The lubricant for the ropes and the impregnant for the organic-fibre cores shall be compatible by their physical and chemical properties.

### **3.15.3 Sampling.**

For testing purposes, from each rope 2,000 m or less long a sample length shall be taken, and from ropes longer than 2,000 m a sample length shall be taken from both ends.

The sample lengths shall be long enough to make all the required testing possible.

### **3.15.4 Scope of testing.**

**3.15.4.1** After manufacture, each rope shall undergo the following tests:

breaking test of rope as a whole;

tensile test (ultimate strength being determined), bend test, twisting test and testing of the bond between the coating and steel core on wires from the rope.

The number of wires to be tested may be determined on the basis of standards, but not less than 10 % of the total number of wires in a group of wires of a particular diameter shall be tested.

**3.15.4.2** Testing shall be conducted in accordance with approved standards.

The breaking test of the rope as a whole shall be effected by means of a breaking machine having the distance between the clamps not less than 50 times rope diameter.

If during testing the rope breaks less than 50 mm away from the grip the test shall be repeated.

**3.15.4.3** The test results shall be in accordance with standards.

**3.15.4.4** Under conditions of an established manufacturing process and in the event of testing equipment of the required capacity being not available to enable the breaking test of a rope as a whole the breaking load may be determined proceeding from the results of the tensile test,  $F$ , in kN, of all the wires making up the rope on the basis of the formula

$$F = c \sum_1^i \left( \left( \sum_1^m F_m \right) n/z \right),$$

where  $c$  is wire efficiency factor for the rope, which shall be adopted on the basis of standards or calculated as the ratio of the breaking load on the rope as a whole to the total breaking load on all the yams making up the rope, both the values being stipulated by the standards;

$i$  is number of groups of wires of the same diameter;

$m$  is number of wires from each group of a particular diameter, subjected to tensile testing, which conform to Register-approved standards;

$F_m$  is the greatest load, during the tensile test of a wire, kN, after which the specimen breaks;

$n$  is number of wires in each group of a particular diameter;

$z$  is number of wires from each group of a particular diameter subjected to tensile testing.

On agreement with the Register and proceeding from the intended application of the rope, the number of wires to be tensile tested may be reduced, but in no case to less than 25 % of the total number of wires in the rope.

### **3.15.5 Inspection.**

**3.15.5.1** The compliance of the structure, diameter and other parameters of the rope to standards shall be confirmed by visual testing.

**3.15.5.2** When bends or burn-off spots are removed from the ends of

unstrandable ropes the strands and wires in the strands shall not uncoil or may uncoil in such a way that they can be easily returned to their initial position.

**3.15.5.3** The rope diameter shall be determined on a slack rope at right angles to the axis between two opposite strands in two positions.

The rope diameter shall not exceed the design value by more than 6 %.

**3.15.5.4** On the rope surface, twisting and bending of strands, sinking, crossing, corrosion and breaking of wires in strands that prevent using the rope in accordance with the purpose are not permitted.

### **3.15.6 Marking and documentation.**

Identification, marking and issued documentation — in accordance with the requirements of 1.4.

## **3.16 CORROSION-RESISTANT (STAINLESS) STEEL**

### **3.16.1 General.**

**3.16.1.1** These requirements apply to stainless steel subject to the Register survey during its manufacture as required in other Parts of the Rules and intended for:

- structures of cargo and process vessels under pressure and without pressure, systems and pipes for chemicals, petroleum products, liquefied gases or fresh water, de-activating solutions, etc.;
- hull structures;
- ballast, cooling, sounding, fire fighting and other systems and pipes;
- machinery products.

For stainless steel products having contact with sea water electromechanical protection shall be used.

The Subsection includes the requirements for stainless steel rolled

plates and bars, forgings and pipes of martensite (M), martensite + ferrite (MF), ferrite (F), austenite + martensite (AM), austenite (A) and austenite + ferrite (AF) classes.

The assumed classification of stainless steel depending on its chemical composition and structure is given in Table 3.16.1.1.

Steel designations are based on the designations used in international standards.

Designations of national marks are given in accordance with the national standards.

Corrosion resistant steel used as an alternative means of providing corrosion protection (protective coatings) of cargo tanks of oil tankers specified in 1.2.5.3, Part II “Hull” shall meet the requirements of resolution MSC.289(87).

**3.16.1.2** Corrosion resistant steel shall be produced under supervision of the Register by manufacturers recognized in accordance with 1.3.1.4.

Materials meeting the Register requirements shall be supplied with the Register Certificates.

Manufacturer Certificates for ingots and blanks with indication of the manufacturer, steel grade, heat number, chemical composition and documentation, in compliance with which ingots/blanks were manufactured, shall be submitted to the Surveyor to the Register who carries out the survey at the manufacturer’s where there are no melting processes.

The ingot/blanks manufacturer shall be recognized by the Register.

**3.16.1.3** The use of stainless steel not meeting the requirements for chemical composition, mechanical properties

and/or condition of supply is subject to special consideration by the Register in each particular case, including the detailed study of steel properties under conditions, for which the steel is intended.

**3.16.1.4** Tests of stainless steel for susceptibility to intergranular, through, crevice and pitting corrosion as well as metallography examination,  $\alpha$ -phase determination, etc. shall be carried out according to the procedures given in the standards recognized by the Register.

**3.16.1.5** Chemical composition and mechanical properties.

Chemical composition and mechanical properties of semi-finished products of stainless steel, as well as steel resistance to environmental effects shall

meet the requirements of this Part of the Rules and also the requirements of national and international standards or other special documents recognized by the Register.

The chemical composition of stainless steel to be determined for each heat shall meet the requirements of Tables 3.16.1.5-1 and 3.16.1.5-2.

Where necessary, samples may be taken, on the Register request, directly from a semi-finished product (plate, forging, etc.).

The requirements for mechanical properties of semi-finished products depending on their type are given in Tables 3.16.2.2-1, 3.16.3.2-1, 3.16.3.2-2 and 3.16.4.2.

**Table 3.16.1.1 The assumed classification of stainless steel depending on its chemical composition and structure**

Steel class	Steel designation	Steel grade		Temperature range for application, °C
		AISI/UNS	National	
M-1	X20Cr13	410	20X13	-20...+450
		420	30X13	
	X7CrNiNb16 4	–	07X16H4B	-60...+350
MF-2	X15CrNi17	431	14X17H2	-20...+350
F-3	X8CrTi17	430Ti	08X17T	0...+600
AM-4	X8CrNiTi17 6	–	08X17H6T	-60...+250
A-5	X10CrNiTi18 10	321, 347	08X18H10T	-165...+600
			12X18H10T	
A-6	X2CrNi19 11	304L, 304LN	–	-165...+600
	X10CrNiMo17 13 2	316L, 316LN	03X17H14M3	-165...+600
	X2CrNiMo18 13 3	317L, 317LN	–	-165...+600
A-7	X10CrNiMoTi17 13 3	–	10X17H13M3T	-165...+600
	X2CrNiMoCu20 18 6	S31254	–	-165...+600
	X2CrNiMoCu21 23 4 2	N08904	–	-165...+600
AF-8	X2CrNiMo22 5 3	S31803	03X22H6M2	-40...+250
	X3CrNiMo25 6 3	S31260	–	-40...+250
	X4CrNiVo25 5 3	S32550	–	-40...+250
	X2CrNiMo25 7 4	S32750	–	-40...+250
	X3CrNiMo25 7 3	S32760	–	-40...+250

X10CrNiTi22 6	–	08X22H6T	–40... +250
X10CrNiMo21 6 2	–	08X21H6M2T	–40... +250

### 3.16.1.6 Condition of supply.

All semi-finished products shall be supplied in heat-treated condition.

Heat treatment procedures are specified in accordance with standards recognized by the Register or other normative documents.

Where heat treatment conditions are not indicated in the standards, such conditions shall be specified by the manufacturer.

Steel plates and flats of 4 mm in thickness and less may be supplied in

semi-cold-worked or cold-worked condition.

Type or procedure of heat treatment shall be indicated in the Certificate for semi-finished product.

### 3.16.1.7 Sampling.

Samples are taken from a semi-finished product.

For forgings separately forged samples prepared from the metal of the same heat and with the same degree of deformation as the semi-finished product submitted for the tests may be used.

Table 3.16.1.5-1 Chemical composition of stainless steel

Steel class and grade	Content of elements, %									
	C, max	Si	Mn	P	S	Cr	Ni	Mo	N	Other
Martensite										
410	0.12	1.0	1.0	0.045	0.03	12.0-14.0	–	–	–	–
420	0.17	1.0	1.0	0.045	0.03	12.0-14.0	–	–	–	–
Martensite-ferrite										
431	0.23	1.0	1.0	0.045	0.03	16.0-18.0	1.5-2.5	–	–	–
Ferrite										
431Ti	0.1	1.0	1.0	0.045	0.03	16.0-18.0	–	–	–	TixC
Austenite										
304L	0.03	1.0	2.0	0.045	0.03	17.0-20.0	8.0-13.0	–	0.10	–
304LN	0.03	1.0	2.0	0.045	0.03	17.0-20.0	8.0-12.0	–	0.10-0.22	–
316L	0.03	1.0	2.0	0.045	0.03	16.0-18.5	10.0-15.0	2.0-3.0	0.10	–
316LN	0.03	1.0	2.0	0.045	0.03	16.0-18.5	10.0-14.5	2.0-3.0	0.10-0.22	–
317L	0.03	1.0	2.0	0.045	0.03	18.0-20.0	11.0-15.0	3.0-4.0	0.10	–
317LN	0.03	1.0	2.0	0.045	0.03	18.0-20.0	12.5-15.0	3.0-4.0	0.10-0.22	–
321	0.08	1.0	2.0	0.045	0.03	17.0-19.0	9.0-12.0	–	0.10	Ti ≥ 5xC ≤ 0.70
347	0.08	1.0	2.0	0.045	0.03	17.0-19.0	9.0-13.0	–	0.10	Nb ≥ 10xC ≤ 1.0
UNS S31254	0.02	0.8	1.0	0.03	0.01	19.5-20.5	17.5-18.5	6.0-6.5	0.18-0.22	Cu 0.50-1.0
UNS N08904	0.02	1.0	2.0	0.04	0.02	19.0-23.0	23.0-28.0	4.0-5.0	0.15	Cu 1.00-2.0

Austenite- ferrite (Duplex)											
UNS S31260	0.03	0.75	1.0	0.03	0.03	24.0-26.0	5.5-7.5	2.5-3.5	0.10-0.30	Cu 0.2-0.8 W 0.1-0.5	
UNS S31803	0.03	1.0	2.0	0.03	0.02	21.0-23.0	4.5-6.5	2.5-3.5	0.08-0.20	–	
UNS S32550	0.04	1.0	1.5	0.04	0.03	24.0-27.0	4.5-6.5	2.0-4.0 <sup>1</sup>	0.10-0.25	Cu 1.5-2.5	
UNS S32750	0.03	0.8	1.2	0.035	0.02	24.0-26.0	6.0-8.0	3.0-5.0	0.24-0.32	Cu 0.50, max	
UNS S32760	0.03 <sub>2</sub>	1.0	1.0	0.03	0.01	24.0-26.0	6.0-8.0	3.0-4.0	0.20-0.30	Cu 0.50-1.0 W 0.50-1.0	

<sup>1</sup> For pipes content of Mo is taken equal to 2.90 to 3.90.

<sup>2</sup> For pipes content of C ≤ 0.05.

**Table 3.16.1.5-2 Chemical composition of stainless steel (national steels)**

Class and grade of steel	Content of elements, %								
	C	Si, max	Mn, max	Cr	Ni	Ti	Mo	S, max	P, max
Martensite									
20X13	0.16-0.25	0.8	0.8	12.0-14.0	–	–	–	0.025	0.030
30X13	0.26-0.35	0.8	0.8	12.0-14.0	–	–	–	0.025	0.030
07X16H4B	0.05-0.10	0.6	0.2-0.5	14.0-16.5	3.5-4.5	Nb 0.2- 0.4	–	0.020	0.025
Martensite- ferrite									
14X17H2	0.11-0.17	0.8	0.8	16.0-18.0	1.5-2.5	–	–	0.025	0.030
Ferrite									
08X17T	Max 0.08	0.8	0.8	16.0-18.0	–	5xC-0.8	–	0.025	0.030
Austenite- martensite									
08X17H6T	Max 0.08	0.8	0.8	16.5-18.0	5.5-6.5	0.15- 0.35	–	0.020	0.035
Austenite									
08X18H10T	Max 0.08	0.8	2.0	17.0-19.0	9.0-11.0	5C-0.7	–	0.020	0.035
12X18H10T	Max 0.12	0.8	2.0	17.0-19.0	9.0-11.0	5C-0.8	–	0.020	0.035
10X17H13M3 T	Max 0.10	0.8	2.0	16.0-18.0	12.0-14.0	5C-0.7	3.0-4.0	0.020	0.035
03X17H14M3	Max 0.03	Max 0.4	1.0-2.0	16.8-18.3	13.5-15.0	–	2.2-2.8	0.020	0.030
Austenite- ferrite									
08X22H6T	Max 0.08	0.8	0.8	21.0-23.0	5.3-6.3	5C-0.65	–	0.025	0.035
08X21H6M2T	Max 0.08	0.8	0.8	20.0-22.0	5.5-6.5	0.20- 0.40	1.8-2.5	0.025	0.035
03X22H6M2	Max 0.03	Max 0.4	1.0-2.0	21.0-23.0	5.5-6.5	–	1.8-2.5	0.020	0.035

In such case, dimensions of the sample in terms of their thickness and diameter may vary from the maximum dimensions of the forging itself by not more than 25 %.

Samples for preparation of specimens shall be cut out upon completion of all types of heat treatment.

Separately forged samples shall be subjected to all types of process heating and heat treatment in one charge with the forging submitted for the tests.

The dimensions of samples shall provide performance of the required and possible retests.

Unless expressly provided otherwise, samples shall be taken as follows:

rolled stock — in accordance with 3.2.5. Samples for impact tests shall be cut in such a manner that the lengthwise axis of specimens is transverse to the last direction of rolling. For steel sections and bars lengthwise specimens may be used. For a semi-finished product having a size (diameter, square side, diameter of inscribed circle) under 40 mm the specimen axis shall coincide with the axis of the semi-finished product;

forgings — in accordance with 3.7.5.1, sample being taken from the feed head of the ingot. On agreement with the Register samples may be taken at a distance of  $\frac{1}{3}$  of the radius or  $\frac{1}{6}$  of the diagonal from the outer surface of the forging or from the centre of the forging;

pipes — in accordance with 3.4.5 and 3.4.6.

Samples for intergranular corrosion tests shall be taken similarly to those for tensile tests.

In any case, schemes of taking samples and cutting out specimens shall

be indicated on the sketch and approved by the surveyor to the Register.

### **3.16.1.8 Scope of tests.**

**3.16.1.8.1** Types of tests, to which stainless steel can be subjected during manufacture, are given in Table 3.16.1.8.1. Tests, to which stainless steel supplied under the Register technical supervision shall be subjected, are marked with “+”.

As a rule, semi-finished products of stainless steel are submitted for tests in batches or individually.

A batch shall consist of semi-finished products of the same steel grade, the same heat, the same condition of supply, one shape (type) and size and made using the same production process.

Forgings of one batch shall be made according to the sketch and heat-treated in one charge.

Pipes included in the batch shall have the same wall thickness.

Steel plates and forgings intended for use at temperatures below zero shall be submitted for tests individually.

Sizes of batches, number and procedure of taking samples for steel plates, sheet steel and bars are given in 3.16.2.3, for forgings — in 3.16.3.3, for pipes — in 3.16.4.3.

**3.16.1.8.2** Tests for the recognizing an enterprise as a manufacturer of stainless steel in accordance with 3.16.1.2 shall be carried out under Register-approved program and, generally, shall include:

chemical analysis;  
determination of mechanical properties ( $R_m$ ,  $R_{p0.2}$ ,  $A_5$ ,  $Z$ ) at 20 °C and design temperature;

determination or confirmation of the

critical brittleness temperature (except for austenite type steels);

metallography examination and macro-structure examination to detect shrinkage cavities, bubbles, non-metallic inclusions, grain size;

tests for susceptibility to intergranular, through, crevice, pitting

corrosion;

determination of  $\alpha$ -phase amount (for austenite type steels);

process tests (ring expanding, flattening, bending, etc.) and plasticity assessment in case of cold stamping.

**Table 3.16.1.8.1 Types of tests for stainless semi-finished products**

Characteristic to be determined	Steel class							
	M-1	MF-2	F-3	AM-4	A-5	A-6	A-7	AF-8
Mechanical properties at 20 °C:								
tensile strength, $R_m$	+	+	+	+	+	+	+	+
yield stress, $R_{p0.2}$	+	+	+	+	+	+	+	+
elongation, $A_5$	+	+	+	+	+	+	+	+
reduction in area, $Z$	+	+	+	+	+	+	+	+
Same at operating temperature	+ <sup>1</sup>							
Impact toughness at +20 °C, $KCV^{+20^\circ}$	+	+	+	+	-	-	-	+
Impact toughness at temperature below zero $KCV$	+ <sup>1</sup>	+ <sup>1</sup>	-	+ <sup>1</sup>				
Impact toughness at temperature below zero, $KV$	-	-	-	-	+ <sup>1</sup>	+ <sup>1</sup>	+ <sup>1</sup>	+
Resistance to intergranular corrosion	+ <sup>2</sup>	+	+	+	+	+	+	+
Macro-structure examination	+	+	+	+	+	+	+	+
$\alpha$ -phase examination	-	-	-	-	+ <sup>1</sup>	+ <sup>1</sup>	+ <sup>1</sup>	-
Grain size control	-	-	+	+ <sup>1</sup>				
Production testing	+ <sup>1</sup>							
Non-destructive testing	+	+	+	+	+	+	+	+
Examination of non-metallic inclusions	+ <sup>1</sup>							
Determination or confirmation of brittleness critical temperature	+ <sup>1</sup>	+ <sup>1</sup>	+ <sup>1</sup>	+ <sup>1</sup>	-	-	-	-

<sup>1</sup> Upon request of the Register.

<sup>2</sup> For 07X16H4B steel only

**3.16.1.8.3** Testing procedures, types and dimensions of specimens shall comply with the requirements of Section 2 of the present Part or national and international standards recognized by the Register.

Retests aiming to check mechanical properties shall be carried out in accordance with 1.3.5.2. During retests those characteristics shall be determined, for which negative results were obtained.

In case of negative results of intergranular corrosion tests and retests for determination of mechanical properties obtained even for one specimen, the blanks shall be subjected to repeated heat treatment and submitted for tests as new ones.

Not more than three complete heat treatments are allowed.

**3.16.1.9 Marking and documentation.**

Identification, marking and issued documentation — in accordance with the requirements of 1.4.

Every semi-finished product of stainless steel shall have the Register stamp.

### 3.16.2 Rolled products.

**3.16.2.1** These requirements apply to stainless steel plates, flats and sections with a thickness up to 50 mm as well as to hot-rolled and forged steel of round, square or rectangular section with a diameter or thickness up to 200 mm.

**3.16.2.2** Mechanical properties of steel at 20 °C shall not be worse than given in Table 3.16.2.2.

In determining mechanical properties of rolled products using transverse specimens, the requirements may be reduced in accordance with the provisions of national or international standards.

**Table 3.16.2.2 Mechanical properties of rolled products made of stainless steel**

Steel grade	Tensile strength $R_m$ , MPa, min	Yield stress $R_{p0.2}$ , MPa, min	Elongation $A_5$ , %, min
M-1	650	440	16
	850	735	13
MF-2	690	540	12
F-3	440	—	18
A-5	440	175	45
	490	195	35
A-6	440	185	40
	510	200	35
A-7	650	300	35
AF-8	580	340	20
	650	450	25
	760	550	15

### 3.16.2.3 Scope of tests.

The number of samples and batch

size for rolled products shall be determined in the following way:

for steel plates and wide flats ( $\geq 600$  mm) more than 20 mm in thickness, more than 10 m long and more than 5 t in mass samples are taken from both ends of each rolled product. In other cases, a sample is taken from one end of the rolled product;

for steel plates and wide flats ( $\geq 600$  mm) less than 20 mm in thickness, samples are taken from one end of the plate of the batch containing not more than 20 plates;

for rolled steel, samples are taken from both ends of each roll;

for steel plates and sections, samples are taken from one end of one semi-finished product of the batch containing not more than 50 pieces, having a mass not more than 5 t.

On agreement with the Register plates that vary in thickness by not more than 5 mm may be combined in one batch.

As a rule, the following specimens shall be prepared from each sample of steel plates, wide flats and bars:

one specimen for tensile test;

two specimens for impact toughness test;

one set of specimens (at least two pieces) for austenite steels, two sets of specimens (at least four pieces) for austenite — ferrite and austenite — martensite steels, one of which is a check specimen, for intergranular corrosion tests;

at least one template for macro-structure examination.

### 3.16.2.4 Inspection.

All the plates and rods of the batch shall undergo surface inspection and verification of dimensions. Rolled

products shall not have any defects preventing them from use for intended applications. The absence of defects shall be the manufacturer's responsibility and may be proved by non-destructive testing.

Non-destructive testing shall be performed according to national standards.

Surface imperfections resulted from the manufacturing process used are permitted, provided they are within permissible limits, counting from the nominal thickness.

Defective areas may be welded in cases where the depth of the chipped areas after rectifying defects does not exceed 20 % of the nominal thickness of the billet, and the total chipped area does not exceed 2 % of the total area of the billet. Where projections of welded areas coincide in thickness on both sides of the blank, the permissible chipped areas shall not exceed in total the depth permissible on one side the billet.

Welding, examination of welded areas and heat treatment (if necessary) shall be performed according to the manufacturer's documentation agreed with the surveyor to the Register with the following marking of welded areas in the Certificate.

### 3.16.3 Forgings.

**3.16.3.1** These requirements apply to semi-finished products manufactured by forging and hot stamping.

**3.16.3.2** Mechanical properties of forgings and stampings, to which intergranular corrosion requirements apply, shall not be lower than that given in Table 3.16.3.2-1.

Mechanical properties of forgings and stampings, to which intergranular corrosion requirements do not apply, shall

meet the requirements given in Table 3.16.3.2-2.

**Table 3.16.3.2-1 Mechanical properties of forgings and stampings, to which intergranular corrosion requirements apply**

Steel grade	Tensile strength $R_m$ , MPa, min	Yield stress $R_{p0.2}$ , MPa, min	Elongation $A_5$ , %, min
M-1	880	690	12
MF-2	690	540	12
AM-4	730	540	12
A-5	490	190	38
A-6	510	210	38
AF-8	590	340	17

**Table 3.16.3.2-2 Mechanical properties of stainless steel forgings and stampings, to which intergranular corrosion requirements do not apply**

Steel grade	Tensile strength $R_m$ , MPa, min	Yield stress $R_{p0.2}$ , MPa, min	Elongation $A_5$ , %, min
M-1	650	440	13
MF-2	690	540	12
AM-4	730	630	10
	880	730	12

In these tables mechanical properties determined on lengthwise specimens are given for semi-finished products, the diameter (thickness) of which does not exceed 300 mm.

Mechanical properties of bigger forgings are subject to special consideration by the Register.

In determining mechanical properties of forgings using transverse, radial or tangential specimens the requirements for mechanical properties may be reduced in accordance with provisions of national and international standards or by values

given in Table 3.16.3.2-3.

**Table 3.16.3.2-3 Permissible reduction of mechanical properties when using transverse, radial and tangential specimens, in %**

Mechanical property	Type of specimen			
	Crosswise	Radial	Tangential for blanks with diameter (thickness), mm	
			≤ 300	> 300
Yield stress $R_{p0.2}$ , MPa	10	10	5.0	5.0
Tensile strength $R_m$ , MPa	10	10	5.0	5.0
Elongation $A_5$ , %	50	35	25	30
Reduction in area $Z$ , %	50	40	25	30
Impact toughness $KCU$ , J/cm <sup>2</sup>	50	40	25	30

Notes: 1. For forgings of “ring” type with a diameter more than 1,000 mm produced by drawing, the requirements for mechanical properties obtained in testing tangential specimens are based on the requirements for lengthwise specimens.

2. In any case impact toughness shall not be less than 30 J/cm<sup>2</sup> and elongation shall not be less than 9 %.

### 3.16.3.3 Scope of tests.

The number of samples and batch size of stainless steel forgings and stampings shall be determined as follows:

for forgings and stampings of 20 kg in mass or less — from one semi-finished product of the batch consisting of not more than 30 pieces. Samples are taken from one end of the semi-finished product;

for forgings and stampings having a mass from 20 to 1,000 kg — from one

semi-finished product of the batch consisting of not more than 10 pieces. Samples are taken from one end of the semi-finished product;

for forgings and stampings of more than 1,000 kg in mass — from each forging. Where a length is 3 m and more, from both ends of each forging.

On agreement with the Register forgings made according to different drawings but close in shape and varying in section by not more than 25 % may be combined in one batch.

As a rule, the following specimens shall be prepared from each sample:

one specimen for tensile test;

two specimens for impact toughness

test;

for intergranular corrosion test —

four specimens, two of which are check specimens;

for macro-structure control — at least one specimen.

### 3.16.3.4 Inspection.

All forgings and stampings of the batch are subject to inspection of a surface and dimensions. Absence of inadmissible defects shall be guaranteed by the manufacturer and may be proved by non-destructive testing, if specified by order specification or on the Register request.

Welding of defects is subject to special consideration by the Register in each particular case and is generally restricted to the rectification of the defects of minor nature and in areas of low working stresses. The repairing technique and testing procedure are subject to the Register approval.

After welding the location of all repairs and the results of inspection shall be shown in the drawing or sketch of the forging and annexed to the Certificate.

**3.16.4 Pipes.**

**3.16.4.1** These requirements apply to hot- and cold-formed pipes of stainless steel.

**3.16.4.2** Mechanical properties of pipes shall not be lower than that given in Table 3.16.4.2.

**3.16.4.3** Scope of tests.

The size of the batch shall be determined as follows:

where the outside diameter is 76 mm and less — 300 pcs.,

where the outside diameter is over 76 mm — 200 pcs.

Samples are taken from one end of at least two pipes of the batch.

Unless expressly specified otherwise by the Register or standards, the following specimens shall be taken from each sample:

for tensile test — 1 specimen;

for flattening or expansion of rings — 1 specimen;

for flaring — 1 specimen;

for intergranular corrosion test of pipes made of austenite steel — 1 set of specimens (at least 2 pieces); for pipes of austenite + ferrite class — 2 sets of specimens (at least 4 pieces), one of which is a check set;

each pipe shall be subjected to a hydraulic pressure test and ultrasonic testing.

**Table 3.16.4.2 Mechanical properties of pipes**

Steel grade	Tensile strength $R_m$ , MPa, min	Yield stress $R_{p0.2}$ , MPa, min	Elongation $A_5$ , %, min
A-5	490	175	30
	549	186	35
A-6	490	185	30

AF-8	529	216	30
	580	200	20
	690	450	25
	760	550	15
	800	550	25

**3.16.4.4** Inspection.

All pipes and tubes shall undergo external and internal examination of the surface. Absence of inadmissible defects shall be guaranteed by the manufacturer and proved by non-destructive testing.

**3.17 CLAD STEEL**

**3.16.1** General.

**3.17.1.1** The present requirements cover steel plates of low-alloy metal coated with a thin layer of stainless steel on one or both sides and intended for tanks and vessels being subject to the Register technical supervision, as well as for ice strakes of icebreakers, ice ships, mobile offshore drilling units and fixed offshore platforms.

**3.17.1.2** Clad steel shall be manufactured under the Register supervision by the manufacturers recognized in compliance with the requirements of 1.3.1.4.

The Register representative carrying out the technical supervision at the manufacturer's of clad steel plates, which has no foundry for all the ingredients of clad steel, shall be provided with the certificates of the billets manufacturer.

The surveyor may demand surveying and recognizing the suppliers of billets for clad steel manufacturing.

**3.17.1.3** Hull structural rolled products of B to F Grades with a yield stress from 235 MPa to 690 MPa shall be used as base material of clad steel in accordance with the requirements of 3.2, 3.5, 3.13 and 3.14.

The steel shall be selected in compliance with the structure function (refer to 1.2, Part II “Hull” of the present Rules and 1.5, Part II “Hull” of the Rules for the Classification, Construction and Equipment of MODU/FOP) reasoning from the design service temperature of the material  $T_P$ , the function of a structural member (special or primary), the base material thickness, requirements for Z-properties and loading conditions.

In cases not specified in Table 1.5.1.2, Part II “Hull” of the Rules for the Classification, Construction and Equipment of MODU/FOP the selection of the base material steel grade shall meet the requirements of 3.17.4.1.9 and 3.17.4.1.11, 3.2 and 3.5 of the present Part, as well as the requirements of 3.2, Part XII “Materials” of the Rules for the Classification, Construction and Equipment of MODU/FOP. The base metal shall be over 10 mm thick.

Austenite or austenite-ferrite stainless steels (classes A and AF) having a chemical composition and properties meeting the requirements of 3.16 shall be used as the cladding metal.

The use of other classes of corrosion-resistant materials as the cladding metal shall be agreed with the Register. The nominal thickness of the cladding metal shall be not less than 2 mm.

The cladding metal shall be chosen taking into account the specific operational conditions on agreement with the Register.

**3.17.1.4** Hot (pack) rolling, explosion welding, overlay rolling or a combination thereof may be used for plate cladding.

**3.17.2 Chemical composition and mechanical properties.**

**3.17.2.1 The chemical composition and mechanical properties** of the base metal shall meet the requirements of 3.2, 3.5, 3.13 and 3.14.

Unless otherwise specified, sampling and the base metal testing shall be carried out in accordance with the requirements of the above subsections.

**3.17.2.2 The chemical composition and mechanical properties of the cladding metal** shall meet the requirements of 3.16.

**3.17.2.3** The use of clad steel for specific operational conditions shall be agreed in each particular case.

**3.17.3 Condition of supply.**

**3.17.3.1** Plates with stainless steel cladding shall be supplied in as-rolled condition and may be heat-treated to ensure the properties of the base metal. In this case the corrosion resistance of the cladding metal after heat treatment shall meet the requirements of 3.16.

The type of heat treatment shall meet the requirements of standards and shall be approved by the Register at the initial survey of the manufacturer.

**3.17.4 Scope of testing.**

**3.17.4.1** The scope of testing at the initial survey shall be determined by the Register-approved programme.

The following types of tests may additionally be carried out:

tensile test on the full thickness clad plate test specimen;

bend test on the clad test specimens;

shear test on the cladding metal;

resistance of the cladding metal against intergranular corrosion;

test for determining the base material Z-properties;

test for determining the base material cold resistance.

**3.17.4.1.1** Strength in tensile test on the full thickness clad plates.

The tensile test on the full thickness clad plate test specimens shall be performed for determining the tensile strength and yield stress of clad steel. With the total thickness of less than 20 mm the clad plate in tensile test shall meet the following requirement:

$$R \geq \frac{R_o t_o + R_n t_n}{t}$$

(3.17.4.1.1)

where  $R$  is nominal value of tensile strength or yield stress of clad steel plate, MPa;

$R_o$ ,  $R_n$  are nominal values of tensile strength  $R_m$  or yield stress  $R_{02}$  ( $\sigma_m$ ,  $\sigma_{0.2}$ ) for the base metal (o) and clad metal(n), MPa;

$t_o$ ,  $t_n$  are nominal thickness, in mm, of the base metal (o) and clad metal (n), respectively;

$t$  is nominal thickness of clad steel plate, in mm.

**3.17.4.1.2** Determination of plybond strength.

The bend test on the clad test specimens shall be performed for the qualitative assessment of bond resistance of the base material and cladding metal. No separations of the cladding in bending shall be a performance criterion.

Three test specimens shall be taken from each plate end for bend test.

One bend test shall be carried out with the cladding metal on the tensioned side and another with the cladding layer on the compressed side.

The third test specimen shall be subject to transverse bending with the cladding vertically oriented.

The procedure for test specimens' preparation and test performance shall comply with the manufacturer's documentation, national or international standards.

**3.17.4.1.3** Shear test on the cladding metal.

Two test specimens shall be taken from each plate end for shear testing. The specimen axis shall be transverse to the rolling direction.

The test shall be performed according to the requirements of the national standard, ASTM 264 or DIN 50162.

The shear strength shall be at least 140 MPa.

**3.17.4.1.4** Testing the cladding layer for resistance against intergranular corrosion.

The cladding metal shall be resistant to intergranular corrosion.

The corrosion resistance tests for clad steel shall be carried out in compliance with a national or international standard.

In any case the test procedure shall be preliminary agreed with the Register.

The resistance against intergranular corrosion shall be checked for each metal heat used for cladding.

**3.17.4.1.5** Z-properties.

Z-properties shall be determined in clad steel with the base material 20 to 100 mm thick and a yield stress of up to 690 MPa inclusive.

Prior to test specimen preparation for determining the Z-properties, the cladding metal shall be completely removed.

The Z-properties criterion is the value of the reduction in cross-sectional area in testing a cylindrical test specimen for axial tension to failure. The specimen shall be cut out so that its lengthwise axis is perpendicular to the plate plane and its centre is the centre of the base metal thickness.

Note:

Selecting the test specimen standard size, two key factors shall be considered:

parallel length diameter  $d$ ;  
repetition factor  $l/d$  or the ratio of working part length  $l$  to working part diameter  $d$ .

Minimum value  $d_{\min} = 4$  mm.

Minimum value of  $l_{\min} = 1.5 d$ .

The use of  $d_{\min}$  and  $l_{\min}$  allows to prepare a solid specimen of  $d = 4$  mm without welded parts for gripping, with metal thickness of 18 to 27 mm.

The solid specimen of  $d = 6$  mm may be used for metal with thickness of 27 to 45 mm, and the one of  $d = 10$  mm — for metal with thickness of more than 45 mm.

For MODU and FOP special purpose structures the average value of the relative reduction of area  $Z_z$  of three test specimens taken from each plate in the through base material thickness direction of a clad plate shall comprise at least 35 % with one test result allowed below 35 %, but not less than 25 %.

For MODU and FOP primary structures the average value of the reduction in area  $Z_z$  of three tested specimens shall comprise at least 25 % with one test result allowed below 25 %, but not less than 15 %.

Z-steel for the clad steel base material shall comply with the requirements of 3.14 for Z35 and Z25 grade steels.

The procedure for determining the clad steel plybond strength shall be approved by the Register.

If the value  $Z_z$  obtained is below the specified minimum value or if one individual test result is less than the specified one, additional tests on three new test specimens shall be carried out.

The average of the results of the six tests shall not be less than the specified value. No individual result from the three new series shall be less than the specified minimum value.

**3.17.4.1.6** The crack resistance of the base material shall be defined in tests for determining the following parameters:

**.1** ductile-brittle transition temperature DBTT;

**.2** nil-ductility temperature NDT.

The above temperatures shall be determined in accordance with Section 2, Part XII “Materials” of the Rules for the Classification, Construction and Equipment of MODU/FOP.

**3.17.4.1.7** Tests for determining temperature DBTT.

The temperature DBTT is the temperature of a ductile-brittle transition and is defined by a 70 % fibrous component in the fracture of a full thickness test specimen.

The tests performed for determining DBTT allow to evaluate the temperature of brittle crack stopping  $T_{br}$  in a full thickness metal (from 14 to 100 mm thick) provided that:

$$T_{br} \geq 0,9T_{kb} - 10 \text{ } ^\circ\text{C}.$$

Test specimens for determining the DBTT value for clad steel shall be prepared from the full thickness base material after the removal of cladding and the part of the base material no more than 0.5 mm thick on the cladding side.

The procedure for tests performance shall be agreed with the Register.

Samples for test specimen preparation for determining DBTT shall be taken in areas which are the nearest to the areas of sampling for determining mechanical properties of the base metal.

The test specimen thickness shall correspond to the base material thickness after the removal of cladding with other

dimensions being in the optimum relationship with thickness:

specimen height  $W = 3\delta \pm 3$  mm;

length  $L = 4W + \delta = 13\delta \pm 10$  mm;

notch depth

$\alpha = \frac{1}{3}W = \delta \pm 1$  mm;

distance between supports at three-

point bending

$l = 4W = 12\delta \pm 10$  mm;

notch radius:

$R = 3^{+0.5}$  mm with metal thickness of up to 32 mm,

$R = 3^{+2}$  mm with metal thickness of more than 32 mm;

notch width is a technological quantity if the notch is made with gas cutting.

The value of the temperature DBTT obtained shall be confirmed by testing of three test specimens. If the fracture contains  $70 \pm 5$  % of the fibrous component in two of three cases, the given temperature is assumed as DBTT.

**3.17.4.1.8** Drop weight test for determining nil-ductility temperature NDT.

The NDT is the temperature at which standard test specimens with a brittle notched weld deposit fail in an impact test.

The specimen deflection in testing shall be bounded with a stop and be in compliance with ASTM E208.

The test specimens for determining the clad steel NDT shall be prepared from the base metal. In this case the tensioned surface of the specimen shall coincide with the base material surface, which is opposite to the cladding, and shall remain in the initial condition.

The procedure for specimens preparation, specimen types, equipment, jigs and fixtures, instrumentation and correctness conditions for the NDT values

obtained shall meet the requirements of 2.3, Part XII "Materials" of the Rules for the Classification, Construction and Equipment of MODU/FOP.

The procedure for drop weight test for determining NDT shall be agreed with the Register.

**3.17.4.1.9** Requirements for clad steel base metal for temperatures DBTT and NDT.

For the special members of ice strake structures directly exposed to dynamic ice or seismic loads of which the material shall effectively stop a brittle crack at the design service temperature  $T_d$ , the conditions below shall be observed:

for DBTT:

$DBTT \leq 1.1T_d + 10$  °C with metal thickness of 14 to 100 mm;

for NDT:

$NDT \leq T_d$  for thickness  $t \leq 15$  mm;

$NDT \leq T_d - 10$  °C for  $15 < t \leq 20$  mm;

$NDT \leq T_d - 20$  °C for  $20 < t \leq 30$  mm;

$NDT \leq T_d - 25$  °C for  $30 < t \leq 40$  mm.

**3.17.4.1.10** For the special members of ice strake structures not covered by the requirements of 3.17.4.1.9 and for the primary members exposed to cyclic ice loads, wind-wave and seismic loads, the condition below shall only be observed for NDT:

$NDT \leq T_d$  for thickness  $t \leq 15$  mm;

$NDT \leq T_d - 10$  °C for  $15 < t \leq 20$  mm.

**3.17.4.1.11** Steels with requirements for crack resistance properties.

The clad steel for structures used at low environmental temperatures of down to  $-50$  °C may, on the Register demand, be tested for determining a crack resistance parameter CTOD being the critical value of a crack opening displacement, in mm, and associated with

a certain kind of crack extension at static loading.

The test for determining the CTOD shall be performed on the test specimens cut from the base metal after the removal of cladding and the part of the base metal not more than 0.5 mm thick.

The CTOD test shall be carried out according to the procedure agreed with the Register according to the requirements of

2.2, Part XII “Materials” of the Rules for the Classification, Construction and Equipment of MODU/FOP or of international standards, e.g. BS7448, Part 2.

The requirements for the CTOD values for clad steel base metal for special and primary structures shall not be lower than those in Tables 3.17.4.1.11-1 and 3.17.4.1.11-2.

**Table 3.17.4.1.11-1 CTOD values for clad steel base metal depending on steel thickness and strength level for main structural elements**

Thickness, mm, max	Strength level (min yield stress required, MPa)									
	*	315	355	390	420	460	500	550	620	690
20	0.08	0.08	0.10	0.10	0.10	0.10	0.15	0.15	0.15	0.20
30	0.08	0.10	0.15	0.15	0.15	0.20	0.20	0.20	0.25	0.25
40	0.15	0.15	0.20	0.20	0.20	0.25	0.25	0.30	0.35	0.35
50	0.20	0.20	0.20	0.25	0.25	0.30	0.30	0.35	0.40	0.45

\* Normal strength level steel.

**Table 3.17.4.1.11-2 CTOD values for clad steel base metal depending on steel thickness and strength level for main structural elements and heat-affected zone base metal of special structural elements**

Thickness, mm, max	Strength level (min yield stress required, MPa)									
	*	315	355	390	420	460	500	550	620	690
20	0.08	0.08	0.08	0.08	0.10	0.10	0.10	0.10	0.10	0.15
30	0.08	0.10	0.10	0.10	0.10	0.10	0.15	0.15	0.20	0.20
40	0.10	0.10	0.10	0.15	0.15	0.15	0.20	0.20	0.20	0.25
50	0.10	0.15	0.15	0.20	0.20	0.20	0.20	0.25	0.25	0.30

\* Normal strength level steel.

**3.17.4.1.12** Additional tests of welded joints for ice strake structures.

**3.17.4.1.12.1** The requirements cover welded joints of the ice strake members of MODU and FOP special and primary structures made of clad steel and intended for operation at low temperatures and exposed to dynamic and seismic loads.

**3.17.4.1.12.2** Welded joints of clad steel shall be made and checked in compliance with the general requirements of 1.3, Part XIV “Welding” of the present Rules, as well as Section 1 and

Subsection 2.1 to 2.5, 2.6.1.4 and 2.9.3, Part XIII “Welding” of the Rules for the Classification, Construction and Equipment of MODU/FOP.

The ice strake structures of clad steel shall be welded with the use of the Register-approved welding consumables produced at the Register-recognized manufacturers.

The welding consumables for the base material shall meet the requirements of 4.1, 4.2, 4.5 and 4.6, and for the

cladding metal, the requirements of 4.8, Part XIV “Welding” of the present Rules.

**3.17.4.1.12.3** The welded joints of clad steel, which comply with 3.17.4.1.12.1 and 3.17.4.1.12.2, may, on the Register demand, be additionally tested for determining the crack resistance parameter CTOD and the resistance against intergranular corrosion.

**3.17.4.1.12.4** Samples for preparing test specimens for CTOD tests shall be taken from the welded butt joints of clad steel. For this purpose, the cladding metal, including the one deposited on the weld, shall be removed after welding.

In order to determine the crack resistance of the heat-affected zone (HAZ), the bevel welding (double-bevel or single-bevel groove) is recommended which allows to arrange a crack front in the proper layer of the HAZ.

The welding procedure shall be approved by the Register.

The CTOD tests of the test specimens prepared in this way shall be carried out in compliance with the requirements of 2.2, Part XII “Materials” of the Rules for the Classification, Construction and Equipment of MODU/FOP.

**3.17.4.1.12.5** The requirements for the CTOD values of the heat-affected zone metal for special structural elements depending on the thickness and strength level of the clad steel base metal shall be not less than those in Table 3.17.4.1.10-2.

Note: On agreement with the Register, the tests of clad steel welded joints for determining the crack resistance parameter CTOD to the extent of the requirements of 3.17.4.1.12.3, 3.17.4.1.12.4 and 3.17.4.1.12.5 may be ignored, and the results obtained on the base metal welded joints may be considered in certification.

**3.17.4.1.12.6** The test specimens for checking the clad steel welded joints

resistance against intergranular corrosion shall be cut from the cladding metal of the welded butt joints in such a way that the cladding HAZ is in the middle of the specimen in the form of a plate dimensioned  $2 \times 25 \times 80$  mm.

The accelerated tests of these specimens for the resistance against intergranular corrosion shall be performed in the same manner as specified in 3.17.4.1.4 for the cladding metal, and then they shall be bent through the angle meeting to the national or international standard requirements.

The presence of cracks on the tensioned side of the specimen evidences the tendency to intergranular corrosion.

The absence of cracks shows the intergranular corrosion resistance.

**3.17.4.1.12.7** The welded joints resistance against intergranular corrosion shall be checked for each welding process for each batch of clad plates which have the cladding from one batch and are made in the same manner.

**3.17.4.1.12.8** The procedure for testing welded joints for the resistance against intergranular corrosion shall be previously agreed with the Register.

**3.17.4.2** The tests scope during steel-making at the Register-recognized manufacturer shall be determined in accordance with the Register-approved documentation considering the additional contract requirements, if any.

**3.17.4.2.1** The tests scope for the base metal of normal and higher strength steels shall comply with the requirements of 3.2, and of higher strength Grade F steel, with the requirements of 3.5, of high strength steel, with the requirements of 3.13 and of steel with specified through thickness properties, with the requirements of 3.14.

**3.17.4.2.2** Besides the above, the Register can demand testing to the following extent:

determination of plybond strength in bending three test specimens. One specimen is bent with the cladding on the tensioned side and another, with the cladding on the compressed side. The third one shall be tested for transverse bending with the cladding vertically oriented;

determination of shear strength of the cladding;

determination of the cladding metal resistance against intergranular corrosion according to 3.17.4.1.4;

all the plates are subject to the ultrasonic testing of the continuity of the cladding and base metal adhesion over the entire surface of the plate.

The continuity characteristics and the ultrasonic testing method shall comply with the requirements of the manufacturer documentation, national or international standards.

The test scope shall be agreed with the Register before the commencement of the technical supervision at the manufacturer.

### **3.17.5 Inspection.**

**3.17.5.1** All plates are subject to surface inspection. The manufacturer shall ensure the absence of unacceptable defects.

The quality of the plate surface shall be checked by surveyor to the Register after the manufacturer's checking.

**3.17.5.2** The cladding metal surface condition shall meet the requirements of 3.16.2.4.

No scale, annealing colours and other defects which may affect the chemical durability and the machinability of clad plates are acceptable.

The surface defects caused by a method of manufacturing are allowed if their depth is within the minus deviations of the cladding metal thickness specified in Table 3.17.5.7.

**3.17.5.3** The cladding metal surface defects being within a tolerance for its thickness shall be ground in such a way that a smooth transition from a restored area to the surface of the rest of the metal is ensured. The residual cladding shall have a thickness not less than the nominal one considering the tolerance for a lower dimension in Table 3.17.5.7.

**3.17.5.4** The surface defects with the cladding thickness after grinding less than the permissible one shall be eliminated by welding provided the total area of all rebuilt defects does not exceed 5 % of the cladding area.

All the plates are subject to ultrasonic testing.

**3.17.5.5** If, after grinding of the defect, the remaining thickness of the cladding is less than half of the guaranteed nominal thickness, it is necessary to replace the cladding by tapering and to rebuild the whole of the cladding metal by welding.

**3.17.5.6** The quality of the base metal and cladding metal adhesion shall be determined by ultrasonic testing which shall be specified in the manufacturer's documentation.

Continuity defects which exceed the values specified in the technical conditions, specification or relevant standard shall be repaired or eliminated.

The repair procedure by rebuilding shall be agreed with the Register considering the following conditions.

**3.17.5.6.1** The rebuilding shall be performed by qualified welders using the

materials and methods approved by the Register.

**3.17.5.6.2** All buildings-up shall be free from cracks, lacks of fusion, undercuts, slags and other defects which can degrade cladding quality.

If the welding process is associated with flashing of the base metal, two layers of cladding metal as a minimum shall be built up on it.

**3.17.5.6.3** Following welding, the rectified defect shall be ground flush with the cladding surface.

After final repairs the plates shall be submitted to Register representative.

The quality of defects elimination shall be proved by non-destructive testing.

**3.17.5.6.4** The manufacturer shall submit to the Surveyor a report on each rectification by rebuilding wherein the dimensions and location of defects, procedure for repairs by rebuilding, type of heat treatment if required, and the results of checking the defects elimination quality shall be specified.

**3.17.5.6.5** Rectification of the base material surface defects by welding is not allowed.

**3.17.5.7** Limiting deviations of a cladding thickness, unless the more strict tolerances are specified in an order, shall correspond to those given in Table 3.17.5.7.

The cladding thickness shall be measured at a distance of not less than 10 mm from a plate edge.

**Table 3.17.5.7 Limiting deviations of cladding metal thickness**

Nominal thickness, mm	Permissible deviation, mm
≥ 2.0 < 3.0	±0.20
≥ 3.0 < 3.5	±0.30
≥ 3.5 < 4.0	±0.35

≥ 4.0 < 5.0	±0.40
≥ 5.0	±0.45

**3.17.6 Marking shall be carried out according to the requirements of 1.4.**

### **3.18 NORMAL AND HIGHER STRENGTH CORROSION-RESISTANT STEELS FOR CARGO OIL TANKS**

#### **3.18.1 Scope of application.**

**3.18.1.1** These requirements apply to normal and higher strength corrosion-resistant steels when such steel is used as the alternative means of corrosion protection for cargo oil tanks as specified in regulation II-1/3-11 of SOLAS-74 with amendments (IMO resolution MSC.289(87) “Performance Standard for Alternative Means of Corrosion Protection for Cargo Oil Tanks of Crude Oil Tankers”).

**3.18.1.2** The requirements are primarily intended to apply to stainless steel products of the following types and thickness:

steel plates and wide flats:  
all grades of up to 50 mm thick;  
sections and bars:  
all grades of up to 50 mm thick.

**3.18.1.3** Normal and higher strength corrosion-resistant steels as defined within these requirements are steels whose corrosion resistance performance in the

bottom or top of the internal cargo oil tank is tested and approved to satisfy the requirements in IMO resolution MSC.289(87) in addition to other relevant requirements for structural steel, strength and construction.

It is not intended that such steels be used for corrosion-resistant applications in other ship areas that are outside of those specified regulation II-1/3-11 of SOLAS-74 with amendments (IMO resolution MSC.289(87)).

**3.18.1.4** Since corrosion-resistant steels described in the present Subsection are similar to the ship steels as specified in 3.2, the basic requirements of 3.2 apply to these steels except where modified by this Subsection.

**3.18.1.5** The weldability of corrosion-resistant steels is similar to those given in 3.2, therefore welding requirements specified in Sections 4 and 6, Part XIV "Welding".

### **3.18.2 Approval of materials.**

**3.18.2.1** All materials shall be manufactured at works recognised by the Register (having Recognition Certificate for Manufacturer in accordance with 1.3).

**3.18.2.2** In addition to the tests carried out for Recognition Certificate for Manufacturer as specified in 2.1, corrosion tests shall be carried out in accordance with 3.18.17.

In the Certificate a special mark may be entered for application in one of the following areas of a cargo oil tank:

- .1** lower surface of strength deck and surrounding structures;
- .2** upper surface of inner bottom plating and surrounding structures;
- .3** both strength deck and inner bottom plating.

**3.18.2.3** It is the manufacturer's responsibility to assure that effective process and production controls in operation are adhered to within the manufacturing specifications agreed upon with the Register.

If the process or production controls are changed in any way, or any product fails to meet specifications, the manufacturer shall issue a report explaining the reasons, and, in the instance of product, which fails to meet specifications, the measures to prevent recurrence.

The complete report shall be submitted to the surveyor to the Register along with such additional information as the surveyor may require.

Each affected piece shall be tested to the satisfaction of the surveyor to the Register. The frequency of testing for subsequent products is at the discretion of the Register with regard to development and performance of the particular arrangements by manufacturer.

### **3.18.3 Methods of manufacture.**

**3.18.3.1** Methods of manufacture, deoxidation practice and rolling practice shall be in accordance with 3.2.

### **3.18.4 Chemical composition.**

**3.18.4.1** The chemical composition of samples taken from each ladle of each cast shall be determined by the manufacturer in an adequately equipped and competently staffed laboratory and shall be in accordance with the requirements of 3.2. Additionally, as required by the Register, chemical analysis of finished steel is performed to confirm its compliance with the documents agreed with the Register.

**3.18.4.2** The manufacturer will establish a relationship of all the chemical elements, which affect the corrosion

resistance. The contents of chemical elements added for corrosion resistance shall be specifically verified for acceptance. Verification shall be based on the ladle analysis of the steel.

**3.18.4.3** The manufacturer's declared analysis will be accepted subject to periodic random checks as required by the surveyor to the Register.

**3.18.4.4** The carbon equivalent shall be in accordance with 3.2.

**3.18.5 Condition of supply.**

**3.18.5.1** All materials shall be supplied in one of the supply conditions specified in 3.2.

**3.18.6 Mechanical properties.**

**3.18.6.1** Tensile testing and V-notch impact testing shall be carried out in accordance with 3.2.

**3.18.7 Freedom from defects.**

**3.18.7.1** The steel shall be reasonably free from segregations and non-metallic inclusions. The finished material shall have a workmanlike finish and shall be free from internal and surface defects prejudicial to the use of the material for the intended application.

**3.18.7.2** The acceptance criteria for surface finish and procedures for the repair of defects, as detailed in 3.2, shall be observed.

**3.18.8 Tolerances.**

**3.18.8.1** Unless otherwise specified, the thickness tolerances in 3.2 are applicable.

**3.18.9 Identification of materials.**

**3.18.9.1** The steelmaker shall adopt a system for the identification of ingots, slabs and finished products, which will enable the material to be traced to its original cast.

**3.18.9.2** The surveyor of the Register shall be given full facilities for so tracing

the material when required.

**3.18 Testing and inspection.**

**3.18.10.1** Facilities for inspection.

**3.18.10.1.1** The manufacturer shall afford the surveyor to the Register all necessary facilities and access to all relevant parts of the works to enable him to verify that the approved process is adhered to, for the selection of test materials, and the witnessing of tests, as required by the Rules, and for verifying the accuracy of the testing equipment.

**3.18.10.2** Testing procedures.

**3.18.10.2.1** The prescribed tests and inspections shall be carried out at the place of manufacture before dispatch. The test specimens and procedures shall be in accordance with Section 2. All the test specimens shall be selected, stamped and marked by the surveyor to the Register and tested in his presence, unless otherwise specified.

**3.18.10.3** Through thickness tensile tests.

**3.18.10.3.1** If plates and wide flats with thickness of 15 mm and over are ordered with through thickness properties, the through thickness tensile test in accordance with 2.2.2.7 shall be carried out.

**3.18.10.4** Ultrasonic testing.

**3.18.10.4.1** If plates and wide flats are ordered with ultrasonic testing, this shall be made in accordance with an accepted standard at the discretion of the Register.

**3.18.10.5** Surface and dimensions inspection.

**3.18.10.5.1** Surface inspection and verification of dimensions are the responsibility of the steel maker. The acceptance by the surveyor to the Register shall not absolve the steel maker from this responsibility.

**3.18.11 Test material.**

**3.18.11.1** Sampling and preparation of test samples shall be in accordance with 3.2.

**3.18.12 Test specimens.**

**3.18.12.1** Mechanical test specimens.

**3.18.12.1.1** The dimensions, orientation and location of the tensile and V-notch test specimens within the test samples shall be in accordance with Section 2 and Subsection 3.2.

**3.18.13 Scope of testing.**

**3.18.13.1** Scope of testing and the corresponding number of tensile and V-notch impact test specimens shall be in accordance with Section 2 and Subsection 3.2.

**3.18.14 Retest procedures.**

**3.18.14.1** Retest procedures shall be in accordance with 1.3.2.

**3.18.15 Marking.**

**3.18.15.1** Every finished product shall be clearly marked by the maker in at least one place with the Register stamp and the following particulars:

**.1** unified identification mark for the grade of steel (e.g. A36);

**.2** steel plates that have complied with the requirements of the Rules shall be marked with a designation by adding a corrosion designation to the unified identification mark for the grade of steel. Example of designation: A36 RCB;

**.3** the corrosion resistant steel shall be designated according to its area of application as follows: lower surface of strength deck and surrounding structures — RCU;

upper surface of inner bottom plating and surrounding structures — RCB;

both strength deck and inner bottom plating — RCW;

**.4** steel supplied in the thermo-mechanically controlled process condition shall have the letters “TM” added after the identification mark but before the corrosion designation (e.g. E36 TM RCU Z35);

**.5** name or initials to identify the steelworks;

**.6** cast or other number to identify the piece;

**.7** if required by the purchaser, his order number or other identification marks.

**3.18.15.2** The above particulars, but excluding the manufacturer’s name or trade marks, where this is embossed on finished products shall be encircled with paint or otherwise marked so as to be clearly legible.

**3.18.15.3** Where a number of light materials are securely fastened together in bundles the manufacturer may, subject to the agreement with the Register, mark only the top piece of each bundle, or alternatively, a firmly fastened durable label containing the marking may be attached to each bundle.

**3.18.15.4** In case any material bearing the Register marking fails to comply with the test requirements, the marking shall be unmistakably defaced by the manufacturer.

**3.18.16 Documentation.**

**3.18.16.1** Certificates of the Register and Quality Certificates of manufacturers shall be verified before the material is used.

**3.18.16.2** The number of copies required shall be specified by the Register.

**3.18.16.3** The documents shall be supplied in either electronic or paper format as required by the Register.

**3.18.16.4** The Register may require

separate documents for each grade of steel.

**3.18.16.5** The document (Register and/or manufacturer certificate) shall contain, in addition to the description, dimensions, etc., of the material, at least the following particulars as a minimum:

**.1** purchaser's order number and if known the hull number, for which the material is intended;

**.2** identification of the heat number and product, including, where appropriate, the test specimen number;

**.3** identification of the steelworks;

**.4** identification of the steel grade and the manufacturer's brand name;

**.5** ladle analysis (for chemical elements specified in 3.2);

**.6** if the steel is approved in accordance with 3.4.2, the weight percentage of each chemical element added or intentionally controlled for improving corrosion resistance;

**.7** condition of supply when other than as rolled i. e. normalised, controlled rolled or thermo-mechanically rolled;

**.8** results of mechanical tests.

**3.18.16.6** Before the test certificates are signed or issued by the surveyor to the Register, the manufacturer is required to furnish the surveyor to the Register with a written declaration stating that the material has been made by an approved process and that it has been subjected to and has withstood satisfactorily the required tests in the presence of the surveyor to the Register.

The Register name shall appear on the test certificate. The following form of declaration will be accepted if stamped or printed on each test certificate or shipping statement with the name of the steelworks and initialled for the makers by an authorized official:

"We hereby certify that the material has been made by an approved process and has been satisfactorily tested in accordance with the Register Rules."

**3.18.16.7** In the case of electronic certification the Register shall agree upon a procedure with the steel mill to ensure the signing of the issued certificate by the surveyor to the Register.

**3.18.17 Additional approval procedure for corrosion-resistant steel.**

**3.18.17.1 Scope.**

**3.18.17.1.1** Manufacturer and approval of corrosion-resistant steel shall be carried out in accordance with 1.3 with the additional requirements for corrosion resistance testing specified in this Subsection.

**3.18.17.1.2** The corrosion resistance tests and acceptance criteria shall be in accordance with the Appendix of the Annex to Performance Standard for Alternative Means of Corrosion Protection for Cargo Oil Tanks of Crude Oil Tankers (IMO resolution MSC.289(87)).

**3.18.17.2 Application for approval.**

**3.18.17.2.1** The manufacturer shall submit to the Register a request for approval, which shall include the following:

**.1** corrosion resistance test plan and details of equipment and test environments;

**.2** technical data related to product assessment criteria for confirming corrosion resistance;

**.3** the technical background explaining how the variation in contents of the elements added for corrosion resistance improves it;

**.4** the grades, the brand name and maximum thickness of corrosion-resistant steel to be approved. Designations for

corrosion-resistant steels are given in Table 3.18.17.2.1;

.5 the welding processes and the brand name of the welding consumables to be used for approval.

**Table 3.18.17.2.1 Designation of corrosion resistant steel**

Type of steel	Application	Corrosion resistance
Rolled steel for hull structures	Strength deck, inner space of tanks	RCU
	Inner bottom plating	RCB
	Strength deck and inner bottom plating	RCW

### 3.18.17.3 Approval of test program.

**3.18.17.3.1** The test procedure presented by the manufacturer shall be assessed and approved by the Register.

Tests that need to be witnessed by the surveyor to the Register shall be identified.

**3.18.17.3.2** Method for selection of test samples shall satisfy the following.

**3.18.17.3.2.1** The numbers of test samples shall be in accordance with the requirements of the Appendix of the Annex to Performance Standard for Alternative Means of Corrosion Protection for Cargo Oil Tanks of Crude Oil Tankers (IMO resolution MSC.289(87)).

**3.18.17.3.2.2** The number of casts and test samples selected shall be sufficient to make it possible to confirm the validity of interaction effects and/or the control range (upper limit, lower limit) of the elements,

which are added or intentionally controlled, for improving the corrosion resistance. Where agreed, this may be supported with data submitted by the manufacturer.

**3.18.17.3.2.3** Additional tests may be required by the Register when reviewing the test program in accordance with 3.2.2.

**3.18.17.3.3** In addition to 3.2, the Register may require additional tests in the following cases:

.1 when the Register determines that the control range is set by the theoretical analysis of each element based on existing data, the number of corrosion resistance tests conducted in accordance with the Appendix of the Annex to Performance Standard for Alternative Means of Corrosion Protection for Cargo Oil Tanks of Crude Oil Tankers (IMO resolution MSC.289(87)) is too few to adequately confirm the validity of the control range of chemical composition;

.2 when the Register determines that the data of the corrosion resistance test result obtained for setting the control range of chemical composition varies too widely;

.3 when the Register determines that the validity of the corrosion resistance test result for setting the control range of chemical composition is not enough reliable or accurate;

.4 when the surveyor to the Register has not attended the corrosion resistance tests for setting the control range of chemical composition, and the Register determines that additional testing is necessary in order to confirm the validity of the test result data;

.5 when the Register determines that it is necessary, for reasons other than in cases of 3.18.17.3.3.1 to 3.18.17.3.3.4.

**3.18.17.3.4** The chemical composition of the corrosion-resistant steel shall be within the range specified for rolled steel used for hull.

Elements to be added for improving the corrosion resistance and for which content is not specified shall be generally within 1 % in total.

**3.18.17.4 Carrying out the approval test.**

**3.18.17.4.1** The manufacturer shall carry out the approval test for corrosion-resistant steel and for obtaining a Recognition Certificate for Manufacturer in accordance with the approved test program.

**3.18.17.5 Attendance of the surveyor to the Register for test.**

**3.18.17.5.1** The surveyor to the Register shall be present, as a rule, when the test samples for the approval test are being identified and for approval tests (refer also to 3.1).

**3.18.17.6 Test results.**

**3.18.17.6.1** After completion of the approval test for corrosion-resistant steel and for obtaining a Recognition Certificate for Manufacturer, the manufacturer shall produce the report of the approval test and submit it to the Register.

**3.18.17.6.2** The Register will give approval for corrosion-resistant steel and issue a Recognition Certificate for Manufacturer where approval tests are considered by the Register to have given satisfactory results based on the data submitted in accordance with this Subsection.

**3.18.17.6.3** The Recognition Certificate for Manufacturer shall contain the manufacturer's name, the period of validity of the Certificate, the grades and thickness of the steel approved, welding

methods and welding consumables approved.

**3.18.17.7 Acceptance criteria for results of corrosion resistance tests of welded joints.**

**3.18.17.7.1** The results shall be assessed by the Register in accordance with the acceptance criteria specified in the Appendix of the Annex to Performance Standard for Alternative Means of Corrosion Protection for Cargo Oil Tanks of Crude Oil Tankers (IMO resolution MSC.289(87)).

**3.19 APPLICATION OF YP47 STEEL PLATES**

**3.19.1 Scope of application.**

**3.19.1.1** General.

**3.19.1.1.1** These requirements apply to container carriers incorporating extremely thick steel plates in accordance with 3.19.1.2.1.

**3.19.1.1.2** This Subsection gives the basic concepts for application of YP47 steel plates to lengthwise structural members in the upper deck region of container carriers (such as lengthwise hatch coamings, hatch coaming top and the attached longitudinals).

Application of YP47 steel plate for other hull structures shall be subject to special consideration by the Register.

**3.19.1.1.3** Unless otherwise specified in the Subsection, the requirements of 3.2 shall be applied to YP47 steel plates.

**3.19.1.1.4** YP47 steel plates mean the steel plates of specified minimum yield stress of 460 N/mm.

The scope of application is defined under 3.19.1.2 and 3.19.1.3.

**3.19.1.2** Thickness.

**3.19.1.2.1** This Subsection gives the requirements for steel plates with thickness of 50 to 100 mm.

**3.19.1.2.2** For YP47 steel plates outside of this thickness range, shall be subject to special consideration and approval by the Register.

**3.19.1.3 Application.**

**3.19.1.3.1** In the case that YP47 steel plates are used for lengthwise structural members in the upper deck region (such as hatch side coaming and hatch coaming top and their attached longitudinals), the grade of YP47 steel plates shall be EH47 specified hereinafter.

**3.19.2 General.**

**3.19.2.1 Hull structures.**

**3.19.2.1.1** Material factor of high tensile steel *K*.

Material factor of high strength steel *K* used for assessment of hull girder strength shall be taken 0.62.

**3.19.2.1 Fatigue assessment.**

Fatigue assessment on the lengthwise structural members shall be performed in accordance with the Register procedure.

**3.19.2.1.3** Details of construction design.

Special consideration shall be paid to the details of constructions of structural members where YP47 steel plates are applied such as connections between outfitting and hull structures. Connections shall be in accordance with the documents approved by the Register.

**3.19.2.2 Material specifications.**

**3.19.2.2.1** Material specifications for YP47 steel plates are given in Tables 3.19.2.2.1-1 and 3.19.2.2.1-2.

The testing shall be conducted in accordance with the requirements of 3.2.

**3.19.2.3 Manufacturing approval test.**

**3.19.2.3.1 General.**

Approval test items, test methods and acceptance criteria not specified in this

Subsection shall be in compliance with 1.3.

**3.19.2.3.2 Range of approval.**

One test product with the maximum thickness to be approved (to obtain a Recognition Certificate for Manufacturer) shall be submitted by the manufacturer, provided the approved target chemical composition range remains unchanged.

**Table 3.19.2.2.1-1 Condition of supply, grade and mechanical properties for YP47 steel plates**

Con diti on of supp ly	Grade	Mech anical properties			Impact test		
		Yield stress, MPa, min	Tensile strength <i>R<sub>m</sub></i> , MPa, min	Elonga tion <i>ε<sub>s</sub></i> , % C	Test temperatu re, °C	Ave rage valu e of imp act ener gy, J	
					0 < <i>t</i> ≤ 70	70 < <i>t</i> ≤ 85	
TMC P <sup>1</sup>	EH47	460	570/720	17	-40	53	64

<sup>1</sup> Other conditions of supply shall be agreed with the Register.

Note: *t* is thickness, in mm.

**Table 3.19.2.2.1-2 Chemical composition of YP47 steel plates**

Chemical composition	<i>C<sub>eq</sub></i> <sup>1</sup>	<i>P<sub>CM</sub></i> <sup>2</sup>
As agreed with the Register	≤ 0.49	≤ 0.22

<sup>1</sup> The carbon equivalent value shall be calculated from the ladle analysis using the formula

$$C_{eq} = C + Mn/6 + (Cr + Mo + V)/5 + (Ni + Cu)/15, \%$$

<sup>2</sup> Cold cracking susceptibility shall be calculated using the formula

$$P_{CM} = C + Si/30 + Mn/20 + Cu/20 + Ni/60 + Cr/20 + Mo/15 + V/10 + 5B, \%$$

**3.19.2.3.3 Base metal test.**

**3.19.2.3.3.1 V-notch impact tests (KV).**

Generally V-notch impact testing shall be carried out in compliance with 2.2.3. Test samples shall be taken from the plate corresponding to the top of the ingot, unless otherwise specified.

In the case of continuous castings, test samples shall be taken from a randomly selected plate. The location of the test sample shall be at the square cut end of the plate, approximately one quarter width from an edge, as shown in Fig. 3.19.2.3.3.1.

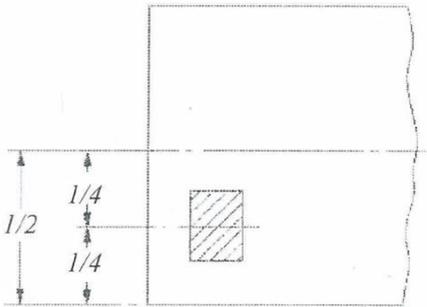


Fig. 3.19.2.3.3.1 Plates and flats

Samples shall be taken with respect to the principal rolling direction of the plate at locations representing the top and bottom of the plate as follows:

lengthwise V-notch impact tests (KVL) — top and bottom;

transverse V-notch impact tests (KVT) — top only;

aged lengthwise V-notch impact tests top only.

V-notch impact tests (KV) are required from both the quarter and mid thickness locations of the test samples.

One set of 3 V-notch impact specimens (KV) is required for each impact test. The impact test temperature shall be -40 °C.

In addition to the determination of the energy value, during impact tests the percentage crystallinity shall be also determined.

The aged samples shall be strained to 5 % followed by heating to 250 °C for 1 hour prior to testing.

Additionally at each location, V-notch impact tests shall be carried out with appropriate temperature intervals to properly define the full transition range (-20 °C, -40 °C, -60 °C, -80 °C) on KV type of samples from ¼ strip thickness.

**3.19.2.3.3.2 Primary test for resistance to brittle fracture.**

CTOD test shall be carried out and the result shall be reported.

Test methods shall be in compliance with 4, Part XII “Materials” of the Rules for the Classification, Construction and Equipment of Mobile Offshore Drilling Units and Fixed Offshore Platforms.

**3.19.2.3.3.3 Drop weight testing for determining nil-ductility temperature (NDT).**

Test methods shall comply with ASTM E208.

NDT is given for reference.

**3.19.2.3.3.4 Brittle crack stopping test.**

Standard ESSO test described in 3.20.6 or other alternative test (double tension test) shall be carried out in order to obtain

the brittle crack stopping toughness. The results are given for reference.

**3.19.2.3.4 Weldability test.**

**3.19.2.3.4.1 V-notch impact test (KV).**

V-notch impact tests shall be taken at a position of ¼ thickness from the plate surface on the face side of the weld with the notch perpendicular to the plate surface.

One set of the specimens transverse to the weld shall be taken with the notch located at the fusion line and at a distance 2.5 mm and minimum 20 mm from the fusion line.

The fusion boundary shall be identified by etching the specimens with a suitable reagent.

One additional set of the specimens shall be taken from the root side of the weld with the notch located at the same position and at the same depth as for the face side.

The impact test temperature shall be – 40 °C.

Additionally, at each location, impact tests shall be carried out with appropriate temperature intervals to properly define the full transition range.

**3.19.2.3.4.2 Y-shape weld hydrog Yiel crack resistance test.**

The test methods shall be stress compliance with recognized national standards such as, international standards such as ISO 17642 (2), KS B 0870, JIS Z 315 , GB 4675.1.

Acceptance criteria shall be in accordance with the Register practice.

**3.19.2.3.4.3 Test for resistance to brittle fracture.**

CTOD test shall be carried out.

Test method and results shall be considered appropriate by the Register-approved documentation.

**3.19.2.4 Welding.**

**3.19.2.4.1 Welders.**

Welders engaged in YP47 steel welding shall possess welder’s qualifications specified in accordance with Section 5, Part XIV “Welding”.

**3.19.2.4.2 Short beads.**

Short bead length for tack and repairs of welds by welding shall not be less than 50 mm.

In the case where  $P_{CM} \leq 0.19$ , 25 mm of short bead length may be adopted upon agreement with the Register.

**3.19.2.4.3 Preheating.**

Preheating shall be 50 °C or over when air temperature is 5 °C or below.

In the case where  $P_{CM} \leq 0.19$ , air temperature of 0 °C or below may be adopted upon agreement with the Register.

**3.19.2.4.4 Welding consumables.**

Specifications of welding consumables for YP47 steel plates are given in Table 3.19.2.4.4-1.

*Table 3.19.2.4.4-1 Mechanical properties for deposited metal tests for welding consumables*

Mechanical properties			Impact test (KV)	
Yield strength, $R_m$ , MPa, min	Tensile strength, $R_m$ , MPa	Elongation $A_5$ , %, min	Test temperature, °C	Average impact energy, J, min
460	570/720	19	-20	53

Mechanical properties of butt weld assemblies for acceptance of consumables shall be in accordance with Table 3.19.2.4.4-2.

**Table 3.19.2.4.4-2 Mechanical properties of butt welds (for assessment of welding consumables)**

TBe end ntes s t il erature str o en gth R <sub>m</sub> , M Pa	4	-20	V-notch impact test (KV)	
			Average impact energy, J, min	
			Welding position	
D/t	°C	Lower, horizontal, on vertical plane, upper	Vertical (upwards and downwards)	
57 0/7 20			53	53

**3.19.2.4.5 Other.**

Special care shall be paid to the final welding so that harmful defects do not remain.

Jigs shall be completely removed with no defects, otherwise the treatment of the jigs shall be agreed with the Register.

**3.19.2.5 Welding procedure approval.**

**3.19.2.5.1 General.**

Unless otherwise specified in this Chapter, qualification test items, test methods and acceptance criteria shall be in compliance with Section 6, Part XIV “Welding” of the Rules.

**3.19.2.5.2 Range of approval.**

Range of approval shall be in compliance with Section 6, Part XIV “Welding”.

**3.19.2.5.3 V-notch impact test (KV).**

V-notch impact test shall be conducted in accordance with Section 4, Part XIV “Welding”.

Average impact energy 64 J at -20 °C shall be satisfied for impact test.

**3.19.2.5.4 Hardness.**

Vickers hardness (HV10), as defined in Section 4, Part XIV “Welding”, shall be not more than 380. Measurement points shall include mid-thickness position in addition to the points specified.

**3.19.2.5.5 Tensile test.**

Tensile strength in transverse tensile test shall be not less than 570 MPa.

**3.19.2.5.6 Test for resistance to brittle fracture.**

CTOD test may be required.

Test method and results shall be considered appropriate by the Register-approved documentation.

**3.20 REQUIREMENTS FOR USE OF EXTREMELY THICK STEEL PLATES**

**3.20.1 Scope of application.**

**3.20.1.1 General.**

**3.20.1.1.1** These requirements apply to the container carriers incorporating extremely thick steel plates in accordance with 3.20.1.2 and 3.20.1.3.

**3.20.1.1.2** This Subsection gives measures for identification and prevention of brittle fractures of container carriers to which extremely thick steel plates are applied for lengthwise structural members.

**3.20.1.1.3** The application of the measures specified in 3.20.2 to 3.20.4 shall comply with 3.20.5.

**3.20.1.1.4** The properties of welded joints shall comply with Sections 4 and 6, Part XIV “Welding” and requirements of the present Subsection.

**3.20.1.2 Steel strength grade.**

**3.20.1.2.1** These requirements apply to the container carriers, to which any of YP36, YP40 and YP47 steel plates having

the thickness specified in 3.20.1.3 are used for the lengthwise structure members.

**3.20.1.2.2** Steel designations used herein: YP36, YP40 and YP47 mean the steel plates having the minimum specified yield points of 355, 390 and 460 N/mm<sup>2</sup>, respectively.

**3.20.1.3** Thickness.

**3.20.1.3.1** These requirements apply to the steel plates with thickness from 50 to 100 mm inclusive.

**3.20.1.3.2** For steel plates with thickness exceeding 100 mm, appropriate measures for prevention of brittle crack initiation and propagation shall be subject to the special consideration by the Register.

**3.20.2 Non-destructive testing (NDT) during construction** (measure 1, 30.2.5).

Where NDT during construction is required in 3.20.5, the NDT shall be in accordance with 3.20.2.1 and 3.20.2.2.

Enhanced NDT as specified in 3.20.4.3.1.2.4 shall be carried out in compliance with the documents approved by the Register and recognized standards.

**3.20.2.1** General.

**3.20.2.1.1** Ultrasonic testing (UT) in compliance with Section 3, Part XIV “Welding” shall be carried out on all block-to-block butt joints of all upper flange lengthwise structural members in the cargo hold region, including include the topmost strakes of the inner hull/bulkhead, the sheer strake, main deck, coaming plate, coaming top plate, and all attached lengthwise stiffeners (refer to Fig. 3.20.2.1).

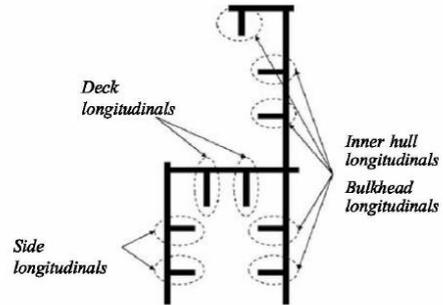


Fig. 3.20.2.1 Upper flange lengthwise structural elements

**3.20.2.2** Acceptance criteria of ultrasonic testing.

**3.20.2.2.1** Acceptance criteria of ultrasonic testing shall be in compliance with Section 3, Part XIV “Welding”, documentation approved by the Register and/or recognized standards.

**3.20.2.2.2** The acceptance criteria may be adjusted under consideration of the appertaining brittle crack initiation prevention procedure, and where this is more severe than that found in the Rules and standards to be amended accordingly to a more severe sensitivity.

**3.20.3 Periodic NDT after delivery** (measure 2, 30.2.5)

Where periodic NDT after delivery is required, the NDT shall be in accordance with 3.20.3.1 to 3.20.3.3.

**3.20.3.1** General.

**3.20.3.1.1** The procedure of the NDT shall be in accordance with 3.2 and the documentation approved with the Register for the steel supply.

**3.20.3.2** Timing of ultrasonic testing.

**3.20.3.2.1** Where ultrasonic testing is carried out, the frequency of survey shall be in compliance with the Register requirements.

### **3.20.4 Brittle crack stopping measures (measures 3, 4 and 5 of 30.2.5)**

#### **3.20.4.1 General.**

**3.20.4.1.1** Measures for prevention of brittle crack propagation in the cargo hold region.

**3.20.4.1.2** It shall be noted that cracks can initiate and propagate away from such joints, therefore, appropriate measures shall be considered in accordance with 3.20.4.2.1.2.2.

**3.20.4.1.3** Brittle crack stopping steel is defined as steel plate with measured crack stopping properties  $K_{ca} > 6,000 \text{ N/mm}^{3/2}$  at  $-10^\circ\text{C}$ .

Where the thickness of the steel exceeds 80 mm, the required  $K_{ca}$  value shall be subject to special consideration by the Register.

Brittle crack stopping steel parameters, as well as the appropriate methods to determine shall be agreed with the Register (e.g. DBTT not exceeding  $-10^\circ\text{C}$ ).

**3.20.4.2** Functional requirements of brittle crack stopping design.

**3.20.4.2.1** The following provisions shall be taken into account during designing the above-mentioned structures in order to stop the brittle cracks and prevent significant damage to the hull girder:

**.1** the point of a brittle crack initiation shall be considered in the block-to-block butt joints both of hatch side coamings and upper deck;

**.2** the following cases shall be considered:

**.2.1** where the brittle crack runs straight along the butt joint;

**.2.2** where the brittle crack initiates or deviates away from the butt joint and runs into base metal.

**3.20.4.3** Concept examples of brittle crack stopping design.

**3.20.4.3.1** The following are considered to be acceptable examples of brittle crack stopping design.

Other concept designs shall be subject to special consideration by the Register.

**3.20.4.3.1.1** Brittle crack stopping design for 3.20.4.2.1.2.2:

**.1** brittle crack stopping steel shall be used for the upper deck along the cargo hold region in a way suitable to stop a brittle crack initiating from the coaming and propagating into the structure below.

**3.20.4.3.1.2** Brittle crack stopping design for 3.20.4.2.1.2.1:

**.1** where the block-to-block butt welds of the hatch side coaming and those of the upper deck are shifted, this shift shall be greater than or equal to 300 mm. Brittle crack stopping steel shall be provided for the hatch side coaming;

**.2** where crack stopping holes are provided in way of the block-to-block butt welds at the region where hatch side coaming weld meets the deck weld, the fatigue strength of the lower end of the butt weld shall be assessed.

Additional countermeasures shall be taken for the possibility that a running brittle crack may deviate from the weld fine into upper deck or hatch side coaming. These countermeasures shall include the application of brittle crack stopping steel in hatch side coaming;

**.3** where stopping insert plates of brittle crack stopping steel or weld metal inserts with high crack stopping toughness properties are provided in way of the block-to-block butt welds at the region where hatch side coaming weld meets the deck weld, additional countermeasures shall be taken for the possibility that a

running brittle crack may deviate from the weld line into upper deck or hatch side coaming. These countermeasures shall include the application of brittle crack stopping steel in hatch side coaming;

.4 the application of enhanced NDT, particularly, time of flight diffraction (TOFD) technique using stricter defect acceptance in lieu of standard ultrasonic testing technique specified in 3.20.2 can be an alternative to 3.20.4.3.1.2.1 to 3.20.4.3.1.2.3.

**3.20.5 Measures for detecting and prevention of brittle fracture of hull structures of container carrier ships made of extremely thick steel plates**

The thickness and the minimum yield stress given in Table 3.20.5 apply to the hatch coaming structure steel, and are the controlling parameters for the application of countermeasures.

If the as-built thickness of the hatch coaming structure is below the values given in Table 3.20.5, individual countermeasures are not necessary regardless of the thickness and yield stress of the upper deck steel.

Table 3.20.5

Yield stress N/mm <sup>2</sup>	Thicknes s, mm	Optic n <sup>1</sup>	Measures			
			1	2	3-4	5
1	2	3	4	5	6	7
36	50 < t ≤ 85	–	Not applicable	Not applicable	Not applicable	Not applicable
	85 < t < 100	–	X	Not applicable	Not applicable	Not applicable

						applicable
40	50 < t ≤ 85	–	X	Not applicable	Not applicable	Not applicable
	85 < t ≤ 100	A	X	Not applicable		X
		B	X <sup>2</sup>	Not applicable <sup>3</sup>	Not applicable	X
47 FCA W (arc welding with powder wire)	50 < t ≤ 100	A	X	Not applicable		X
		B	X <sup>2</sup>	Not applicable <sup>3</sup>	Not applicable	X
47EG W (gas-electric welding)	50 < t ≤ 100	–	X	Not applicable		X

<sup>1</sup> Option A or B may be selected.

<sup>2</sup> Refer to 3.20.4.3.4

<sup>3</sup> To be agreed with the Register.

End of Table 3.20.5

Symbols:  
X — applicable

Note:

List of measures (columns 4-7 in Table 3.20.5):

1. Non-destructive testing of all welded joints according to 3.20.2 (during construction).

2. Periodic non-destructive testing after delivery of steel according to 3.20.2 (during construction).

3. Brittle crack stopping design against straight propagation of brittle crack along weldline (during construction). Refer to 3.20.4.3.1.2.1, 3.20.4.3.1.2.2.

4. Brittle crack stopping design against deviation of brittle crack from weldline (during construction). Refer to 3.20.4.3.1.1.1.

5. Brittle crack stopping design against propagation of cracks from other weld areas such as fillets and attachment welds (during construction). Refer to 3.20.4.3.1.1.1.

**3.20.6 Standard ESSO test**

**3.20.6.1 Scope of application.**

**3.20.6.1.1** The ESSO test method is used to estimate the brittle crack stopping toughness value  $K_{ca}$  of rolled steel plates for hull of thickness 100 mm or less.

**3.20.6.2** The symbols and arrangement of test specimen, holder and fixtures are given in Table 3.20.6.2 and in Fig. 3.20.6.2, respectively.

**Table 3.20.6.2 Symbols and definitions**

Symbol	Unit	Parameters
$t_s$	mm	Specimen thickness
$W_s$	mm	Specimen width
$L_s$	mm	Specimen length

$t_r$	mm	Holder thickness
$W_r$	mm	Holder width
$L_r$	mm	Holder length
$L_p$	mm	Distance between pins
$a$	mm	Length of crack projection onto the surface normal to load line
$a_a$	mm	Maximum length of brittle crack in the point of stopping
$T$	°C	Specimen temperature
$dT/da$	°C/mm	Specimen temperature gradient
$\sigma$	N/mm <sup>2</sup>	Maximum stress in the specimen ( $load/W_s \times t_s$ )
$K_{ca}$	N/mm <sup>3/2</sup>	Brittle crack stopping characteristic

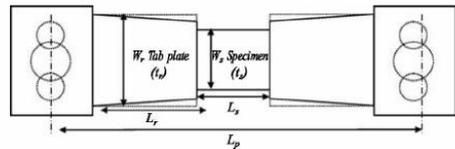


Fig. 3.20.6.2 Arrangement of specimen, holder and fixture

**3.20.6.3 Purpose.**

**3.20.6.3.1** The purpose of this test shall encourage the performance of a standard

test for assessment of brittle crack stopping toughness with temperature gradient and to obtain the corresponding brittle crack stopping toughness value  $K_{ca}$ .

**3.20.6.4 Standard test specimen.**

**3.20.6.4.1** Fig. 3.20.6.4.1 shows the shape and size of the standard test specimen.

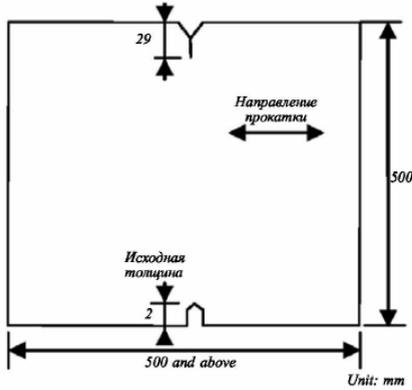


Fig. 3.20.6.4.1 Shape and size of the standard test specimen (dimensions in mm)

**3.20.6.4.2** The thickness and width of the test specimen shall be in accordance with Table 3.20.6.4.2.

**Table 3.20.6.4.2 Specimen thickness and width**

Thickness $t_s$	$\leq 100$ mm
Width $W_s$	500 mm

Note: If the width of the test specimen cannot be made 500 mm, it may be taken as 600 mm.

**3.20.6.4.3** The test specimens shall be taken from the same steel plate.

**3.20.6.4.4** Test specimens shall be taken in such a way that the axial direction of the load is parallel to the rolling direction of the steel plate.

**3.20.6.4.5** The thickness of the test specimen shall be the same as the

thickness of the steel plate to be used in the ship's hull structures.

**3.20.6.5 Test equipment.**

**3.20.6.5.1** The test equipment to be used shall consist of pin load type hydraulic test equipment capable of tensile tests.

**3.20.6.5.2** The distance between the pins shall be not less than 2,000 mm.

**3.20.6.5.3** Drop weight type or air gun type impact equipment may be used for the impact energy required for generating brittle cracks.

**3.20.6.5.4** The wedge shall have an angle greater than the upper notch of the test specimen.

**3.20.6.5.5** An opening force shall be applied to the notch.

**3.20.6.6 Preparation for tests.**

**3.20.6.6.1** The test piece shall be fixed directly to the pin load jig or by means of weld joint through the tab plate.

The overall length of the test specimen and tab plate shall be not less than  $3 W_s$ .

The thickness and width of the tab plate shall be in accordance with Table 3.20.6.6.1.

**Table 3.20.6.6.1 Tab plate thickness and width**

	Thick ness $t_r$	Wi dth $W_r$
Dimens ions of tab plate	$0.8 t_s$ $\leq t_r \leq 1.5 t_s$	$W_s$ $\leq W_r \leq 2W_s$

Note:

- $t_s$  is thickness of test specimen.
- If the tab plate has a thickness smaller than the test specimen, the reflection of stress wave will be on the safer side for the assessment; therefore, the minimum value of thickness is taken as  $0.8t_s$ .

**3.20.6.6.2** Thermocouples shall be fitted at 50 mm pitch on the notch extension line of the test specimen.

**3.20.6.6.3** If the brittle crack is estimated to deviate from its presumed course, thermocouples shall be fitted at two points separated by 100 mm on the line of load from the notch extension line at the centre of width of the test specimen.

**3.20.6.6.4** If dynamic measurements are necessary, strain gauges shall be fitted at specific locations.

**3.20.6.6.5** The test specimen shall be fixed to the testing machine together with the tab plate after welding and the pin load jig.

**3.20.6.6.6** The impact equipment shall be mounted. The construction of the impact equipment shall be such that the impact energy is correctly transmitted.

An appropriate jig shall be arranged to minimize the effect of bending load due to the impact equipment.

### **3.20.7 Test method.**

**3.20.6.7.1** To eliminate the effect of residual stress or correct the angular deformation of tab welding, a preload less than the test load may be applied before cooling.

**3.20.6.7.2** Cooling and heating may be implemented from one side on the side opposite the side on which the thermocouple is fitted, or from both sides.

**3.20.6.7.3** The temperature gradient shall be controlled in the range of 0.25 to 0.35 °C/mm in the range of width from 0.3 $W_s$  to 0.7  $W_s$ , at the central part of the test specimen.

**3.20.6.7.4** When the specific temperature gradient is reached, the temperature shall be maintained for more than 10 minutes, after which the specified

test load shall then be applied.

**3.20.6.7.5** After maintaining the test load for at least 30 seconds, a brittle crack shall be generated by impact.

The standard impact energy is taken as 20 to 60 J per 1 mm plate thickness.

If the brittle crack initiation characteristics of the base metal are high, and it is difficult to generate a brittle crack, the impact energy may be increased to the upper limit of 120 J per 1 mm plate thickness.

**3.20.6.7.6** Loading is stopped when the initiation, propagation, and stopping of brittle crack have been confirmed.

Then normal temperature is restored, and if necessary, the ligament is broken by gas cutting and forcibly the specimen is broken by using the testing machine.

Or, after the ductile crack has been propagated to an adequate length with the testing machine, the ligament is broken by gas cutting.

**3.20.6.7.7** After forcing the fracture, photos of the fractured surface and the propagation route shall be taken, and the crack length shall be measured.

### **3.20.8 Test results.**

**3.20.6.8.1** The distance from the top of the test specimen, including the notch to the maximum length in the plate thickness direction of the arrested crack tip, shall be measured.

If the crack surface deviates from the surface normal to the line of load of the test specimen, the projected length on the surface normal to the line of load shall be measured. In this case, if the trace of brittle crack stopping is clearly visible on the fractured surface, the first crack stopping position is taken as the stopping crack position.

**3.20.6.8.2** From the results of

thermocouple measurement, the temperature distribution curve shall be plotted, and the stopping crack temperature shall be measured corresponding to the stopping crack length.

**3.20.6.8.3** The brittle crack stopping toughness value  $K_{ca}$  of each test shall be determined by using the following formula:

$$K_{ca} = \sqrt{\pi\alpha} \cdot \sqrt{2Ws/\pi\alpha} \cdot \tan(\pi\alpha/2W_s). \quad (3.20.6.8.3)$$

### 3.20.9 Test report.

**3.20.6.9.1** The following items shall be reported:

**.1** testing machine specifications; testing machine capacity, distance between pins  $L_p$ ;

**.2** load jig dimensions; tab plate thickness  $t_r$ , plate width  $W_r$ , test specimen length including tab plates  $L_s + 2L_r$ ;

**.3** test specimen dimensions; plate thickness  $t_s$ ; test specimen width  $W_s$  and length  $L_s$ ;

**.4** test conditions; preload stress, test stress, temperature distribution (figure or table); impact energy;

**.5** test results; crack arrest length  $a_a$ , temperature gradient at stopping position, brittle crack stopping toughness  $K_{ca}$ ;

**.6** dynamic measurement results (if measurement is carried out); crack growth rate, strain change;

**.7** test specimen photos; fracture route, fractured surface.

**3.20.6.9.2** If the conditions below are not satisfied, the test results shall be treated as reference values.

**.1** the brittle crack stopping position shall be in the range of the hatched part shown in Fig. 3.20.6.9.2.1.

In this case, if the brittle crack stopping position is more than 50 mm away from the centre of the test specimen in the lengthwise direction of the test specimen, the temperature of the thermocouple at the  $\pm 100$  mm position shall be within  $\pm 3$  °C of the thermocouple at the centre;

**.2** the brittle crack shall not have a distinct crack bifurcation while it propagates.

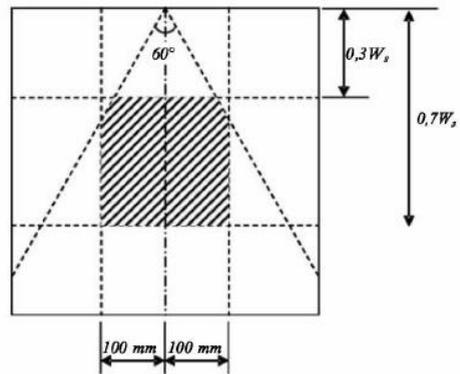


Fig. 20.6.9.2.1 Necessary conditions of stopping crack position

**3.20.6.9.3** From effective test results measured at more than 3 points, the linear approximation equation shall be determined on the Arrhenius plot, and  $K_{ca}$  at the desired temperature shall be calculated.

In this case, data shall exist on both sides, that is, the high temperature and low temperature sides around the assessed temperature.

## 4. COPPER AND COPPER-BASE ALLOYS

### 4.1 SEMI-FINISHED PRODUCTS OF

### COPPER AND COPPER-BASE

## ALLOYS

### 4.1.1 General.

These requirements apply to semi-finished products of copper and copper-base alloys (rolled, forged, drawn, press-formed, etc.) and castings, which are used in shipbuilding and marine engineering, and the manufacture of which is subject to the Register survey.

Semi-finished products of copper and copper-base alloys shall be manufactured at works recognized according to 1.3.1.4.

### 4.1.2 Chemical composition and mechanical properties.

The chemical composition and mechanical properties of copper and copper-base alloys products such as pipes, plates, bars, rolled sections, forgings and castings shall meet the requirements of appropriate standards or specifications approved by the Register.

When selecting copper-base alloys, one shall consider the required level of mechanical properties at indoor or higher temperatures, corrosion resistance, and other properties determined by their application.

### 4.1.3 Condition of supply.

If, in the process of manufacture, parts made of copper and copper-base alloys are subjected to heat treatment, the type of heat treatment shall be reported to the Register and stated in the material certificate.

Rolled products made of CuZn alloys (brasses) shall be annealed for stress relieving.

Products in solid and semi-solid condition may be used only upon agreement with the Register.

### 4.1.4 Sampling.

Tensile test samples shall be cut from

plate material transversely to the direction of rolling (forging), and from tubes, rods, sections and forgings — longitudinally to the direction of rolling.

Tubes, rods and sections with a diameter (or thickness) of 40 mm and less may be subjected to tensile tests in the rough condition.

Forging samples may be forged separately or forged on the forgings.

The samples shall have the same degree of upsetting as the forging in its highest loaded cross-section.

Casting samples may be separately cast, cast-on or cut out from the casting.

In any case, the samples shall be cut after the final heat treatment (in the supply condition).

### 4.1.5 Scope of testing.

If not otherwise specified, the following samples shall be taken from each batch:

for determination of chemical composition (heat analysis);

for determination of mechanical properties ( $R_m$ ,  $R_{eH}$ ,  $A_5$ );

for fabrication testing.

The scope of testing for semi-finished products (rolled products, forgings, castings) shall be determined according to standards recognized by the Register.

CuZn alloy tubes for heat exchangers shall be subjected to the following tests:

mercuric nitrate or ammonia treatment according to the requirements of appropriate standards (one specimen per lot);

flattening (two specimens cut from two tubes,  $H = 3t$ );

expanding (two specimens from two tubes, with the angle of mandrel taper  $\alpha = 45^\circ$ , and the expansion degree of

30 %);

micro-structure check (one specimen per lot).

Average grain diameter shall be 0.01 to 0.05 mm.

Tubes shall be subjected to hydraulic testing; the test pressure shall be determined by standards or specifications.

Test pressure for heat exchanger tubes shall be 5 MPa, for propeller lining tubes — 2 MPa.

Substitution of non-destructive testing for hydraulic testing is, in each case, subject to special consideration by the Register.

#### **4.1.6 Inspection.**

Products submitted for the Register inspection shall comply with the requirements of corresponding standards or specifications, on the basis of which they are accepted.

The products shall not have defects, which are detrimental for their intended use.

#### **4.1.7 Marking and documentation.**

Identification, marking and issued documentation — in accordance with the requirements of 1.4.

### **4.2 PROPELLER CASTINGS**

#### **4.2.1 General.**

**4.2.1.1** These requirements apply to castings intended for cast propellers, blades and bosses of propellers with detachable blades.

The requirements are applicable to moulding, casting, inspection of new propellers, blades and bosses as well as repair of new propellers in the course of their manufacture.

Upon special consideration these requirements may also be applied for the repair and inspection of propellers becoming damaged during service.

**4.2.1.2** All propellers and their components shall be cast by foundries approved by the Register in compliance with 1.3.1.4.

The application for approval shall be accompanied by specifications of the propeller materials, manufacturing procedures, repair, non-destructive testing and a description of the foundry facilities, including the maximum capacity of the ladles.

**4.2.1.3** The approval tests shall be carried out in compliance with 1.3.5 under the programme approved by the Register.

The purpose of the tests shall verify that the castings and their quality, including chemical composition and mechanical properties, comply with these requirements.

**4.2.1.4** The foundry shall have an adequately equipped laboratory, manned by experienced personnel, for the testing of moulding materials, chemical analyses, mechanical testing and micro-structure testing of metallic materials.

Provision shall be made for non-destructive testing. If these test facilities are not available, details shall be provided to the Register regarding an approved local laboratory which will provide such services. The laboratory shall be recognized by the competent national body and/or Register.

**4.2.1.5** The pouring shall be carried out into dried moulds using degassed liquid metal. The pouring shall be controlled as to avoid turbulences of flow. Special devices and/or procedures shall prevent slag flowing into the mould.

**4.2.1.6** Subsequent stress relieving heat treatment may be performed to reduce the residual stresses. For this purpose, the manufacturer shall submit a specification containing the details of the heat treatment to the Register for approval (refer to Tables 4.2.8.5-1 and 4.2.8.5-2).

**4.2.2 Chemical composition and structure characteristics.**

**4.2.2.1** The chemical composition of typical copper-base alloys for propellers shall comply with the requirements of Table 4.2.2.1.

Note: The main constituents of the micro-structure in the copper-base alloys categories CU1 and CU2 are alpha and beta phases.

Important properties such as ductility and resistance to corrosion fatigue are strongly influenced by the relative proportion of beta phase (too high percentage of beta phase having a negative effect on these properties). To ensure adequate cold ductility and corrosion fatigue resistance, the proportion of beta phase shall be kept low. The concept of the zinc equivalent shall be used as control since it summarizes the effect of the tendency of various chemical elements to produce beta phase in the structure.

Table 4.2.2.1

Alloy type	Chemical composition of copper-based alloys for propellers, %							
	Cu	Al	Mn	Zn	Fe	Ni	Sn	Pb
CU1	52-62	0.5-3.0	0.5-4.0	35-40	0.5-2.5	Max 1.0	0.1-1.5	Max 0.5
CU2	50-57	0.5-2.0	1.0-4.0	33-38	0.5-2.5	3.0-8.0	Max 0.15	Max 0.05
CU3	77-82	7.0-11.0	0.5-4.0	Max 1.0	2.0-6.0	3.0-6.0	Max 0.1	Max 0.03
CU4	70-80	6.5-9.0	8.0-20.0	Max 6.0	2.0-5.0	1.5-3.0	Max 1.0	Max 0.05

Note: Chemical composition shall be determined for the metal of each ladle.

**4.2.3 Mechanical properties.**

Mechanical properties of standardized alloys as applied to test specimens taken from separately cast samples shall comply with Table 4.2.3.

These properties are a measure of the mechanical quality of each heat; and they are generally not representative of the

The structure CU1 and CU2 type alloys shall contain an alpha phase component of at least 25 %. The content of alpha phase shall be measured by the manufacturer. Zinc equivalent calculated with the following formula shall not exceed 45 %.

$$\text{Zinc equivalent (\%)} = 100 - \frac{100\% \text{ Cu}}{100 + A}, \%$$

where A is the algebraic sum of the following values:

- 1×% Sn,
- 5×% Al,
- 0.5×% Mn,
- 0.1×% Fe,
- 2.3×% Ni.

The negative sign in front of the elements Mn, Fe and Ni signifies that these elements tend to reduce the proportion of beta phase.

Copper-base alloys of chemical composition different from those given in Table 4.2.2.1 may be allowed only after their approval by the Register.

mechanical properties of the propeller casting itself, which may be up to 30 % lower than that of a separately cast samples.

The requirements for mechanical properties of cast-on specimens or cut out from the casting are subject to special approval by the Register.

Copper alloys with mechanical characteristics different from those given in Table 4.2.3 may be allowed only after their approval by the Register in compliance with 1.3.1.4.

**Table 4.2.3 Mechanical properties of copper-based alloys for propellers (separately cast samples)**

Alloy type	Proof stress, $R_{p0.2}$ , MPa, min	Tensile strength, $R_m$ , MPa, min	Elongation, $A_5$ , %, min
CU1	175	440	20
CU2	175	440	20
CU3	245	590	16
CU4	275	630	18

#### 4.2.4 Sampling.

Separately cast samples for determining the mechanical properties of propeller alloys shall be taken from each ladle and shall have the dimensions as shown in Fig. 4.2.4.

Samples may be prepared in accordance with the standards approved by the Register.

Use of cast-on samples or taken directly from a casting is subject to special consideration by the Register.

For the purpose of approval of a foundry the tests indicated in 4.2.1.3 may be carried out on separately cast samples and specimens of cast-on metal or casting metal.

#### 4.2.5 Scope of testing.

Out of each sample at least one cylindrical specimen is machined to undergo the tensile test (refer to Table 2.2.2.3).

The tensile strength, proof stress and elongation shall be determined by tensile test.

Generally, the specimens shall be taken from separately cast samples (refer to 4.2.4).

The samples shall be cast in moulds made of the same material as the mould for propeller. They shall be cooled down under the same conditions as the propeller. If propellers are subjected to a heat treatment the samples shall be heat treated together with them.

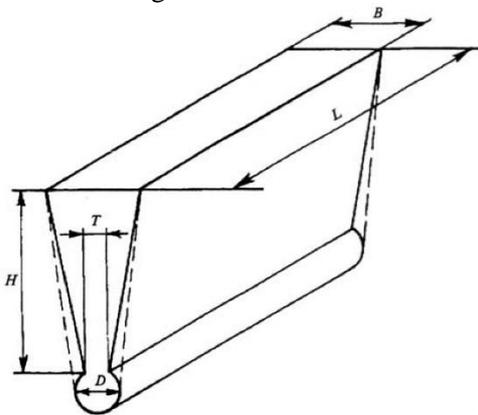


Fig. 4.2.4 Separately cast sample with dimensions, mm:  $H = 100$ ,  $B = 50$ ,  $L > 150$ ,  $T = 15$ ,  $D = 25$

Where use of cast-on samples specimens is approved by the Register, they shall, wherever possible, be located on the blades in an area lying between  $0.5R$  to  $0.6R$ , where  $R$  is the radius of the propeller. The sample material shall be removed from the casting by non-thermal procedures. For CU1 and CU2 alloy types the proportion of alpha phase is determined additionally. For this purpose, at least one specimen shall be taken from each cast.

The proportion of alpha phase shall be determined as the average value of 5 counts. The requirements of 4.2.2.1 shall be fulfilled.

#### 4.2.6 Severity zones (repair zones).

**4.2.6.1** In order to relate the degree of inspection to the criticality of defects in propeller blades and to help reduce the risk of failure by fatigue cracking after repair, propeller blades are divided into the three zones designated A, B and C (refer to Figs 4.2.6.2-1 and 4.2.6.3).

Note: Propellers are divided into high skew propellers, i.e. propellers with a skew angle greater than  $25^\circ$ , and low skew propellers with a skew angle of up to  $25^\circ$ .

The skew of the propeller is defined as the angle, in projected view of the blade, between a fine drawn through the blade tip and the shaft centreline and a second fine through the shaft centreline, which acts as a tangent to the locus of the midpoints of the helical blade section (refer to Fig. 4.2.6.1).

#### 4.2.6.2 Severity zones for low-skew propeller blades.

Zone A is in the area on the pressure side of the blade, embraced by hub radius  $R_b$  and radius  $0.4R$ , and bounded on either side by lines at a distance  $0.15$  times the chord length  $C_r$  from the leading edge and  $0.2$  times  $C_r$  from the trailing edge, respectively, as shown in Fig. 4.2.6.2-1 ( $C_r$  is the chord width of the blade on radius  $0.4R$ ).

Where the hub radius exceeds  $0.27R$ , the upper boundary of zone A may be increased to  $1.5R_b$ .

Zone A also includes the parts of the separately cast propeller hub around the holes for blades as illustrated in Fig. 4.2.6.2-2, and the flange and fillet area of controllable pitch and fixed pitch propeller blades as illustrated in Fig. 4.2.6.2-3.

Zone B is the area on the pressure and suction sides of the blade. On the pressure side zone B is the remaining area up to  $0.7R$  (the area within the boundaries of  $0.4R$  and  $0.7R$  plus areas on the leading and trailing edges bounded by lines  $0.15C_r$  and  $0.2C_r$ , respectively, and the line over the blade length with a radius of  $0.4R$ ) as illustrated in Fig. 4.2.6.2-1.

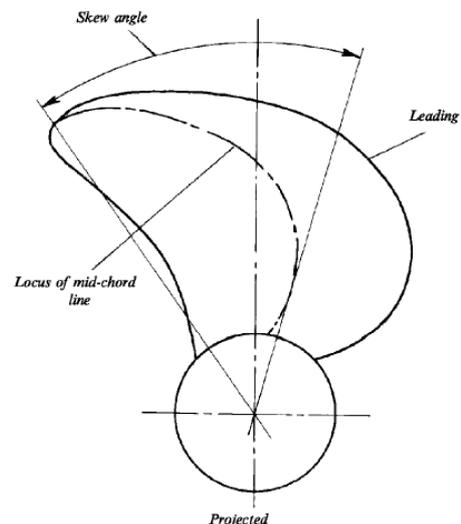


Fig. 4.2.6.1 Definition of skew angle

On the suction side zone B is the area from the fillet to  $0.7R$ .

Zone C is the area outside  $0.7R$  on both pressure and suction sides of the blade (between  $0.7R$  and  $R$ ) as illustrated in Fig. 4.2.6.2-1. It also includes all the surfaces of the hub other than those designated zone A above.

#### 4.2.6.3 Severity zones for high-skew propellers.

Zone A is the area on pressure and suction sides of the blade as described in Fig. 4.2.6.3.

On the pressure face zone A is contained within the blade root-fillet and a line running from the junction of the leading edge with the root fillet to the trailing at  $0.9R$  and at passing through the mid-point of the blade chord at  $0.7R$  and a point situated at  $0.3$  of the chord length from the leading edge at  $0.4R$ . Zone A also includes an area between the above-mentioned line and the edge from the root to the chord at  $0.4R$ .

Zone A includes an area along the trailing edge on the suction side of the blade from the root to  $0.9R$  and with its inner boundary at  $0.15$  of the chord lengths from the trailing edge.

Zone B is the area of the pressure and suction sides of the blade as described in Fig. 4.2.6.3.

Zone B includes the blade surfaces not included in zone A.

**4.2.6.4** Zone A is a region characterized by the highest operating stresses and the greatest thickness, and therefore it requires the highest degree of inspection and performance of all repair works.

Zone B is also a region where the operating stresses may be high, and therefore welding shall preferably be avoided in repair works.

Zone C is a region, in which the operating stresses are low and where the blade thickness is relatively small.

Repair welding is safer and is permitted in accordance with a procedure approved by the Register.

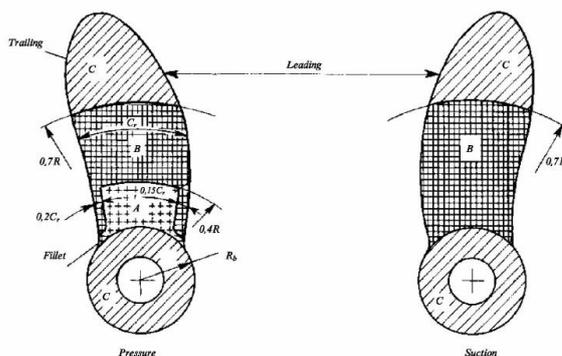


Fig. 4.2.6.2-1 Severity zones for integrally cast

low-skew propellers, where  $R$  is propeller radius,  $C_r$  is chord length at any radius

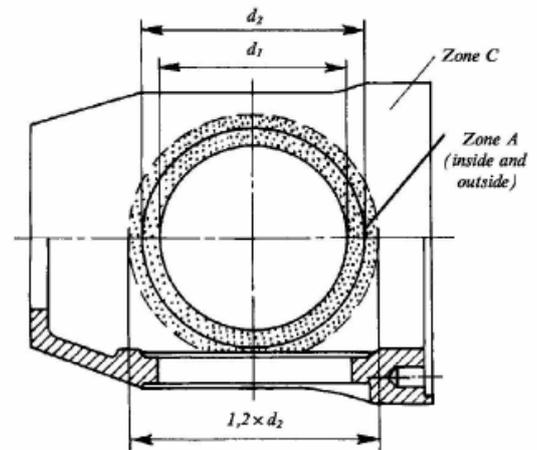


Fig. 4.2.6.2-2 Severity zones for hub of a controllable pitch propeller

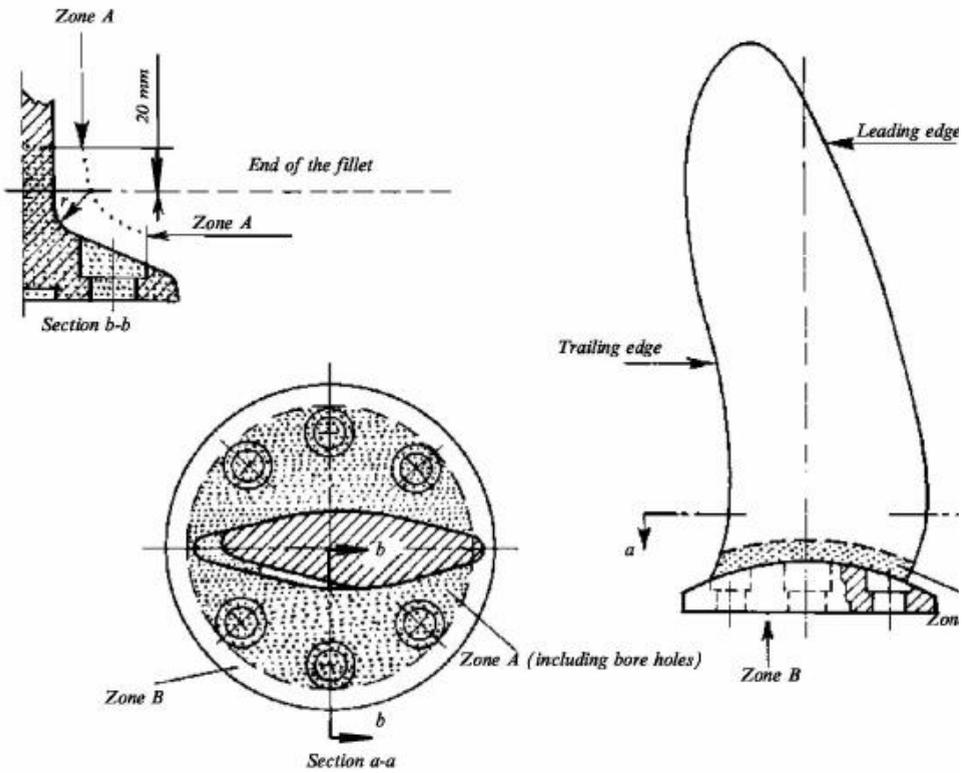


Fig. 4.2.6.2-3 Zones of control for variable pitch propeller blades and propellers with detachable blades

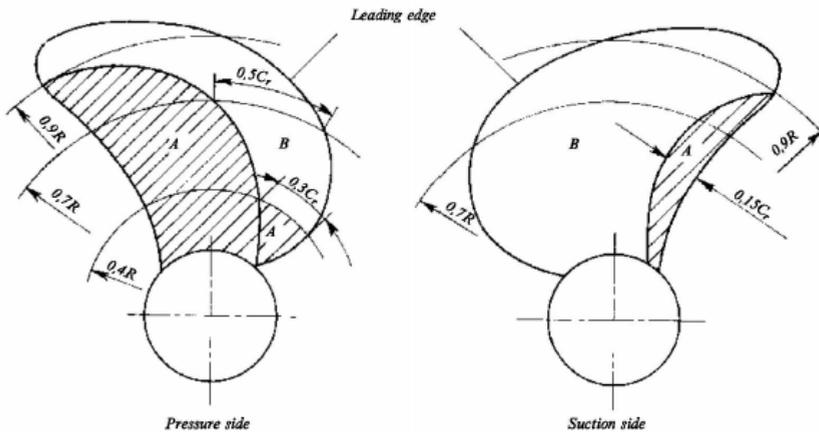


Fig. 4.2.6.3 Zones of control of blades with more than 25° blade rake

#### 4.2.7 Inspection.

**4.2.7.1** Propeller castings shall be visually tested at all stages of manufacture.

The castings shall be subjected to a comprehensive visual testing in the finished condition by the surveyor to the Register. At the final stage of manufacture the inspection shall include the bore. The castings subject to inspection shall be fettled and their surface prepared for non-destructive testing. The surface shall be free from defects liable to result in damage of propellers in the course of operation.

Note: Casting defects, which may impair the serviceability of the castings, e.g. major non-metallic inclusions, shrinkage cavities, blow holes and cracks, are not permitted. These defects may be removed by one of the methods described in 4.2.8 and repaired within the limits and restrictions for the severity areas. Full description and documentation shall be presented to the surveyor to the Register before commencement of works.

**4.2.7.2** The dimensions and the dimensional and geometrical tolerances shall comply with the requirements of the drawings approved by the Register and order documentation. The above

documents and the results of measurements and inspection drawn up in the form of a report shall be submitted to the surveyor to the Register at the time of the test. Unless expressly provided otherwise, the accuracy and verification of the dimensions are the responsibility of the manufacturer.

Static balancing shall be carried out on all the propellers in accordance with the documentation approved by the Register.

Dynamic balancing is necessary for propellers running above 500 rpm.

#### 4.2.7.3 Non-destructive testing.

##### 4.2.7.3.1 Penetrant testing.

The severity zones A (refer to 4.2.6) shall be subjected to penetrant testing in the presence of the surveyor to the Register. In zones B and C the penetrant testing shall be performed by the manufacturer and may be witnessed by the surveyor upon his request.

If repairs have been made either by grinding or by welding the repaired areas shall be additionally subjected to penetrant testing independent of their

location and/or severity zone.

The penetrant testing shall be carried out in accordance with a standard or specification approved by the Register. The following definitions shall be applied:

Indication is the presence of detectable bleed-out of the penetrant from the material discontinuities appearing at least 10 minutes after the developer has been applied. The Indication type shall be determined in accordance with Fig. 4.2.7.3.1.

Reference area is an area of 100 cm<sup>2</sup>, which may be square or rectangular with the major dimension not exceeding 250 mm.

For evaluation of surface quality by penetrant testing method the entire surface to be inspected shall be divided into reference areas of 100 cm<sup>2</sup> each. The area shall be taken in the most unfavourable locations relative to the indication being evaluated; i.e., the shape and dimensions of each reference area are chosen so that they cover the maximum number of defects without their distribution to an adjacent reference area.

The indications detected in each of such areas are, with respect to their size and number, shall not exceed the values given in Table 4.2.7.3.1.

Areas, which are prepared for welding, shall, independent of their

location, always be assessed according to zone A. The same applies to the welded areas after being finished machined and/or grinded.

**4.2.7.3.2 Radiographic and ultrasonic testing.**

Where serious doubts exist that the castings are not free from internal defects further radiographic and/or ultrasonic testing shall be carried out upon request of the Register. The evaluation and acceptance criteria shall be agreed between the manufacturer and the Register in accordance with the standards approved by the Register.

It shall not be that the absorption of the X-rays and gamma-rays is stronger in copper-base alloys than in a steel.

For propeller bronzes, 300 kV X-rays can normally be used up to 50 mm and Co 60 gamma-rays up to 160 mm thickness. Due to the limited thicknesses that can be radiographed as well as for other practical reasons radiographic testing is generally not a suitable method for checking of the thickest parts of large propellers.

As a general rule, ultrasonic testing of CU1 and CU2 is not feasible due to the high damping capacity of these materials. For CU3 and CU4, ultrasonic testing of subsurface defects is possible.

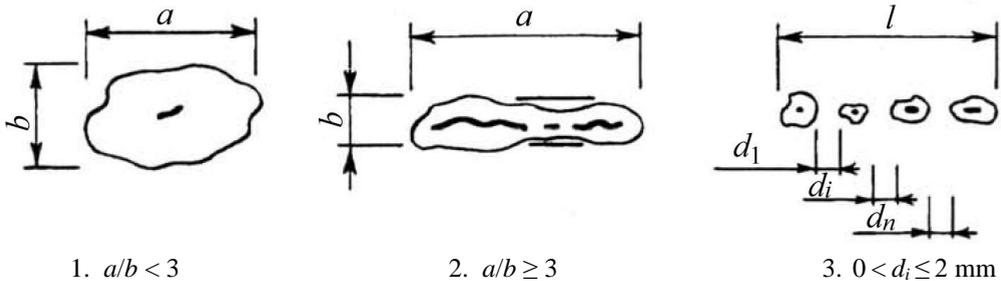


Fig. 4.2.7.3.1 Indication type: 1 — circular; 2 — linear; 3 — aligned.

**Table 4.2.7.3.1 Allowable number and size of indications in a reference area of 100 cm<sup>2</sup>, depending on the severity zones**

Severity zone	Total number of indications, max	Indication type	Max. number of each type of indications	Dimension <i>a</i> or <i>l</i>
A	7	Circular	5	4
		Linear	2	3
		Aligned	2	3
B	14	Circular	10	6
		Linear	4	6
		Aligned	4	6
C	20	Circular	14	8
		Linear	6	6
		Aligned	6	6

Notes: 1. Singular circular indications less than 2 mm for zone A and less than 3 mm for the other zones may be disregarded.

2. The total number of circular indications may be increased to the maximum total number represented by the absence of linear/aligned indications. The total number of circular indications may also be increased due to the absence of part of linear and/or testing is generally not a suitable method for checking of the thickest parts of large propellers.

#### **4.2.8 Repair of defects.**

**4.2.8.1** Discontinuities of the surface causing indications when penetrant testing is carried out and not meeting the requirements of Table 4.2.7.3.1, such as cracks, shrinkage cavities, sand, slag and other non-metallic inclusions, blow holes, etc., which may impair the safe service of the propeller, shall be eliminated or welded.

Dimensions, number and location of defects allowable without repairs, as well as of those subject to repair shall be determined on agreement with the Register.

In general the repairs shall be carried out by mechanical means, e.g. by grinding, chipping or milling. Welding may be applied subject to agreement with the surveyor to the Register if the requirements stated here will be complied with. After milling or chipping grinding shall be applied for such defects, which

shall not be welded. Grinding shall be carried out in such a manner that the contour of the ground depression is as smooth as possible in order to avoid stress concentrations or to minimize cavitation corrosion.

Welding of areas less than 5 cm<sup>2</sup> shall be avoided.

#### **4.2.8.2 Repair of defects in zone A.**

In zone A, repair welding is not allowed.

Grinding shall be carried out to an extent, which maintains the blade thickness of the drawing approved by the Register. The possible repair of defects, which are deeper than those referred to above, shall be specially considered by the Register.

#### **4.2.8.3 Repair of defects in zone B.**

Defects that are not deeper than  $dB = t/40$  mm ( $t$  = minimum local thickness, in mm, according to the Rules) or 2 mm (whichever is greater) shall be removed by

grinding. Those defects, which are deeper than allowable for removal by grinding, may be repaired by welding.

#### **4.2.8.4 Repair of defects in zone C.**

In zone C, repair welds are generally permitted.

#### **4.2.8.5 Repair welding.**

**4.2.8.5.1** The welding procedure and welding consumables used in repair welding shall be recognized by the Register as required by Part XIV "Welding".

Defects shall be repaired by welders of adequate qualification, allowed by the Register to perform such works.

The approval of the welding procedure shall be based on welding of samples as shown in Fig. 4.2.8.5.1-1, which shall be subjected to non-destructive testing (penetrant and radiographic testing).

Two transverse round tensile test specimens shall be taken from samples as shown in Fig. 2.2.2, *b* and three macro-etch specimens shall be prepared.

As an alternative, tensile test specimens may be prepared in compliance with the methods approved by the Register or the recognized standards.

The above works shall be performed by the manufacturer before commencement of welding operations.

Welding specification to be submitted to the Register for approval shall be made taking into account the following requirements and recommendations:

defects shall be repaired by mechanical means in accordance with 4.2.8, using penetrant testing for determination of the complete removal of the defects;

selection of welding consumables,

selection of preheat temperature and heat treatment temperature for stress relief shall be made in compliance with the requirements of Table 4.2.8.5.1-1. It shall be noted that with the exception of alloy CU3 all weld repairs shall be stress relief heat treated, in order to avoid stress corrosion cracking;

where stress relief heat treatment of alloy CU3 propeller castings is required after major repairs in zone B and/or zone A (the latter requires special approval by the Register) or if a welding consumable susceptible to stress corrosion cracking is used, the propeller shall be either stress relief heat treated in the temperature 450 to 500 °C or annealed in the temperature range 650 to 800 °C, depending on the extent of repair (refer to Table 4.2.8.5.1-1);

the defects shall be repaired as far as possible in the down-hand position, using arc welding with coated electrodes or "wire — shielded gas" combination.

Where the down-hand position is impossible for repairs, only "wire — shielded gas" combination shall be used;

Note: Use of argon-shielded tungsten welding is not recommended due to the higher specific heat input of this process.

for CU1 and CU2 materials having a thickness 30 mm and less gas welding may give a satisfactory weldment;

the time of conditioning for stress relief heat treatment is determined in accordance with Table 4.2.8.5.1-2. The cooling rate shall not exceed 50 °C/h until the temperature of 200 °C is reached.

#### **4.2.8.6 Straightening.**

For hot and cold straightening, static loading only shall be used.

Straightening of a bent propeller blade or pitch modification shall be

carried out after heating the bent region and approximately 500 mm wide zones on either side of it. The temperature range shall comply with the requirements of Table 4.2.8.5.1-1; the heating shall be slow and uniform.

**Table 4.2.8.5.1-1 Recommended filler metals and heat treatments**

Alloy type	Filler metal	Preheat temperature, °C, min	Interpass temperature, °C, max	Stress relief temperature, °C	Hot straightening temperature, °C
CU1	Al-bronze <sup>1</sup>	150	300	350-550	500-800
	Mn bronze	150	300	350-550	500-800
CU2	Al bronze	150	300	350-550	500-800
	Ni-Mn bronze	150	300	350-550	500-800
CU3	Al bronze	50	250	450-500	700-900
	Ni-Al bronze <sup>2</sup>	50	250	450-500	700-900
	Mn-Al bronze	50	250	450-500	700-900
CU4	Mn-Al bronze	100	300	450-600	700-850

<sup>1</sup> Ni-Al-bronze and Mn-Al-bronze are acceptable.

<sup>2</sup> Stress relieving is not required.

**Table 4.2.8.5.1-2 Time of conditioning for stress relief heat treatment of propellers**

Temperature, °C	Alloy grade CU1 and CU2		Alloy grade CU3 and CU4	
	Hours per 25 mm thickness	Max. recommended total time, hours	Hours per 25 mm thickness	Max. recommended total time, hours
350	5	15	–	–
400	1	5	–	–
450	0.5	2	5	15
500	0.25	1	1	5
550	0.25	0.5	0.5 <sup>1</sup>	2 <sup>1</sup>
600	–	–	0.25 <sup>1</sup>	1 <sup>1</sup>

<sup>1</sup> 550 and 600 °C only applicable to CU4 alloys.

**Table 4.2.8.5.1-3 Required tensile strength values for copper-base alloys welded joints**

Alloy type	Tensile strength, MPa
CU1	370
CU2	410
CU3	500
CU4	550

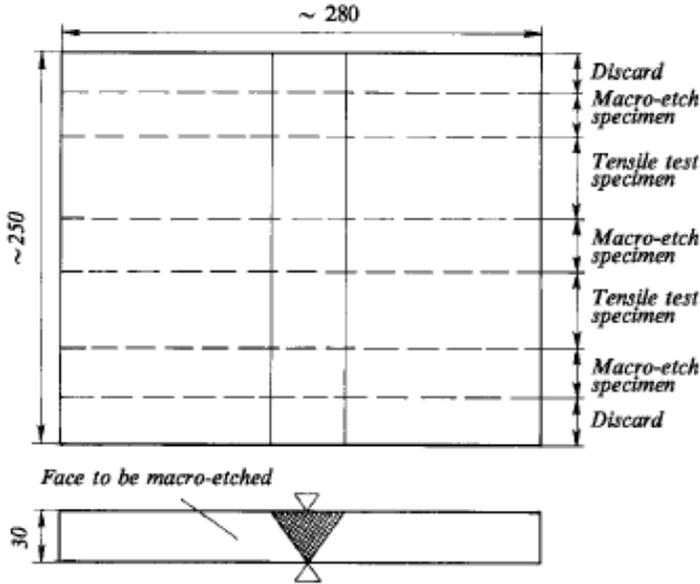


Fig. 4.2.8.5.1-1

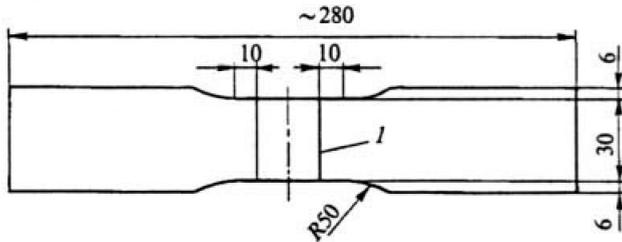


Fig. 4.2.8.5.1-2 A tensile test specimen: 1 — weld edge

The concentrated flame such as oxy-acetylene and oxy-propane shall not be used.

Cold straightening shall be used for minor repairs of tips and edges only. Cold straightening on CU1 and CU2 as well as CU4 bronze shall be always followed by a stress relieving heat treatment in accordance with Table 4.2.8.5.1-1.

**4.2.9 Identification and marking.**

**4.2.9.1 Identification.**

The manufacturer's shall employ a monitoring system, which enables all castings to be traced back to their heat.

The confirmation of the availability of such system at the manufacturer's shall be given to the surveyor to the Register at his request.

**4.2.9.2 Marking.**

Marking shall be made in compliance

with the requirements of 1.4.

Besides, marking shall contain the following data:

number of the Register Certificate;  
skew angle for high-skew propellers;  
ice class symbol, where applicable.

**4.2.9.3** The Manufacturer's Certificate to be submitted to the surveyor to the Register shall contain the following details:

purchaser and order number;  
shipbuilding project number, if known;  
description of the casting with

drawing number;

propeller diameter, number of blades,  
pitch, direction of turning;

type or grade of alloy and chemical  
composition of each heat;

heat and casting number;

final weight;

results of non-destructive tests, if  
used;

portion of alpha phase for CU1 and  
CU2 alloys;

mechanical test results;

casting identification number;

skew angle for high-skew propellers.

## 5. ALUMINIUM ALLOYS

### 5.1 WROUGHT ALUMINIUM ALLOYS

#### 5.1.1 General.

The present requirements apply to semi-finished products of wrought aluminium alloys (plates, sections, panels etc.) of 3 to 50 mm in thickness intended for ship hulls, superstructures and other marine constructions. The requirements are not applicable to aluminium alloys for constructions serving at low, cryogenic temperatures.

Designation of aluminium alloys is based on the designations of the Aluminium Association. Designation of national alloys approved by the Register is given in accordance with the Russian standards.

The use of wrought aluminium alloys, which don't comply with the present requirements in respect of chemical composition, mechanical properties or temper conditions, is the

matter of special consideration by the Register in each case, which implies thorough examination of alloy properties, corrosion resistance, welding technology features, as well as study of alloys behaviour in the working conditions.

Alloys shall be approved by the Register in accordance with 1.3.2.1.

All aluminium alloys shall be manufactured under the technical supervision of the Register at the enterprises recognised by the Register in accordance with 1.3.1. The material complying with the Register requirements shall be supplied with the Register certificates and marks.

Certificates of ingot, slab and billet manufacturers with the indication of the manufacturer's name, alloy grade, number of cast and chemical composition shall be available to the Surveyor performing survey at the enterprise with no melting facilities. Information about the system,

which is capable of ingot, slab and billet identification, shall be provided.

The enterprise, which performs aluminium alloys melting, shall be approved by the Register.

The requirements of the present Subsection apply to the following aluminium alloys:

**.1** rolled products (plates, strips and sheets):

5083, 5086, 5383, 5059, 5456, 5754;

condition of supply: O/H111/H112, H116, H321;

national alloys: 1530, 1550, 1561, 1561H, 1575;

condition of supply: O/H111/H112, H321;

**.2** pressed sections (full sections, hollow sections, panels, angles and bars etc.):

5083, 5383, 5059, 5086;

condition of supply: O/H111/H112; 6005A, 6061, 6082;

condition of supply: T5, T6;

national alloys: 1530, 1550, 1561, 1575;

condition of supply: O/H111/H112.

Alloys 6005A, 6061 and 6000 series shall not be used in direct contact with sea water unless protected by anodes and/or coating system.

### 5.1.2 Chemical composition.

The chemical composition of wrought aluminium alloys determined for each cast shall meet the requirements of Table 5.1.2.

If necessary, upon the Register requirement the samples for testing of chemical composition shall be blanked directly from the semi-finished products (plates, panels etc.).

Table 5.1.2 Chemical composition

Grade	Al, %	Si, %	Fe, %	Cu, %	Mn, %	Mg, %	Cr, %	Zn, %	Ti, %
1	2	3	4	5	6	7	8	9	10
5083	Base	≤ 0.40	≤ 0.40	≤ 0.10	0.4-1.0	4.0-4.9	0.05-0.25	≤ 0.25	≤ 0.15
5383	Base	≤ 0.25	≤ 0.25	≤ 0.20	0.7-1.0	4.0-5.2	≤ 0.25	≤ 0.40	≤ 0.15
5059	Base	≤ 0.45	≤ 0.50	≤ 0.25	0.6-1.2	5.0-6.0	≤ 0.25	0.4-0.9	≤ 0.20
5086	Base	≤ 0.40	≤ 0.50	≤ 0.10	0.20-0.7	3.5-4.5	0.05-0.25	≤ 0.25	≤ 0.15
5754	Base	≤ 0.40	≤ 0.40	≤ 0.10	≤ 0.50 <sup>2</sup>	2.6-3.6	≤ 0.30	≤ 0.20	≤ 0.15
6005A	Base	0.50-0.90	≤ 0.35	≤ 0.30	≤ 0.50 <sup>3</sup>	0.04-0.7	≤ 0.30 <sup>3</sup>	≤ 0.20	≤ 0.10
6061	Base	0.40-0.80	≤ 0.70	0.15-0.40	≤ 0.15	0.8-1.2	0.04-0.35	≤ 0.25	≤ 0.15
6082	Base	0.70-1.30	≤ 0.50	≤ 0.10	0.4-1.0	0.6-1.2	≤ 0.25	≤ 0.20	≤ 0.10
National alloys									
1530	Base	0.50-0.80	≤ 0.50	≤ 0.10	0.30-0.60	3.2-3.8	≤ 0.05	≤ 0.20	≤ 0.10
1550	Base	≤ 0.50	≤ 0.50	≤ 0.10	0.30-0.80	4.8-5.8	–	≤ 0.20	≤ 0.10
1561	Base	≤ 0.40	≤ 0.40	≤ 0.10	0.70-1.10	5.5-6.5	–	≤ 0.20	–
1561H	Base	≤ 0.40	≤ 0.40	≤ 0.10	0.50-0.80	5.5-6.5	–	≤ 0.20	–
1575	Base	≤ 0.20	≤ 0.30	≤ 0.10	0.35-0.60	5.4-6.4	0.05-0.15	≤ 0.01	≤ 0.07

Table 5.1.2 (continued)

Grade	Other elements, %	Notes
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	each	general <sup>1</sup>	
1	11	12	13
5083	≤ 0.05	≤ 0.15	–
5383	≤ 0.05 <sup>4</sup>	≤ 0.15 <sup>4</sup>	–
5059	≤ 0.05 <sup>5</sup>	≤ 0.15 <sup>5</sup>	–
5086	≤ 0.05	≤ 0.15	–
5754	≤ 0.05	≤ 0.15	0.10 ≤ Mn + Cr ≤ 0.60
6005A	≤ 0.05	≤ 0.15	0.12 ≤ Mn + Cr ≤ 0.50
6061	≤ 0.05	≤ 0.15	–
6082	≤ 0.05	≤ 0.15	–
National alloys			
1530	≤ 0.05	≤ 0.15	–
1550	≤ 0.05	≤ 0.15	–
1561	≤ 0.05	≤ 0.15	Zr (0.02-0.12)
1561H	≤ 0.05	≤ 0.15	Zr (0.10-0.17)
1575	≤ 0.05	≤ 0.15	Zr (0.10-0.12)

<sup>1</sup> Including Ni, Ga, V and other elements not given here.

<sup>2</sup> Mn + Cr: 0.10-0.60.

<sup>3</sup> Mn + Cr: 0.12-0.50.

<sup>4</sup> Zr: max 0.20. The total for other elements does not include Zirconium.

<sup>5</sup> Zr: 0.05-0.25. The total for other elements does not include Zirconium.

### 5.1.3 Mechanical properties.

Mechanical properties of wrought aluminium alloys shall meet the

requirements of Tables 5.1.3-1 and 5.1.3-2.

Table 5.1.3-1 Mechanical properties for rolled products.

Grade	Condition of supply	Yield stress, $R_{p0.2}$ , min, MPa	Tensile strength, min, $R_m$ , MPa	Thickness $t$ , mm	Elongation, %, min.	
					$A_{50\text{ mm}}$	$A_{5d}$
5083	O	125	275-350	$3 \leq t \leq 50$	16	14
	H112	125	275		12	10
	H116	215	305		10	10
	H321	215-295	305-385		12	10
5383	O	145	290	$3 \leq t \leq 50$	–	17
	H116	220	305		10	10
	H321	220	305		10	10
5059	O	160	330	$3 \leq t \leq 50$	–	24
	H116	270	370	$3 \leq t \leq 20$	10	10
		260	360	$20 < t \leq 50$	10	10
	H321	270	370	$3 \leq t \leq 20$	10	10
		260	360	$20 < t \leq 50$	10	10
5086	O	95	240-305	$3 \leq t \leq 50$	16	14
	H112	125	250	$3 \leq t \leq 12.5$	8	–
		105	240	$12.5 < t \leq 50$	–	9
H116	195	275	$3 \leq t \leq 50$	10 <sup>2)</sup>	9	

5754	O	80	275	$3 \leq t \leq 50$	18	17
5456	O	130-205	290-365	$3 \leq t \leq 6.3$	16	14
		125-205	285-360	$6.3 < t \leq 50$	16	
	H116	230	315	$3 \leq t \leq 30$	10	10
		215	305	$30 < t \leq 40$		10
200		285	$40 < t \leq 50$		10	
H321	230-315	315-405	$3 \leq t \leq 12.5$	12	10	
	215-305	305-385	$12.5 < t \leq 40$			
	200-295	285-370	$40 < t \leq 50$			
National alloys						
1530	O/H112	80	185	$3 \leq t \leq 12.5$	15	11
		60	165	$12.5 < t \leq 50$		
1550	O/H112	125	275	$3 \leq t \leq 12.5$	15	12
		110	255	$12.5 < t \leq 50$		
1561	O/H112	175	335	$3 \leq t \leq 12.5$	12	10
		175	335	$12.5 < t \leq 50$		
1561H	H32/H321	245	355	$3 \leq t \leq 12.5$	10	12
		225	335	$12.5 < t \leq 50$		
1575	O/H112	295	400	$3 \leq t \leq 12.5$	11	

Notes: 1. The values in the Table are applicable for longitudinal and transverse specimens as well.  
2. 8 % for thickness up to and including 6.3 mm.

**Table 5.1.3-2 Mechanical properties for extruded products**

Grade	Condition of supply	Yield stress, $R_{p0.2}$ , min, MPa	Tensile strength, $R_m$ , min, MPa	Thickness $t$ , mm	Elongation, %, min.	
					$A_{50\text{ mm}}$	$A_{5d}$
5083	O	110	270-350	$3 \leq t \leq 50$	14	14
	H111	165	275		12	10
	H112	110	270		12	10
5383	O	145	290	$3 \leq t \leq 50$	17	17
	H111	145	290		17	10
	H112	190	310			10
5059	H112	200	330	$3 \leq t \leq 50$	–	10
5086	O	95	240-315	$3 \leq t \leq 50$	14	14
	H111	145	250		12	
	H112	95	240		12	9
6005A	T5	215	260	$3 \leq t \leq 50$	9	–

	T6	215 210	260 250	$3 \leq t \leq 10$ $10 < t \leq 5$ 0	8 8	14 10
6061	T6	240	260	$3 \leq t \leq 50$	10	8
6082	T5	230	270	$3 \leq t \leq 50$	8	10
	T6	250 260	290 310	$3 \leq t \leq 5$ $5 < t \leq 50$	6 10	10
National alloys <sup>1</sup>						
1530	O/H111/H112	80	175	$3 \leq t \leq 12.5$ $12.5 < t \leq 50$	12	12
1530	O/H111/H112	125	255	$3 \leq t \leq 12.5$ $12.5 < t \leq 50$	13	13
1561	O/H111/H112	205	335	$3 \leq t \leq 12.5$ $12.5 < t \leq 50$	11	11
1575	O/H111/H112	295	400	$3 \leq t \leq 12.5$ $12.5 < t \leq 50$	11	11

<sup>1</sup> The mechanical properties specified for national alloys also cover hollow sections made of these alloys if their cross-section does not exceed 60 mm<sup>2</sup> or the diameter of a circumscribed circle is equal or less than 250 mm.

Note: The values in the Table are applicable for longitudinal and transverse specimens as well.

#### 5.1.4 Condition of supply.

Condition of supply shall be specified in accordance with EN515.

National aluminium wrought alloys shall be delivered with indication of condition of supply in accordance both with EN515 and applicable national standards.

The parameters of thermal and thermo-mechanical treatment providing alloys properties are determined by semi-finished products manufacturer.

Condition of supply is specified in the certificate for semi-finished product.

#### 5.1.5 Sampling.

Samples for mechanical properties determining shall be taken so that the longitudinal axis of the test specimen is oriented as follows:

for rolled products, as a rule, — across the direction of rolling. If the width of rolled products is insufficient for cutting off of specimens or if there are

special national standards — the production of longitudinal samples is allowed;

for pressed sections (full sections, hollow sections, bars etc.) — along the main axis of the semi-finished product;

for pressed sections for welding of hollow sections — perpendicular to the section axis.

The samples shall be taken at one third of the width from a longitudinal edge of rolled products.

In the range  $\frac{1}{3}$  to  $\frac{1}{2}$  of the distance from the edge to the centre of the semi-finished product samples shall be taken at the thickest part of it.

Blanking of specimens as well as production of specimens for tests shall be made by the methods preventing the possible change of alloys properties because of hardening.

Each specimen shall be marked so that after its manufacture and cleaning it is

possible to identify it with the specific semi-finished product and to determine the place where it was blanked and orientation of it.

The requirements for tensile test specimens are set forth in 2.2.2.5, and the general requirements for the tests — in 2.1.

#### **5.1.6 Scope of testing.**

Semi-finished products of wrought aluminium alloys are submitted for testing in batches.

A batch shall consist of semi-finished products of the same grade (the same cast), of the same form and dimensions (for plates — of the same thickness), of the same temper condition and manufactured by the same technological process.

##### **5.1.6.1 Rolled products.**

One tensile test specimen is taken from each 2,000 kg. If the weight of the batch exceeds 2,000 kg, one extra tensile testing shall be carried out for each 2,000 kg (full or not).

For plates, strips or coils weighting more than 2,000 kg each, only one tensile test specimen shall be taken.

**5.1.6.2** Pressed sections (full sections, hollow sections, bars etc.).

One tensile test specimen shall be taken from each batch:

- of 1,000 kg — for products weighting less than 1 kg;
- of 2,000 kg — for products weighting from 1 to 5 kg;
- of 3,000 kg — for products weighting more than 5 kg.

If the weight of semi-finished products batch exceeds the specified figures, an additional testing shall be carried out for each batch (full or not).

If the test results are unsatisfactory,

the testing shall be repeated in accordance with the requirements of 1.3.5.

#### **5.1.7 Quality testing of welded joints of hollow sections made by welding.**

The manufacturer shall carry out macrosection tests and drift expansion tests confirming that there is no lacks of fusion in each batch of closed sections.

Sections for testing shall be submitted in batches consisting of no more than five semi-finished products. One section from each batch is submitted to testing. If the lengths of sections exceed 6 m every semi-finished product shall be tested.

The test samples from each semi-finished product submitted to testing shall be cut from the each end perpendicular to the axis of the section. In any case the length of the specimen shall not be less than 50 mm.

Drift expansion testing shall be carried out at ambient temperature by means of a hardened steel conical mandrel (of at least 60°).

Testing is considered unsatisfactory if the specimen fails with a clean split along the weld line, which confirms lack of fusion.

#### **5.1.8 Corrosion testing.**

Rolled alloys of type 5083, 5383, 5059 and 5086 in the H116 and H321 tempers intended for use in marine hull construction or in marine applications where frequent direct contact with seawater is expected shall be corrosion tested in the above medium with respect to exfoliation and intergranular corrosion resistance.

During the initial works survey for the purpose of its recognition, the manufacturer shall provide data

concerning the relationship between micro structure and resistance to corrosion.

Reference photomicrographs taken at 500X shall be established for each of the alloy-temperers and thickness ranges relevant.

The reference photographs shall be taken from samples, which have exhibited no evidence of exfoliation corrosion and a pitting rating of PB or better, when subjected to the test described in ASTM G66 (ASSET). The samples shall also have exhibited resistance to intergranular corrosion at a mass loss no greater than 15 mg/cm<sup>2</sup>, when subjected to the test described in ASTM G67 (NAMLT). The tests for exfoliation corrosion and intergranular corrosion may be conducted in accordance with other national standards recognized by the Register.

The documentation (reports) relating to the test results and the established relationship between micro structure and resistance to corrosion submitted by the manufacturer shall be approved by the Register. Any changes in production practices of the material shall require respective examinations to be carried out and documentation exhibiting evidence of alloy corrosion resistance to be reapproved.

For rolled alloys of type 5083, 5383, 5059 and 5086 in the H116 and H321 tempers, comparative metallographic examination of one sample selected from mid width at one end of a batch coil (semi-finished product) shall be carried out.

A longitudinal section perpendicular to the rolled surface shall be prepared for comparative metallographic examination. If the microstructure shows evidence of continuous grain boundary

network of aluminium-magnesium precipitate in excess of the metal tested at the initial approval, the batch shall either be rejected or, at discretion of the Register, tested for exfoliation-corrosion resistance and intergranular corrosion resistance. The methods and assessment criteria of corrosion resistance test results shall be in accordance with ASTM G66 and G67 or the standards recognized by the Register.

If the results from testing satisfy the above criteria, the batch is accepted.

As an alternative to metallographic testing, each batch may be tested for exfoliation-corrosion resistance and intergranular corrosion resistance, in accordance with ASTM G66 and G67 or the equivalent standards recognized by the Register.

#### **5.1.9 Inspection.**

Semi-finished products of wrought aluminium alloys prepared for delivery shall have no internal and external defects negatively affecting their direct use.

All semi-finished products are liable to visual testing.

The application of non-destructive testing is not required if not specially indicated. Still it is supposed that manufacturers use the required non-destructive testing during manufacturing of wrought aluminium alloys in order to maintain products quality at the appropriate level.

It is allowed to rectify the detected surface defects by grinding or flogging provided this corrections doesn't change the size of semi-finished products out of the allowed tolerances.

Ultimate negative thickness tolerances for rolled aluminium alloys are given in Table 5.1.9. Rolling with

tolerances in compliance with recognized national or international standards is allowed upon agreement with the Register.

Ultimate negative thickness tolerances for pressed semi-finished products shall be in compliance with the

requirements of recognized international or national standards.

Manufacturer of the material is responsible for dimensions of semi-finished products and the appropriate allowed tolerances.

**Table 5.1.9 Ultimate negative thickness tolerances for rolled products**

Nominal thickness $t$ , mm	Ultimate tolerances in relation to rolled products thickness, mm		
	< 1,500	from 1,500 to 2,000	from 2000 to 3500
$3 \leq t \leq 4$	0.10	0.15	0.15
$4 < t \leq 8$	0.20	0.20	0.25
$8 < t \leq 12$	0.25	0.25	0.25
$12 < t \leq 20$	0.35	0.40	0.50
$20 < t \leq 50$	0.45	0.50	0.65

#### **5.1.10 Marking.**

The main requirements for marking are set out in 1.4.

Each semi-finished product shall be clearly identified by the agreed method and in the agreed place by the marks of the manufacturer and the Register.

Marking shall include as a minimum: name and/or identification of the manufacturer;

alloy grade and temper conditions in accordance with the requirements of the present Subsection;

batch number, semi-finished product number and identification number in accordance with the system adopted by the enterprise to trace back the whole production process.

It is allowed to put marks on labels if semi-finished products are delivered in bundles.

#### **5.1.10 Documents.**

Each batch or semi-finished product (if products are delivered in pieces) tested in accordance with 5.1.6 shall have the Register Certificate or the manufacture's document attested by the Register

representative. As a minimum, the Register Certificate shall contain the following:

- order number;
- construction of the ship or floating facility number, when known;
- name, number, dimensions and weight of the semi-finished product;
- alloy grade (category) and condition of supply;
- batch number or semi-finished product number, or identification number, which allows to identify the material delivered.

The results of chemical analysis, mechanical tests and corrosion tests (if any) are the mandatory supplement to the Register's Certificate. The results of those tests shall confirm the material compliance with the Register requirements (the supplement may be the Manufacturer's Certificate and/or test reports).

If materials are supplied with the Manufacturer's Certificates attested by the Register representative, its form and content shall be agreed with the Register

and the customer.

## 5.2 CAST ALUMINIUM ALLOYS

### 5.2.1 General.

The requirements of the present Subsection apply to parts and structures of cast aluminium alloy used in hull and ship machinery construction and manufactured under survey by the Register.

Semi-finished products of cast aluminium alloys shall be manufactured at works recognized according to 1.3.1.4.

### 5.2.2 Chemical composition and mechanical properties.

The chemical composition and mechanical properties of items cast of

aluminium alloys shall meet the requirements of Table 5.2.2.

When chill or pressure casting is employed, the Register may require higher values of mechanical properties. In this case, the mechanical properties required and the sampling procedure to be used shall be agreed with the Register.

The use of alloys with chemical composition and mechanical properties differing from those indicated in Table 5.2.2 is in each case subject to special consideration by the Register.

For new alloys having a modified chemical composition the Register may require a check of corrosion resistance.

**Table 5.2.2 Chemical composition and mechanical properties of cast aluminium alloys**

Grade	Chemical composition, %		Condition of supply	Mechanical properties, min			
	Allowable residual elements	Allowable additives, max		$R_{p0.2}$ , MPa	$R_m$ , MPa	$A_5$ , %	HB
1	Mg — 2.0-4.5	Cu — 0.10	Untreated	70	140	3	50
	Si — 0.05-1.3 Mn — 0.05-0.6 Al — remainder	Fe — 0.50 Zn — 0.20 Ti — 0.20	Solution-treated with slow cooling down	125	210	1	65
2	Mg — 4-6	Cu — 0.10	Untreated	80	150	2	55
	Si — 0.5-1.3 Mn — 0.05-0.5 Al — remainder	Fe — 0.50 Zn — 0.10 Ti — 0.20					
3	Mg — 9-11.5	Cu — 0.10	Solution-treated and hardened	145	270	8	60
	Si — max 1.3 Mn — max 0.4 Al — remainder	Fe — 0.50 Zn — 0.10 Ti — 0.15					
4	Si — 7-11	Cu — 0.10	Untreated	90	150	2	50
	Mg — max 0.5 Mn — 0.15-0.5 Al — remainder	Fe — 0.60 Zn — 0.30 Ti — 0.15	Solution-treated with slow cooling down	165	200	1.5	70
5	Si — 10-13.5	Cu — 0.10	Untreated	70	150	2	50
	Mn — max 0.5 Al — remainder	Fe — 0.60 Zn — 0.30 Ti — 0.15	Solution-treated and hardened	80	160	3	50

**5.2.3 Heat treatment.**

If castings of aluminium alloys are heat treated the type of heat treatment is chosen by the maker and recorded in the material certificate.

**5.2.4 Sampling.**

The samples may be cast-on or separately cast. The sample thickness shall not be less than the minimum wall thickness of the casting.

Whenever possible, the cooling of the samples will be effected in conditions similar to the cooling of castings.

In the case of castings for parts operating under high loads the thickness of the samples shall not be less than the thickness of the highest loaded zone of the castings and it shall be specified in the drawing.

**5.2.5 Scope of testing.**

Depending on their application the castings of aluminium alloys shall be divided into test groups and tested accordingly within the scope indicated in Table 5.2.5.

The scope of testing for castings with cast-on samples shall be agreed with the Register.

Tensile tests are conducted to determine the yield stress, tensile strength and elongation, but in certain cases, the Register may agree to omit the yield stress determination.

When castings for small-size pistons are checked, the Register may also allow to omit the tensile test being satisfied with the hardness test alone.

**5.2.6 Inspection.**

The castings shall be submitted for inspection in the fettled condition with sprues, heads and burrs removed. They shall be free of any defects detrimental to their application and strength.

Surface defects within the dimensional tolerances may be either ignored or removed by machining. Certain casting defects may be repaired by welding, the procedure of which shall be agreed with the Register.

If the material of the castings is tested for soundness by hydraulic pressure, the casting drawing shall contain information on the working pressure in the tested space and on the test pressure employed at testing.

*Table 5.2.5 Test groups for cast aluminium alloys*

Test group	Conditions of application	Examples of application	Test type	Scope of testing	
				Batch size	Number of tests
I	Cast items subjected to loads and exposed to corrosion	Parts of internal combustion engines, pumps, compressors, fans, valves	Determination of chemical composition	Per cast	
			Tensile test	1 cast	2
II	Parts operating at high temperature and exposed to fuel oil, petroleum products, etc.	Pistons of internal combustion engines, compressors	Determination of chemical composition	Per cast	
			Tensile test	Each casting	1
			Hardness test		1

The test pressure value is selected on the basis of the requirements of the relevant parts of the Rules or on agreement with the Register.

The Register may require non-destructive testing to be conducted on

castings intended for items, which operate under high loads.

### **5.2.7 Marking and documentation.**

Identification, marking and issued documentation — in accordance with the requirements of 3.8.8.

## **6. PLASTICS AND MATERIALS OF ORGANIC ORIGIN**

### **6.1 GENERAL**

**6.1.1** The present Section contains requirements for plastics and materials of organic origin used in hull and ship machinery construction for the manufacture of parts and structures, which are subject to survey by the Register.

The requirements of the present Section may be also applied to plastics and materials of organic origin used in structures and products not normally surveyed by the Register, if their application has considerable effect on the safety of the ship as a whole.

As a rule, manufacture of all materials and items regulated by the present Part shall be carried out in accordance with the documentation, approved by the Register, at works having the quality system approved by the Register and the Type Approval Certificate issued by the Register for the manufactured type of products.

#### **6.1.2 General.**

All plastics and materials of organic origin shall satisfy the following requirements unless there are special provisions regarding them in the subsections of the Section:

**.1** their combustibility, flame spread, ignitability and also by the volume of smoke and quantity of toxic substances shall be assessed in conformity with 1.6, Part VI “Fire Protection”;

**.2** they shall ensure reliable operation of items and structures on the open deck at temperatures from  $-40$  to  $+70$  °C and in the interior spaces of the ship at temperatures from  $-10$  to  $+70$  °C unless their service conditions provide for lower or higher operating temperatures;

**.3** they shall resist embrittlement and reduction of mechanical properties in service by more than 30 % in comparison with the original values;

**.4** they shall resist decay and destruction by fungi and not to affect adversely the materials, with which they come into contact.

#### **6.1.3 Scope of technical supervision.**

**6.1.3.1** The main provisions defining the scope and procedure of technical supervision are stipulated in 1.1.5 and 1.3.

**6.1.3.2** Technical supervision over manufacture of materials and products at works includes:

review and analysis of the manufacturer’s application with attachments thereto (refer to 6.1.3.2.2);

survey of the works including the quality system assessment and control testing (refer to 6.1.3.2.3);

issue of the Type Approval Certificate (refer to 6.1.3.2.4).

**6.1.3.2.1** To obtain the Register approval of the manufacturer’s products, as satisfying the requirements of the

Rules, and to get the documents mentioned in 1.1.5, the manufacturer shall apply to the Register with a request.

**6.1.3.2.2** Application of the manufacturer shall be supplemented by the following documents:

**.1** information describing the works and its products (documents confirming the works status, its structure, production and control management schemes);

**.2** list of manufactured materials and products;

**.3** information on the staff of employees and their qualification;

**.4** information on qualification of the personnel involved in the product quality system;

**.5** information on availability of ISO 9001 standards. Availability of the manufacturer's quality management system certified document issued by the manufacturer according to the ISO 9001 standard may be accepted by the Register as proof of the required level of existing control systems without additional requirements in this area;

**.6** information on available approvals by other classification societies and results of earlier tests, also data on practical application of materials and products indicated in the application confirming the possibility of their application for intended purpose;

**.7** Quality Manual with description of quality policy;

**.8** procedures and instructions describing production processes, sources of supply and stockyards of source materials, storage of finished products;

**.9** data on periodical control equipment and devices employed in the process of production, as well as equipment of the works laboratory;

**.10** specifications or other technical documents describing materials and products mentioned in the application and defining their main characteristics and conditions of manufacture;

**.11** rules for safe utilization of materials or products;

**.12** program of testing the specimens of materials or products compiled on the basis of requirements of the present Rules and technical documentation for materials or products.

**6.1.3.2.3** If the results of consideration of the submitted documentation are positive, a survey of the manufacturer's works is undertaken; it is aimed at establishing the actual condition of organization and quality control processes including products manufacture, as well as control tests in accordance with the program approved by the Register.

If the tests of products in question cannot be conducted at the manufacturer's works, it can be done at a laboratory approved by the Register.

Availability of the manufacturer's quality provision system certified document issued by the manufacturer according to the ISO 9001 standard may be accepted by the Register as proof of the required level of existing control systems without additional requirements in this area.

**6.1.3.2.4** Where results of the manufacturer's survey are satisfactory, the Type Approval Certificate for the products is issued:

a) Certificates of the typical approval for materials or products and a Certificate of Compliance of the Manufacturer's Quality System — issued provided positive results of testing and inspection

of the manufacturer;

*b)* a Certificate of the typical approval for products of the manufacturer — issued if the actual status of organization and control of quality system processes at the manufacturer does not comply with the requirements of the Register and if the product quality and the results of manufacturing process inspection and review of technical documentation are satisfactory.

The term of the Certificate of Compliance and the Certificate of the Typical Approval and the procedure and conditions for their confirmation shall be stipulated when these documents are issued.

If the manufacturer uses a quality system that has already been certified by the Register and its inspections confirm the availability of an actually existing testing and monitoring system that provides for the required level of output, Certificates of Typical Approval may be issued on the basis of the positive results of consideration of technical documents for the products and their control tests.

**6.1.3.3** Supervision during manufacture.

**6.1.3.3.1** Manufacturers that are issued a Certificate of Typical Approval and a Certificate of Compliance of the Quality System according to 6.1.3.2.4 (*a*) may supply their products with certificates of manufacturers and, if necessary, with copies of Register documents listed here.

Manufacturers who have only been issued a Certificate of Typical Approval according to 6.1.3.2.4 (*b*) can supply materials or products only under the direct supervision of the Register with certificates of the Register.

**6.1.3.4** Recognition of enterprises that perform installation (application) of polymer compositions.

**6.1.3.4.1** Normally, materials designed for application (installation) at objects supervised by the Register become the main characteristics established by technical documentation in the process of application; thus, all the work associated with the use of polymer compositions must be performed by companies recognized by the Register.

To this end, the manufacturer shall file a corresponding request with the Register.

**6.1.3.4.2** The application must be accompanied by the following documents:

*a)* information that characterizes the manufacturer (documents that confirm the status of the manufacturer, its structure, and manufacture and management organizational chart);

*b)* a list of work performed and materials used;

*c)* information on the staff of employees and their qualification;

*d)* information on qualification of the personnel involved in the product quality system;

*e)* information on availability of ISO 9001 standards.

*f)* information on available approvals of the manufacturer by other classification societies and results of earlier tests, also data on practical application of materials and products indicated in the application confirming the possibility of their application for intended purpose;

*g)* Quality Manual with description of quality policy;

*h)* procedures and instructions that describe both the processes of production and the resources applicable to specific

work;

i) reference letters and forms of reports or other reporting documents for the registration of the results of the work performed (services rendered);

j) training programmes for the technical staff.

**6.1.3.4.3** In case of positive results of consideration specified in 6.1.3.4.2 of the documentation, a review of the manufacturer shall be held in order to establish the actual state of the organization and management of quality system processes, including the processes of work, and their compliance with the documents in question. The manufacturer shall also practically demonstrate the performance of a specific job (service) and the proper registration of reporting documents.

**6.1.3.4.4** In case of positive results of the review of the manufacturer according to 6.1.3.4.3, a Certificate of Compliance of the Quality System and a Certificate of Recognition shall be issued, which attest that the manufacturer is authorized to implement the claimed work (services) and that the results of these work and services can be used as the basis for the issuance of relevant documents of the Register.

The terms and the period of validity and confirmation of the Certificate of Compliance and the Certificate of Recognition shall be concurred at the time of issuance.

**6.1.3.5** Delivery of products shall be implemented with a copy of the Certificate of Typical Approval

#### **6.1.4 Definitions and explanations.**

**Abrasive Blasting:** action of the flow of a mix with a high kinetic energy on the surface being cleaned.

**Acrylic coating:** a one-component coating based on acrylic resin that becomes hardened as a result of evaporation of the solvent (water).

**Alkyd coating:** a one-component coating based on polyester resin that becomes hardened as a result of oxidation by air.

**Vinyl coating:** a one-component coating based on vinyl chloride copolymers with vinyl acetate which becomes hardened as a result of physical evaporation of the solvent.

**Primer coating:** the first layer of a coating system (after interoperational primer) that provides increased adhesion and anticorrosive properties of the coating system.

**Shot-blasting:** action of shots on the surface being cleaned through the effect of the centrifugal force from the rotor with rotating blades.

**Epoxy coating:** a two-component coating based on epoxy resin that is formed as a result of a chemical reaction of hardening with the use of crosslinking of nitrogen-containing curing compounds.

**Coal tar epoxy coating:** a two-component coating based on epoxy resin and bitumen that is produced by a chemical reaction using crosslinking nitrogen-containing curing compounds. Bitumen is a pigment and improves the elastic properties of the coating.

**Almost white metal:** the degree of abrasive-jet or shot-blasting cleaning of a steel surface whose inspection shall not result in detection of oils, dirt, and rolling grilles, interoperational primer, and other foreign particles. Any traces of remaining contaminants shall look as light paintwork

on the surface (as spots and stripes).

**Interoperational primer:** fine (TSP 10-25  $\mu\text{m}$ ) coating applied to steel rolled products for their temporary storage and transportation.

**Mechanical cleaning:** action of a manual mechanical tool (percussion hammers, rotating wire brushes, wire brushes, cleaning machines with abrasive wheels and skins) on the surface being cleaned.

**Semi-hard coating:** a coating obtained in the process of solvent evaporation which maintains softness and elasticity while being sufficiently hard to be walked on.

**Facing:** reinforced coating with a thickness of 1,000  $\mu\text{m}$ .

**Coating:** a film of a lacquer and paint material with a thickness from 15 to 1,000  $\mu\text{m}$ .

**Light coating:** coating on which rust is easily identified.

**Polyurethane coating:** a two-component coating that is a product of the interaction of polyalcohols and polyisocyanates as a result of a hardening chemical reaction.

**Thinner:** a volatile organic liquid that does not dissolve a film-forming coating base but can reduce the viscosity of the paint material.

**Solvent:** a volatile organic liquid that is capable of dissolving a dry film-forming coating.

**Coating system:** a coating that consist of two or more layers of paint materials.

**Bandpass layer:** the narrow layer of a coating that is applied to corners, edges, and cuts, welds, as well as hard-to-reach spaces with a brush.

**“Good” coating condition:**

coating with minor corrosion spots.

**“Satisfactory” coating condition:** coating with local destruction on the edges of stiffeners and welding seams and/or minor corrosion that covers 20 % or more of the area being inspected but less than the value specified for the “Bad” coating condition.

**“Bad” coating condition:** coating with total destruction of the coating in an area of 20 % or more or with the presence of hard scales on 10 % or more of the area being inspected.

**Solid coating:** coating that is created by a hardening chemical reaction, including non-reversible coatings that become hardened during chemical oxidation.

**Dry film thickness:** the thickness of a layer or the entire coating system, which is determined after hardening or drying (evaporation of solvent) of paint materials.

**Wet film thickness:** the thickness of a layer or the entire coating system, which is determined in the course of application of the paint material.

**Dew point:** the temperature at which air becomes saturated and water vapour that is present in the air begins to condense into a liquid state.

**Chlorinated rubber coating:** a one-component coating that is the product of chlorination of the rubber with gaseous chlorine, which becomes hardened during the evaporation of the solvent.

**Roughness:** average arithmetical value of the five maximum heights of the surface roughness profile.

## **6.2 MATERIALS FOR REINFORCED PLASTIC**

**STRUCTURES**

**6.2.1 General.**

The present requirements cover materials for the manufacture of glass-fibre reinforced ship structures and systems, and of other items subject to survey by the Register.

**6.2.2 Glass-reinforcement material.**

**6.2.2.1** As reinforcement material, glass-fibre materials in the form of rovings, roving cloths, twisted composite filaments, mats and chemically bonded roving lengths (not less than 25 mm long) may be used.

**6.2.2.2** The application of a reinforcement material other than glass fibre may be permitted by the Register on the case-to-case basis.

**6.2.2.3** Reinforcement materials shall be manufactured from non-alkaline aluminoborosilicate glass (SiO<sub>2</sub> 52-56 %, CaO 16-25 %, Al<sub>2</sub>O<sub>3</sub> 12-16 %, B<sub>2</sub>O<sub>3</sub> 6-12 %, MgO 0-6 %, Na<sub>2</sub>O + K<sub>2</sub>O 0-1 %).

**6.2.2.4** Individual elementary fibres shall have a diameter of 5 to 15 µm.

**6.2.2.5** The moisture content in the reinforcement material shall not exceed 0.2 % of the mass of the material.

**6.2.2.6** Cloths of reinforcement material shall be treated with water-repellent adhesive compound to ensure a secure bond with the resin.

**6.2.2.7** The adhesive, by which the bondage of roving lengths is ensured in mats, shall be well soluble in the resin without any adverse effect on its

properties. A rapid solution of the adhesive shall not result in the mat collapsing while it is impregnated with the resin.

**6.2.2.8** The mechanical properties of reinforcement materials shall be in compliance with the Register-approved documentation.

**6.2.2.9** Each batch of reinforcement material shall be provided with the maker's certificate stating the following:

- manufacturer's name;
- grade of material;
- type of cloth;
- weight per unit length or area;
- N<sub>2</sub>O + K<sub>2</sub>O content (alkalinity);
- type of resin, for which the water-repellent adhesive treatment was made;
- test results.

**6.2.3 Bonding agent.**

**6.2.3.1** When manufacturing reinforced plastic structures, polyester resins approved by the Register and produced by Register-approved manufacturers shall be used.

**6.2.3.2** Application of epoxy resins may be permitted by the Register on the case-to-case basis.

**6.2.3.3** The physical and mechanical properties of the resin shall be in accordance with the requirements of Table 6.2.3.3.

**6.2.3.4** Addition of pigments and other colouring agents adversely affecting the resin properties is permitted for the decorative layer compound only, and their content shall not exceed 15 % of the resin weight.

Table 6.2.3.3

Gelation time, minutes, min	Minimal temperature of thermal deformation for resin in solid condition, °C, min	Modulus of elasticity in bending, MPa, min	Water absorption in 24 hours, %, max
20	70	3000	0.3

**6.2.3.5** Under the effects of sea water in conformity with 2.3.12.1, oil products in conformity with 2.3.11.2 and ageing in conformity with 2.3.10.1, the mechanical properties of resin shall not deteriorate by more than 25 % as compared to their initial values.

**6.2.3.6** To verify the resin adaptability to manufacture and the resin properties, the Register may require plastic specimens, reinforced with several layers of glass mats, to be prepared and tested. After the complete hardening of the specimen, its bending strength shall not be less than 90 MPa.

**6.2.3.7** When the resin is approved by the Register, instructions on the application and storage of technical documentation for the resin shall be submitted together with the documentation proper, in which, among other things, the chemical resistance of the resin to the attack of various aggressive media shall be indicated.

**6.2.3.8** Each batch of resin shall be provided with the maker's certificate stating the following:

- manufacturer's name;
- grade of resin;
- test results.

**6.3 LAMINATED TEXTILES**

**6.3.1 General.**

**6.3.1.1** The present requirements apply to textiles subject to survey by the Register, which have a rubber or plastic watertight coating and are intended for structures that are under pressure during their service.

**6.3.2 Properties.**

**6.3.2.1** Laminated textiles shall be air-tight and shall comply with the requirements of Table 6.3.2.1.

**6.3.2.2** After ageing and bend test, the change of tensile strength in laminated textiles shall not be more than 10 % of that before ageing, and the difference of dimensions along the warp and weft before and after ageing shall not be more than 2 %.

When the adhesive joints of laminated textiles are tensile-tested before and after ageing, the rupture shall occur in the base material.

*Table 6.3.2.1 Mechanical properties*

Tensile strength, kN/5 cm		Fracture elongation, %		Tear propagation strength, N		Coating adhesion, N/cm
Warp	Weft	Warp	Weft	Warp	Weft	
Min		Max		Min		
1	2	3	4	5	6	7
2.0		35		40		10

Note: In agreement with the Register, tensile strength can be reduced to the strength of shells of specific structures required by the Register but no more than four ring tensions arising in tubes filled with gas at a pressure of safety valve opening.

**6.3.2.3** No stickiness, cracks, delaminations or colour modifications shall be observed on the surface of laminated textiles after testing for

bending, ageing, creasing and shape stability after ageing, oil resistance, cold resistance, resistance to ozone and sea water.

**6.3.2.4** The colouring agents applied shall not detrimentally affect the properties of the base material.

#### **6.3.3 Sampling.**

Sampling for test specimens shall be effected from each batch of laminated textiles 0.1 m from the edge and at least 1 m from the roll end. Samples shall be taken 24 hours after fabrication at the earliest.

#### **6.3.4 Scope of testing.**

**6.3.4.1** Laminated textiles are submitted for tests in batches. A batch consists of one roll fabricated during one manufacturing cycle.

If the results of mechanical testing are continuously satisfactory, the mass of material comprising the batch may be increased on agreement with the Register.

**6.3.4.2** For each batch, tensile tests to determine fracture elongation as stated in 2.3.2.2, test to determine tear propagation strength as stated in 2.3.2.3 on ten specimens each (five along the warp and five along the weft), delamination test as stated in 2.3.2.4 on three specimens and air permeability test as stated in 2.3.13 on two specimens shall be effected, and the material mass shall be determined in accordance with a recognised standard.

**6.3.4.3** For the purpose of laminated textiles approval, tensile test after ageing in accordance with 2.3.10.2, bend test in accordance with 2.3.5.3, test of the bond joints of laminated textiles before and after ageing in accordance with 2.3.2.5 on ten specimens each (five along the warp and five along the weft), creasing and

shape stability test after ageing in accordance with 2.3.10.3, oil product resistance test in accordance with 2.3.11.2, sea water resistance test in accordance with 2.3.12.2, cold resistance test in accordance with 2.3.14 and ozone resistance test in accordance with 2.3.15 shall be effected in addition to those mentioned under 6.3.4.2.

**6.3.4.4** The test results shall comply with the requirements of 6.3.2.

#### **6.3.5 Inspection.**

On the surface of laminated textiles, damage, recesses, dead folds, textile flaw marks, spots, blisters, porosity or other defects, which may preclude their application in accordance with the purpose, are not permitted.

#### **6.3.6 Marking.**

Marking of laminated textiles is effected in accordance with 1.4. In addition, the mass of material per unit of area shall be stated.

### **6.4 FOAM PLASTICS**

#### **6.4.1 General.**

**6.4.1.1** The present requirements apply to foam plastics used for the manufacture of items subject to survey by the Register.

#### **6.4.2 Properties.**

**6.4.2.1** By their properties and conditions of application, foam plastics are subdivided into three grades:

grade 1 is represented by rigid foam plastics for filling up the spaces between supporting surfaces of sandwich structures;

grade 2 is represented by rigid foam plastics for filling up the air chambers of lifeboats and other similar hollow spaces;

grade 3 is represented by elastic foam plastics for the manufacture of buoyant

material for life jackets.

**6.4.2.2** Foam plastics shall chiefly have closed-cell structure.

**6.4.2.3** The shrinkage of grades 1 and 2 foam plastics shall not result in poor adhesion to boundary surfaces.

**6.4.2.4** The physical and mechanical properties of grade 1 foam plastics shall be in accordance with Table 6.4.2.4.

*Table 6.4.2.4*

Apparent density, g/cm <sup>3</sup> , min	0.8
Bending strength, MPa, min	0.3
Modulus of elasticity in bending, MPa, min	12
Compression strength, MPa, min	0.7
Modulus of elasticity in compression, MPa, min	30
Water absorption in 24 hours, kg/m <sup>2</sup> , max	0.2

**6.4.2.5** The physical and mechanical properties of grades 2 and 3 foam plastics shall be in accordance with the Register-approved documentation.

**6.4.2.6** Under the effects of sea water and petroleum products, the mechanical properties of grade 1 foam plastics shall not deteriorate by more than 25 % as compared to the initial values.

**6.4.2.7** Under the effects of 10 cycles of temperature variation in conformity with 2.3.1, high-octane petrol in conformity with 2.3.11.3 and fresh water as stated in 2.3.9.2, the buoyancy of grade 2 foam plastics shall not be reduced by more than 5 % of the initial value.

**6.4.2.8** When approving foam plastics of grade 2, they shall also be tested by conditioning in oil products in conformity with 2.3.11.4.

**6.4.2.9** Under the effects of 10 cycles of temperature variation in conformity with 2.3.16 and of fresh water as stated in 2.3.9.2, the floatability of grade 3 foam

plastics shall not be reduced by more than 5 %, and if they come additionally under the effects of diesel oil in conformity with 2.3.11.3, it shall not be reduced by more than 16 % of the initial value.

**6.4.2.10** The cyclic effects of temperature, oil products and fresh water shall not bring about a deterioration of the mechanical properties of grades 2 and 3 foam plastics.

#### **6.3.4 Sampling.**

Samples shall be cut out in the middle of a foam-plastic block, and a section with the most uniform cell structure shall be chosen for the purpose.

#### **6.4.4 Scope of testing.**

**6.4.4.1** Testing of grade 1 foam plastics.

**6.4.4.1.1** Bending strength is determined on three specimens in compliance with 2.3.3.2. For this purpose the maximum load causing an abrupt failure of the foam plastic structure is determined, which shall be reached within 1 minute approximately.

**6.4.4.1.2** Apparent density is determined on three specimens in compliance with 2.3.7.

**6.4.4.1.3** Bending strength is determined on three specimens in compliance with 2.3.5.1.

**6.4.4.1.4** Water absorption is determined on five specimens in compliance with 2.3.9.

**6.4.4.1.5** Resistance to oil products is determined in conformity with 2.3.11.2, and to sea water, in conformity with 2.3.12.1. Each of the tests is made on three specimens only at the time of the foam plastic approval.

**6.4.4.2** Grade 2 and 3 foam plastics are tested in conformity with technical documentation approved by the Register.

### 6.4.5 Inspection.

During the inspection, the surface structure of the foam plastic shall be checked at cross section for closed cells.

Under the cyclic effects of temperatures, oil products and fresh or sea water, no cracks, bulges or disintegration shall be visible on the foam plastic surface.

### 6.4.6 Marking.

The marking of foam plastics is effected in conformity with 1.4.

The test results shall be entered in the Certificate.

## 6.5 PROTECTIVE COATINGS

### 6.5.1 Anticorrosive protective coatings.

**6.5.1.1** Epoxy-based coatings or equivalent shall be applied to the inner surfaces of ballast tanks and rooms between two hulls of steel ships in accordance with the manufacturer's recommendations. Light colours of the coatings are the most preferable.

For ships covered by SOLAS-74 Convention and in spaces referred to 1.2.5.4, Part II "Hull", the coating shall be applied according to the Performance Standard for Protective Coatings<sup>2</sup>.

This standard may not apply to the covers of ballast tanks identified as "Spaces included in Net Tonnage" in the 1969 ITC Certificate, sea water ballast tanks in passenger vessels also designated for the carriage of grey water or black water, sea water ballast tanks in livestock carriers also designated for the carriage of the livestock dung.

**6.5.1.2** In tankers for crude oil with a

deadweight of 5,000 t or more referred to in 1.2.5.3, Part II "Hull", except combination vessels and chemical tankers:

- whose contract for construction is signed on or after 1 January 2013; or

- in the absence of a contract for construction and whose keels were laid or were at a similar stage of construction on or after 1 July 2013; or

- that are put into operation on or after 1 January 2016.

Cargo oil tanks shall have anti-corrosive coating according to the "Standards of Quality of Protective Coatings for Cargo Oil Tanks on Crude Oil Tankers" adopted by the resolution MSC.288(87) with regard to MSC.1/Circ.1381 and "Standards of Alternative Methods of Corrosion Protection of Cargo Oil Tanks on Crude Oil Tankers" adopted by the resolution MSC.289(87).

**6.5.1.3** It is recommended to protect the inner spaces of cofferdams, duct keels, supports of transverse bulkheads and other similar void spaces of oil tankers and bulk carriers with anticorrosive protective coatings in accordance with IMO Resolution MSC.244(83).

**6.5.1.4** Requirements for aluminium coatings, as well as coatings applied to interior decoration of the premises, are listed in 2.1.1.7, Part VI "Fire Protection".

### 6.5.2 Antifouling coatings.

**6.5.2.1** Antifouling coatings shall comply with the requirements of the Rules for preventing fouling of ships, Part VI "Requirements for antifouling systems".

### 6.5.3 Ice-resistant coatings.

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<sup>2</sup> Refer to Resolutions IMO MSC.215(82) as amended and the letter MSC.1/Circ.1378 and MSC.216(82)

**6.5.3.1** A coating is considered ice-resistant if it provides the protection of the ship's hull shell against the external actions under the ice navigation conditions demonstrating the performance, which meets the requirements in Table 6.5.3.1.

Ice-resistant coating shall be applied to vessels that have strengthened categories in their ice category marks: Ice4, Ice5, Ice6; and to icebreakers of all ice-strengthening categories.

Table 6.5.3.1

Ser. No.	Characteristic	Value	
		For icebreakers of all ice category marks	For ice class ships with a category of ice strengthening Ice4, Ice5, Ice6
1	2	3	4
1	Durability as per ISO 12944-6 for a corrosivity category Im2 in compliance with ISO 12944-2 (refer to 2.5.1)	High	High
2	Adhesion by a	≤ 3	≤ 3

	cross-cut test method as per ISO 2409 after testing for resistance to low temperature exposure (refer to 2.5.2.3)		
3	Adhesion by X-cut test method as per ISO 16276-2 after testing for resistance to low temperature exposure (refer to 2.5.2.3)	≤ 3	≤ 3
4	Adhesion strength as per ISO 4624 (refer to 2.5.3.4)	> 10 MPa	> 8 MPa

5	Abrasive wear after 1,000 cycle tests on the Taber's abrader (wheel CS-17) (refer to 2.5.4)	≤ 120 mg	≤ 160 mg
6	Impact resistance as per ISO 6272 (refer to 2.5.5)	≥ 8 J	≥ 5 J
7	Cathode disbondment as per ISO 15711 (method A) (refer to 2.5.6)	< 5 mm after three-month testing; < 8 mm after six-month testing,	< 5 mm after three-month testing; < 10 mm after six-month testing

Note: Tests shall be carried out in compliance with 2.5 according to the Register-approved program.

**6.5.3.2** The underwater portion of the hull and its board to a height of at least 1.0 m above the upper limit of the ice belt shall be covered with an ice-resistant coating (except for the use of a two-layer steel for ice belt covering when applying appropriate means of electrochemical corrosion protection).

The documentation of the supplier of the coating shall be agreed between the shipowner, the shipyard, and the manufacturer of the coating and shall be submitted to the Register for approval.

**6.6 ROPES OF NATURAL AND SYNTHETIC FIBRE**

**6.6.1** The present requirements apply to ropes, subject to survey by the Register, which are intended for cargo handling gear, life-saving appliances and other ship appliances.

**6.6.2** The ropes shall be manufactured and tested in conformity with standards approved by the Register.

The breaking load on a rope is determined by testing the rope as a whole.

**6.6.3** The breaking load on a rope *F*, in kN, may be determined by the

End of Table 6.5.3.1

1	2	3	4
8	A wetting interfacial angle (refer to 2.5.7)	> 90°	> 90°
9	Compatibility with cathode protection (manufacturer's methods)	Compatible	Compatible

following formula:

$$F = c \left( \sum_{1}^m F_m \right) n/z, \quad (6.6.3)$$

where *c* — yam efficiency factor for the rope, which shall be adopted on the basis of standards or calculated as the ratio of the breaking load on the rope as a whole to the total breaking load on all the yams making up the rope, both the values being stipulated by the standards;

*m* — number of yams, subjected to tensile testing, which conform to standards;

*F<sub>m</sub>* — the greatest load, during the tensile test

of a yam, in kN, after which the specimen breaks;  
 $n$  — number of yams in a rope;  
 $z$  — number of yams subjected to tensile testing, which is adopted equal to  $0.5n$  for ropes below 80 mm in diameter,  $0.3n$  for ropes 80 to 115 mm in diameter and  $0.1n$  for ropes over 115 mm in diameter.

**6.6.4** A rope of synthetic fibre shall undergo testing to determine fracture elongation.

The fracture elongation of a rope  $\sigma_{CP}$ , in %, is determined by the formula

$$\sigma_{CP} = (l_p - l_0) / l_0 \cdot 100, \quad (6.6.4)$$

where  $l_0$  — initial length of the rope specimen tested, cm;

$l_p$  — length of the same rope specimen under the load equal to the breaking load on the rope as a whole, which shall be found in the standard, cm.

**6.6.5** The compliance of the structure diameter and other parameters of the rope to the standard shall be confirmed by visual testing.

On the surface of a finished rope, no brown spots, mould, burned spots or smell of fume or rot shall be detectable.

The colour of the rope shall be uniform along its whole length and shall not differ from that of the yam or synthetic fibre, of which the rope is manufactured.

**6.6.6** The marking of the ropes is effected in conformity with 1.4.

**6.6.7** The test results shall be entered in the Certificate of Test, the contents of which shall be agreed with the Register.

## 6.7 RETRO-REFLECTIVE

Table 6.7.2.2

Entrance angle, deg.	Observation angle, deg.			
	0.1	0.2	0.5	1
5	180	175	72	14
30	140	135	70	12
45	85	85	48	9.4

## MATERIALS FOR LIFE-SAVING APPLIANCES

### 6.7.1 General.

**6.7.1.1** The present requirements apply to the retro-reflective materials of life-saving appliances subject to survey by the Register.

**6.7.1.2** Proceeding from their service conditions, retro-reflective materials are divided into two types:

type 1 includes materials to be fitted on elastic surfaces occasionally exposed to the weather;

type 2 includes materials to be fitted on rigid surfaces continuously exposed to the weather.

### 6.7.2 Properties.

**6.7.2.1** The tensile strength of retro-reflective materials with an adhesive layer shall not be less than 16 N/25 mm, and of those with a warp for mechanical attachment — 330 N/25 mm in the longitudinal direction and 200 N/25 mm in the transverse direction.

**6.7.2.2** Proceeding from the entrance angle and observation angle, the values of the retro-reflection factor  $R$ , in  $\text{cd} \cdot \text{lx}^{-1} \cdot \text{m}^{-2}$ , shall not be less than those to be found in Table 6.7.2.2.

**6.7.2.3** When the material is under a water film and after ageing, the retro-reflection factor may be lowered by not more than 20 % as compared to Table 6.7.2.2, and after the abrasion test, it may be lowered by not more than 50 %.

**6.7.2.4** Exposure to sea water, mildew, salt fog and ultimate temperatures shall not lower the retro-reflection factor of the material.

**6.7.2.5** For retro-reflective materials with an adhesive layer, the strength of adhesion to different surfaces shall not be less than 16 N/25 mm.

**6.7.2.6** Exposure to ultraviolet irradiation, sea water and distilled water shall not lower the adhesion properties of retro-reflective materials with an adhesive layer.

### **6.7.3 Sampling.**

The sample for the preparation of specimens is taken from each batch of retro-reflective materials at least one metre from the roll end.

Before the specimens have been prepared, the sample is conditioned in conformity with 2.3.1.1 during 24 hours.

### **6.7.4 Scope of testing.**

**6.7.4.1** Retro-reflective materials are submitted for testing in batches.

A batch comprises one roll manufactured during one production cycle.

Where the test results are stable, the bulk of the batch may be increased on agreement with the Register.

**6.7.4.2** Each batch of the material is tensile-tested in conformity with 2.3.2.6, and the strength of adhesion to different surfaces is determined in conformity with 2.3.2.7 for the material with an adhesive layer, as well as the retro-reflection factor in conformity with 2.3.18.1.

**6.7.4.3** When approving retro-reflective materials, besides the tests mentioned in 6.7.4.2, the retro-reflection factor is determined for the material under a water film in conformity with 2.3.18.2,

after ultraviolet irradiation in conformity with 2.3.10.4, abrasion in conformity with 2.3.22, sea-water conditioning in conformity with 2.3.12.3, exposure to salt fog in conformity with 2.3.12.4, to ultimate temperatures in conformity with 2.3.16 and mildew in conformity with 2.3.21. Besides, the bend test in conformity with 2.3.19, adhesion test in conformity with 2.3.20 and contaminant-resistance test in conformity with 2.3.23 are conducted.

For retro-reflective materials with an adhesive layer, the strength of adhesion to different surfaces shall be determined in conformity with 2.3.2.7 after exposure to the ultraviolet irradiation in conformity with 2.3.10.4 and to distilled and sea water in conformity with 2.3.12.5.

**6.7.4.4** Each type of tests shall be conducted at least on three specimens.

**6.7.4.5** The test results shall comply with the requirements of 6.7.2.

**6.7.4.6** Under the effects of seawater during 10 minutes, salt fog and ultimate temperatures during 4 hours, and after the bend and adhesion tests, no cracks, delamination, bulging, stickiness or change of colour shall be observed on the surface of retro-reflective materials, and their size shall be the same.

### **6.7.5 Inspection.**

The surface of retro-reflective materials shall be free from injuries, recesses, creases, delaminations, stains or other defects, which might adversely affect their application in accordance with the purpose.

### **6.7.6 Marking and documentation.**

The marking of retro-reflective materials shall be effected in conformity with 1.4.

The test results shall be entered in

the Certificate.

## 6.8 PLASTIC PIPES AND FITTINGS

### 6.8.1 General.

Plastic pipes shall comply with the requirements of standards approved by the Register.

### 6.8.2 Strength.

**6.8.2.1** The strength of pipes shall be determined by hydraulic failure testing of specimens.

**6.8.2.2** The strength of fittings and joints shall not be less than that of pipes.

**6.8.2.3** The nominal pressure  $p_{nom}$  shall be determined from the following conditions:

for internal pressure:

$$p_{nom} < p_{sth}/4 \text{ or } p_{nom} < p_{lth}/2,5$$

where  $p_{sth}$  — short-term hydraulic test failure pressure;

$p_{lth}$  — long-term hydraulic test failure pressure (more than 100,000 hours);

for external pressure:

$$p_{nom} < p_{col}/3$$

where  $p_{col}$  — pipe collapse pressure.

**6.8.2.4** In any case the collapse pressure shall not be less than 0.3 MPa.

**6.8.2.5** The maximum working external pressure is a sum of internal vacuum and external pressure of the pipe tested.

**6.8.2.6** The maximum permissible working pressure shall be determined taking into account the maximum possible working temperatures in accordance with the manufacturer's recommendations.

### 6.8.3 Axial strength.

The sum of longitudinal stresses because of pressure, weight and other loads shall not exceed the allowable stress

in the longitudinal direction.

For fibre reinforced plastic pipes the sum of longitudinal stresses shall not exceed the half of nominal circumferential stresses determined under nominal pressure.

### 6.8.4 Impact resistance.

Plastic pipes shall have an impact resistance sufficient for preserving the integrity of piping under external effects likely to occur in service, such as tods falling on them, for instance.

### 6.8.5 Temperature.

**6.8.5.1** The permissible working temperature depending on the working pressure shall be determined in accordance with the manufacturer's recommendations, but in any case it shall be at least 20 °C lower than the minimum heat distortion temperature of the pipe material.

**6.8.5.2** The minimum heat distortion temperature shall not be less than 80 °C.

### 6.8.6 Fire protecting coatings.

Where fire protecting coatings of pipes and fittings are used for achieving the required fire resistance level, they shall comply with the requirements of 6.8.6.1 to 6.8.6.4.

**6.8.6.1** As a rule pipes shall be delivered from the Manufacturer with fire protecting coatings on.

**6.8.6.2** Fire protecting properties of coatings shall not be diminished when exposed to sea water or oil products. It shall be demonstrated that the coating is resistant to products likely to come into contact.

**6.8.6.3** In considering fire protecting coatings such characteristics as thermal expansion, resistance against vibrations and elasticity shall be taken into account. It is advisable that these characteristics are

close to the similar characteristics of pipes.

**6.8.6.4** Fire protecting coatings shall have the sufficient impact resistance. It is advisable that this characteristic is close to the similar characteristic of the pipe.

**6.8.7 Materials approval and quality control during manufacture.**

**6.8.7.1** Plastic pipes and fittings shall be manufactured by the works having the quality system approved by the Register.

**6.8.7.2** Specimens of pipes and fittings of each type and size shall be tested for compliance with the requirements of the Rules.

**6.8.7.3** Serial specimens of pipes and fittings for tests determining strength, fire resistance and low surface flame spread characteristics, electrical resistance (for electrically conductive pipes) shall be chosen in accordance with the procedure approved by the Register.

**6.8.7.4** Each pipe and fitting shall be tested by the manufacturer at a hydrostatic pressure not less than 1.5 times the nominal pressure.

Alternatively, for pipes and fittings not employing hand layup techniques, the hydrostatic pressure test may be carried out in accordance with the hydrostatic testing requirements stipulated in the recognized national or international standard to which the pipe or fittings are manufactured, provided that there is an effective quality system in place.

If the Register deems it necessary, it may require special pressure testing of each pipe and fitting depending on the system intended application.

**6.8.7.5** Pipes and fittings shall be permanently marked with identification in compliance with the approved standard. Identification shall include the nominal

pressure, the design standard, in accordance with which the pipe is manufactured, and the pipe material.

**6.8.7.6** In case the manufacturer does not have the quality system approved by the Register, each batch of pipes and fittings shall be tested for compliance with the requirements of the Rules under the technical supervision of the surveyor to the Register.

**6.9 POLYMER COMPOUNDS**

**6.9.1** These requirements shall apply to polymer compounds used for products that are subject to supervision by the Register.

**6.9.2** Depending on their scope, polymer compositions shall be divided into:

**.1** adhesives: compounds that are used to connect and to restore strength elements of hull structures, mechanisms, systems, and devices;

**.2** polymer pastes: compounds that are used to install mechanisms and arrangements;

**.3** sealants: compounds that are used to seal off systems and to correct defects of moulding as well as to fix and to lock fasteners;

**.4** coatings: compounds that are used to protect the hull structures, mechanisms, systems, and devices from exposure to the environment.

**6.9.3** Physical and mechanical characteristics of polymer compounds shall comply with technical documents approved by the Register.

**6.9.4** Technical documentation that is submitted to the Register in accordance with 6.1.3.4.2 shall include the following information:

a) the name and the description of the

polymer compound;

*b)* the scope, including the temperature range;

*c)* the name and the description of the main components of the polymer compound;

*d)* technical characteristics of basic components, which include colour, viscosity, flash point, dry residue (paint), shelf life;

*e)* the instructions for use;

*f)* the time of full hardening at different temperatures;

*g)* the preparation of the surface of the base material (substrate).

**6.9.5** In addition to the above, the documentation shall specify the following physical and chemical characteristics of polymer compounds after hardening:

*a)* the elastic modulus, the tensile strength, and the tensile elongation;

*b)* the elastic modulus, the tensile strength, and the compression elongation;

*c)* adhesion or detachment from the base material (substrate) under

mechanical or electromechanical action;

*d)* bending strength;

*e)* shear strength;

*f)* hardness and apparent density;

*g)* impact strength;

*h)* durability;

*i)* dielectric resistance;

*j)* deformation under load in the range of operating and limit temperatures;

*k)* heat distortion temperature;

*l)* coefficient of thermal expansion;

*m)* friction factor for various metals;

*n)* chemical resistance;

*o)* durability in operation;

*p)* the impact on the process of heat treatment of the base material and manufacture of welded structures.

In agreement with the Register, the technical documentation may omit physical and mechanical characteristics of polymer compounds whose values do not significantly affect the performance of a particular object of supervision of the Register.

## 7. ANCHOR AND MOORING CHAIN CABLES

### 7.1 ANCHOR CHAIN CABLES AND ACCESSORIES

#### 7.1.1 General.

**7.1.1.1** The present requirements apply to the materials, design, manufacturing and testing of anchor chain cables and accessories used for ships. The requirements for the chafing chain for emergency towing arrangements are given in 7.1.6.

Studless chain cables used for ships in exceptional cases and by the separate agreement with the Register may be manufactured according to the

international or national standards recognized by the Register.

**7.1.1.2** Chain cables and accessories shall be made and tested by the manufacturers recognized in accordance with 1.3.1.4. In addition to the mentioned in 1.3.1.4, the request shall indicate the material grade, nominal dimensions and, if necessary, specification for the material. If there are several chain cable grades in the request, tests may be conducted only for the highest grade, provided the chain cable material, manufacturing methods and heat treatment are unchanged.

**7.1.1.3** Depending on the tensile

strength of the chain cable steel used for manufacture, stud link chain cables and accessories are subdivided into grades 1, 2 and 3.

### **7.1.2 Materials for chain cables and accessories.**

**7.1.2.1** All the materials used for the manufacture of chain cables shall be made by the manufacturers recognized in accordance with 1.3.1.4.

**7.1.2.2** Unless otherwise stated, the rolled products, forgings and castings for chain cables and accessories shall meet the requirements of 3.6.

Grade 1 rolled products may be used for the manufacture of chain cables with the Manufacturer's Certificates.

**7.1.2.3** The studs shall be made of steel corresponding to that of the chain cable links or from rolled, forged or cast carbon steels.

The use of other materials, e.g. grey or nodular cast iron is not permitted.

### **7.1.3 Design and manufacture of chain cables and accessories.**

**7.1.3.1** Chain cable links are manufactured by flash butt welding using bar material. Manufacture of the links by drop forging or steel casting is permitted.

Studless links of 26 mm diameter and below may be manufactured by pressure butt welding.

**7.1.3.2** Accessories such as Kenter and joining shackles, swivels and swivel shackles shall be forged or cast in steel of at least Grade 2.

These parts may also be welded.

**7.1.3.3** Chain cables and accessories shall comply with Register-adopted specification, as well as with Figs 7.1.3-1 to 7.1.3-7 (dimensions on all figures are given multiple to the nominal diameter of the usual link), and length of chain cable

shall comprise an odd number of links.

Where designs do not comply with this and where accessories are welded, relevant drawings shall be submitted to the Register, and the specification shall include full details of the manufacturing process and the heat treatment.

**7.1.3.4** According to the grade of steel, chain cables and accessories shall be supplied in one of the conditions specified in Table 7.1.3.4.

The heat treatment shall be performed prior to mechanical tests and also prior to the breaking load and proof load testing.

*Table 7.1.3.4 Heat treatment of chain cables and accessories*

Steel grade	Condition of supply	
	Chain cable	Accessories
1	As welded or normalized	Not applicable
2 <sup>1</sup>	As welded or normalized	Normalized
3	Normalized, tempered or quenched and tempered	normalized and quenched and tempered

<sup>1</sup> Chain cables made by forging and casting shall be supplied in the normalized condition.

**7.1.3.5** The mechanical properties of the material of a finished chain cable and accessories shall be in accordance with Table 7.1.4.3.3.

**7.1.3.6** Chain cables and accessories shall be manufactured in a manner such as to withstand the proof and breaking loads indicated in Table 7.1.4.1.2 depending on the relevant chain cable grade.

**7.1.3.7** All chain links and accessories shall have a clean surface consistent with the method of manufacture and be free from cracks, notches, inclusions and other defects

impairing the performance of the product. The flashes produced by upsetting or drop forging shall be properly removed. Minor surface defects may be ground off so as to leave a gentle transition to the surrounding surface.

Remote from the crown local grinding up to 5 % of the nominal link diameter or item thickness may be permitted.

**7.1.3.8** The dimensions of stud chain links and accessories shall comply with Figs 7.1.3-1 to 7.1.3.7 and with approved specifications.

The dimensions of studless links shall comply with the requirements of recognised standards, and they are in each case subject to the special consideration of the Register.

**7.1.3.9 Allowable tolerances of chain link dimensions.**

**7.1.3.9.1** Diameter tolerances in the elbow outside the link contact area shall comply with the requirements of Table 7.1.3.9.1.

**7.1.3.9.2** The cross-sectional area of the elbow shall have no negative tolerance.

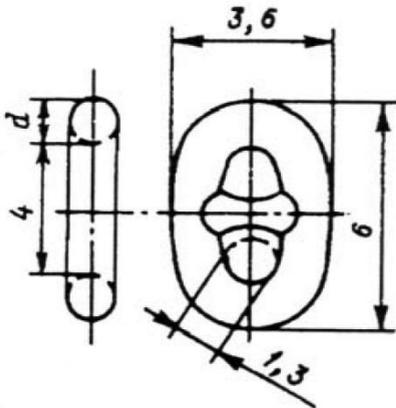


Fig. 7.1.3-1 Common link

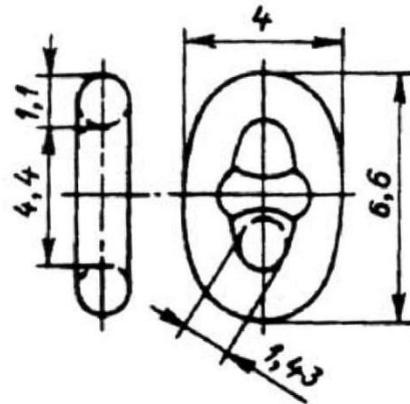


Fig. 7.1.3-2 Enlarged link

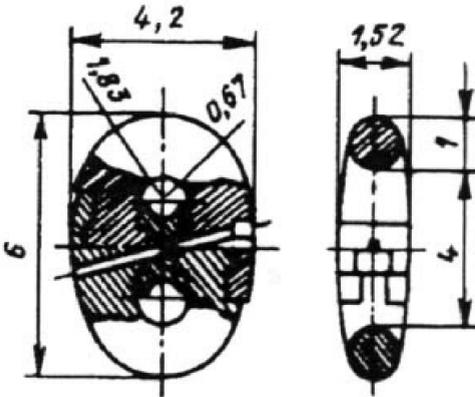


Fig. 7.1.3-4 Kenter joining link

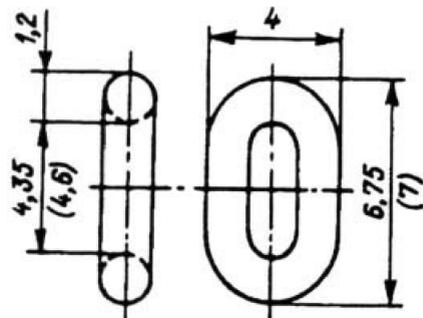


Fig. 7.1.3-3 Studless link

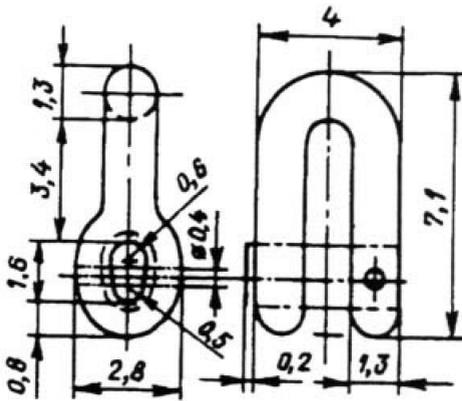


Fig. 7.1.3-5 Joining shackle

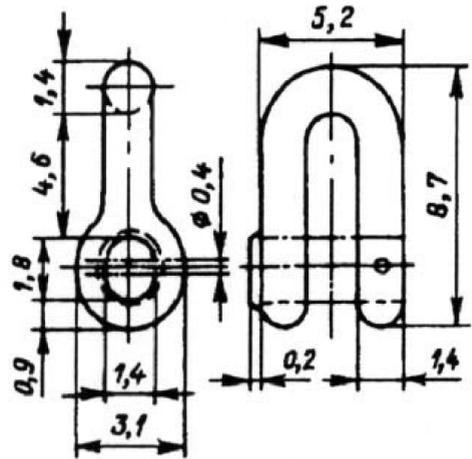


Fig. 7.1.3-6 End shackle

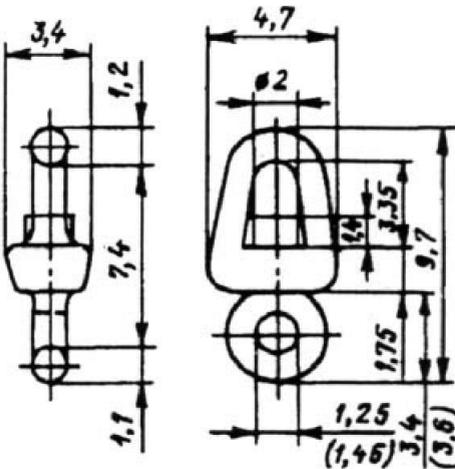


Fig. 7.1.3-7 Swivel

For the purpose of determining the

cross-sectional area the diameter adopted is an arithmetic mean of four values measured at points uniformly distributed along the cross section perimeter.

7.1.3.9.3 The length of the chain cable shall be measured after applying a proof load and, preferably, at the loading of 10 % of the minimal value of the proof load. Measurements shall be performed during elongation of the chain under test load.

7.1.3.9.4 Studs shall be located in the link centrally and perpendicular to longitudinal axis of the link,

although the studs of the final link at each end of any length may also be located off-centre to facilitate the insertion of the Kenter and joining shackles.

Table 7.1.3.9.1 Allowable tolerances of chain link diameter

Nominal link diameter, mm	Allowable tolerances <sup>1</sup> , mm
≤ 40	-1
40-84	-2
84-122	-3
> 122	-4

<sup>1</sup> The plus tolerances shall not exceed 5 % of the nominal diameter.

The following tolerances are permitted provided, that the stud fits

snugly and its ends be practically flush against the inside of the link: maximum off-centre distance  $X$ :

maximum off-centre distance  $X = 10\%$  of the nominal diameter  $d$ ;

maximum deviation from the  $90^\circ$  position  $\alpha = 4^\circ$ .

The tolerances shall be measured in accordance with Fig. 7.1.3.9.4.

**7.1.3.10** The following tolerances are applicable in accessories:

diameter —  $+5-0\%$ ;

other diameter —  $\pm 2.5\%$ .

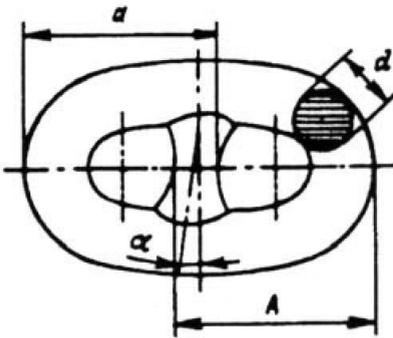


Fig. 7.1.3.9.4

$$X = \frac{A - a}{2}$$

**7.1.3.11** The welding of studs shall be in accordance with procedure approved by the Register subject to the following conditions.

The studs shall be of weldable steel in accordance with 7.1.2.3.

The studs shall be welded at one end only, i.e. opposite to the weldment of the link. The stud ends shall fit the inside of the link without appreciable gap.

The welds, preferably in the downhand position, shall be executed by qualified welders using suitable welding consumables.

*Table 7.1.4.1.2*

All welds shall be carried out before the final heat treatment of the chain cable.

The welds shall be free from defects liable to impair the proper use of the chain cable. Undercuts, end craters and similar defects shall, where necessary, be ground off.

If required by the Register, a procedure for the welding of chain studs shall be effected.

**7.1.4 Testing of finished chain cables.**

**7.1.4.1** Proof and breaking load testing.

**7.1.4.1.1** All finished chain cables shall be subjected to the tests specified below in the presence of a surveyor to the Register.

To ensure the proper visual testing of the chain cable and of its weld in particular, if present, the chain cables shall be submitted for tests free from paint and anti-corrosion media.

The tests shall be conducted on the equipment approved by the relevant competent organizations in the laboratory recognized by the Register and be witnessed by the Register representative.

**7.1.4.1.2** Each chain cable length (27.5 m) shall be subjected to the proof load testing in accordance with the requirements of Table 7.1.4.1.2.

**7.1.4.1.3** For the breaking load test, one sample comprising at least of three links shall be taken from every four length of the chain cable. The links concerned shall be made in a single manufacturing cycle together with the chain cable and be welded and heat-treated together with it. The breaking load according to Table 7.1.4.1.2 shall be maintained for a minimum of 30 seconds.

Test type	Steel grade		
	1	2	3
Proof load, kN	$0.00686d^2 (44 - 0.08d)$	$0.00981d^2 (44 - 0.08d)$	$0.01373d^2 (44 - 0.08d)$
Breaking load, kN	$0.00981d^2 (44 - 0.08d)$	$0.01373d^2 (44 - 0.08d)$	$0.01961d^2 (44 - 0.08d)$

Note: *d* — nominal diameter, mm.

**7.1.4.1.4** If the tensile loading capacity of the testing machine is insufficient to apply one breaking load for chain cables of large diameter, another equivalent testing method shall be agreed with the Register.

**7.1.4.2 Retests.**

**7.1.4.2.1** Shall a breaking load test fail, a further test specimen may be taken from the same length of chain cable and tested. The test shall be considered successful if the requirements are then satisfied.

If the retest fails, the length of chain cable concerned shall be rejected. If the manufacturer so wishes, the remaining three lengths belonging to the unit test quantity may then be individually subjected to test at the breaking load. If one such test fails to meet the requirements, the entire unit test quantity is rejected.

**7.1.4.2.2** Shall a proof load testing fail, the defective link (links) shall be replaced, a local heat treatment to be carried out on the new link (links) and the proof load testing shall be repeated. An investigation shall be made to identify the cause of the failure.

**7.1.4.3** Tensile and impact testing of specimens cut out of a finished chain

cable.

**7.1.4.3.1** For Grade 2 and 3 chain cables, mechanical test specimens shall be taken from every four lengths according to the requirements of Table 7.1.4.3.1.

For forged and cast chain cables, the tests shall be carried out on the metal of each heat and charge (heat treatment).

Sampling is effected according to 3.6.5 and retesting — according to 3.6.5.4.

The Register may require a tensile test transverse to the weld and an impact test with a notch along the weld for specimens taken from the weldment. Testing and retesting are conducted in the presence of the Register representative.

**7.1.4.3.2** For the purpose of test specimen preparation, provision shall be made for an additional link (or where the chain diameter is small, several links) in a length of chain cable.

The additional link shall be manufactured by the same procedure as the specimen for breaking test in accordance with 7.1.4.1.3.

**7.1.4.3.3** The test results shall comply with the requirements of Table 7.1.4.3.3 and shall be indicated in the certificate.

**Table 7.1.4.3.1 Number of mechanical test specimens for finished chain cables and accessories**

			Number of test specimens
--	--	--	--------------------------

Steel grade	Manufacturing method	Condition of	Tensile test for base metal	Impact test, KV	
				Base metal	Welded joint
1	Flush-butt welded	AW, N	Not required	Not required	Not required
2	Flush-butt welded	AW	1	3	3
		N	Not required	Not required	Not required
	Forged or cast	N	1	3 (not required for chain cables)	3
3	Flush-butt welded	N, NT, QT	1	3	3
	Forged or cast	N, NT, QT	1	3	Not applicable

Symbols:

AW — as welded; N — normalized; NT — normalized and tempered; QT — quenched and tempered.

**Table 7.1.4.3.3 Mechanical properties of finished chain cables and accessories**

Steel grade	Yield stress, $R_{eH}$ , N/mm <sup>2</sup> , min	Tensile strength, $R_m$ , N/mm <sup>2</sup>	Elongation, $A_s$ , %, min	Reduction in area, $Z$ , %, min	Charpy V-notch impact test <sup>1</sup> , KV		
					Temperature, °C	Impact energy, J, min	
						Base metal	Welded joint
1	Not required						
2	295	490-690	22	Not required	0	27	27
3	410	690 min	17	40	0	60	50
					-20	35	27

<sup>1</sup> If required by the Register, the impact tests for Grade 3 are carried out at a temperature of -20 °C.

**7.1.4.4** Chain cables shall be marked at both ends of each length, and the marking shall include Certificate number, chain cable grade and the Register stamp.

The arrangement of symbols comprising the marking shall be in accordance with Fig. 7.1.4.4.

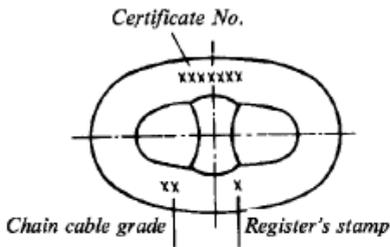


Fig. 7.1.4.4

### 7.1.5 Testing of accessories.

**7.1.5.1** Proof and breaking load testing.

**7.1.5.1.1** All chain cable accessories are subject to the tests below witnessed by the Register representative.

To ensure the proper visual testing, of welded joints in particular, if present, the accessories shall be submitted for tests free from paint and anti-corrosion media.

**7.1.5.1.2** All accessories are proof load tested in accordance with the above requirements and those in Table 7.1.4.1.2.

**7.1.5.1.3** For breaking load test in accordance with Table 7.1.4.1.2, the accessories shall be submitted in batches.

A batch of shackles, swivels, swivel shackles, large links and end links shall comprise not more than 25 items and one consisting of Renter shackles shall comprise 50 items of the same grade and size, which were manufactured from material of the same heat and heat treated in the same furnace charge.

Out of each batch, one item is subjected to the breaking load test and after testing, the use of the items according to the purpose is not permitted.

**7.1.5.1.4** On agreement with the Register, breaking load test may be waived if:

the breaking load is confirmed by the positive results of the initial testing of the item when the manufacturer is approved

by the Register; and

the results of mechanical testing in accordance with 7.1.5.2 are satisfactory for each batch; and

the parts are subjected to non-destructive testing in accordance with the procedure approved by the Register.

**7.1.5.1.5** Notwithstanding the above, at the discretion of the Register, the items, which withstood the tests with a breaking load prescribed for the particular chain cable, may be used for the intended purpose, provided the following conditions were met in manufacturing of the items:

**.1** the material, of which the items are made, meets more severe requirements than those prescribed for the chain cable, with which the items are expected to be used (e.g., material corresponds to Grade 3 where the required Grade is 2);

**.2** the material, of which the items are made, corresponds to the grade required for the item but the item has greater dimensions than those required and has withstood the tests with breaking load at least 1.4 times over the prescribed one.

### 7.1.5.2 Mechanical tests.

**7.1.5.2.1** Unless otherwise stated, forgings and castings after heat treatment shall meet the requirements of Table 7.1.4.3.3. For sampling, castings and forgings of similar dimensions originating from the same heat treatment charge and the same heat of steel may be combined into batches. Testing and retesting shall be witnessed by the Register representative. From each manufacturing batch in one material grade, one tensile test specimen and the set of three-impact test specimens are taken in accordance with Table 7.1.4.1.3.

Specimens are machined in

accordance with 3.6.5; the retests are performed according to 3.6.5.4. Enlarged links and end links need not be tested, provided they are manufactured and heat treated together with the chain cable.

**7.1.5.2.2** The results of the mechanical tests shall comply with the requirements of Table 7.1.4.3.3.

**7.1.5.3** Each item of accessories shall be marked, and the marking shall include the Certificate number, grade and the Register stamp.

### **7.1.6 Chafing chain for emergency towing arrangements.**

#### **7.1.6.1 General.**

The present requirements apply to the chafing chain for chafing gear of emergency towing arrangements (ETA) with specified safe working load of 1,000 kN (ETA 1000) and 2,000 kN (ETA 2000).

Chafing chains other than, those specified are subject to the special consideration by the Register.

**7.1.6.2** Chafing chains shall be manufactured only by the works recognized by the Register according to 7.1.1.2.

**7.1.6.3** The materials used for the manufacture of the chafing chain shall meet the requirements of 7.1.2.

**7.1.6.4** The chafing chain shall be designed, manufactured and tested in accordance with the requirements of 7.1.3 to 7.1.5.

**7.1.6.5** One end of the chafing chain shall be suitable for connection to the strongpoint of a towed vessel, and the other end of the chafing chain shall be fitted with a pear-shaped open link

allowing connection to a shackle (refer to Fig. 7.1.6.5).

**7.1.6.6** The chafing chain for emergency towing arrangements shall be of Grade 2 or 3 and withstand a breaking load of at least twice the safe working load.

For each type of ETA, the nominal diameter of a common link shall be in accordance with Table 7.1.6.6.

#### **7.1.7 Documents.**

Chains complying with the above requirements shall have the Register certificates containing as a minimum the following data: Certificate number; order number; manufacturer's name; grade;

number of the Certificate;

order number;

manufacturer's name;

category;

chemical composition (including the total content of aluminium);

nominal diameter;

test/break load;

heat treatment type;

manufacturing method;

mark of chain;

length;

mechanical properties if needed.

If required,

protocols of tests performed may be attached to the Certificate.

*Table 7.1.6.6*

Type of ETA	Nominal diameter of common link $d$ , mm, min	
	Grade 2	Grade 3
ETA 1000	62	52
ETA 2000	90	76

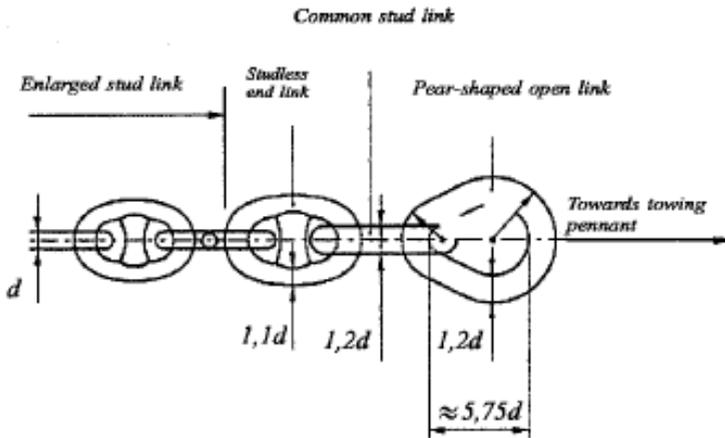


Fig. 7.1.6.5

## 7.2 MOORING CHAIN AND ACCESSORIES

### 7.2.1 General.

**7.2.1.1** The present requirements apply to the materials, design, manufacture and testing of mooring chain and accessories intended to be used for mobile offshore units and fixed offshore platforms.

The present Subsection also includes requirements for chafing chain for single point moorings, FPSO and similar uses.

The accessories covered are as follows: common stud and studless links, connecting common links (splice links), enlarged links, end links, detachable connecting links (shackles), end shackles, swivels and swivel shackles.

Studless link chain is normally deployed only once, being intended for long-term permanent mooring systems with pre-determined design life.

### 7.2.1.2 Chain grades.

Depending on the nominal tensile strength of the steels used for manufacture, chains and accessories shall be subdivided into five grades, i.e.: R3, R3S, R4, R4S

and R5.

Manufacturers' proprietary specifications for R4S and R5 may vary subject to design conditions and the acceptance of the Register.

Each grade shall be individually approved. Approval for a higher grade does not constitute approval of a lower grade.

**7.2.1.3** Recognition of chain manufacturers.

**7.2.1.3.1** Mooring chains and accessories shall be manufactured only by works recognized in accordance with 1.3.1.4.

For this purpose tests shall be carried out, the scope of which shall include proof and breaking load tests, measurements and mechanical tests including fracture mechanics tests.

**7.2.1.3.2** Manufacturers shall submit the information on the works and manufacturing processes;

as well as the following documentation:

bar heating and bending including method, temperatures, temperature control and recording;

flash welding including current, force, time and dimensional variables as well as control and recording of parameters;

flash removal including method and inspection;

stud insertion method, for stud link chain;

heat treatment including furnace types, means of specifying, controlling and recording of temperature and chain speed and allowable limits, quenching bath and agitation, cooling method after exit;

proof and break loading including method/machine, means of horizontal support (if applicable), method of measurement and recording;

non-destructive testing methods;

the manufacturer's surface quality requirement of mooring chain accessories.

**7.2.1.3.3** For initial approval CTOD tests shall be carried out on the particular mooring chain material.

CTOD tests shall be performed in accordance with a recognized standard such as BS 7448, Parts 1 and 2.

The CTOD specimen shall be a standard  $2 \times 1$  single edge notched bend specimen.

Test location as shown in Fig. 7.2.1.3.3.

The minimum test specimen size shall be  $50 \times 25$  mm for chain diameters up to 120 mm, and  $80 \times 40$  mm for diameters above 120 mm.

CTOD specimens shall be taken from both the side of the link containing the weld and from the opposite side; apex of crack shall cross the weld metal.

Three links shall be selected for testing. The tests shall be taken at  $-20$  °C and the results submitted for review. The tests shall meet the minimum CTOD values indicated in Table 7.2.1.3.3.

**7.2.1.3.4** Calibration of furnaces shall be verified by measurement and recording of a calibration specimen with dimensions equivalent to the maximum size of link manufactured.

Thermocouples shall be placed both on the surface and in a drilled hole located to the mid thickness position of the calibration block.

**7.2.1.3.5** For R4S and R5 chain and accessories, prior to approval, the manufacturer shall undertake experimental tests or have relevant supporting data to develop the chain and accessory material.

The tests and data may include: fatigue tests, hot ductility tests (no internal flaws shall develop whilst bending in the link forming temperature range), welding parameter research, heat treatment study, strain age resistance, temper embrittlement study, stress corrosion cracking data and hydrogen embrittlement study, using slow strain specimens in hydrated environments.

Reports indicating the results of experimental tests shall be submitted.

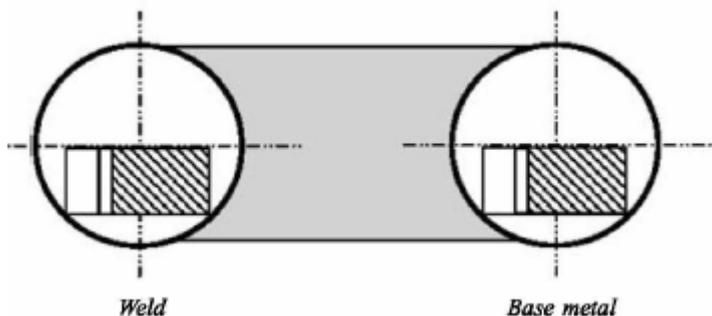


Fig. 7.2.1.3.3. Test location

Table 7.2.1.3.3

Grade of chain	R3, mm		R3S, mm		R4, mm		R4S and R5, mm	
	Base metal	Weld metal	Base metal	Weld metal	Base metal	Weld metal	Base metal	Weld metal
Stud links	0.20	0.10	0.22	0.11	0.24	0.12	0.26	0.13
Studless links	0.20	0.14	0.22	0.15	0.24	0.16	0.26	0.17

**7.2.1.4** Approval of quality system at chain and accessory manufacturers.

Chain and accessory manufacturers shall have a documented and effective quality system approved by the Register.

The provision of such system is required in addition to, and not in lieu of, the witnessing of tests by a surveyor as specified in 7.2.2 to 7.2.5.

**7.2.1.5** Recognition of bar manufacturers. Rolled bar for chains.

**7.2.1.5.1** Bar materials intended for chain and accessories shall be manufactured only by works approved by the Register and holding a Recognition Certificate for Manufacturer (refer to 1.3.1.4 and 3.6).

The recognition is limited to a nominated supplier of bar material.

If a chain manufacturer wishes to use material from a number of suppliers,

separate recognition tests shall be carried out for each supplier.

**7.2.1.5.2** The Recognition Certificate for Manufacturer may be issued to a rolled products supplier only after successful testing of the completed chain.

The Recognition Certificate for Manufacturer will normally be limited up to the maximum diameter equal to that of the chain diameter tested.

The rolling reduction ratio shall be recorded in the Recognition Certificate for Manufacturer and shall be at least 5:1. The rolling reduction ratio used in production can be higher, but shall not be lower than that qualified.

**7.2.1.5.3** The steelmaker shall submit a specification of the chemical composition of the bar material, which shall be approved by the Register and by the chain manufacturer.

For Grade R4, R4S and R5 chain the steel shall contain a minimum of 0.20 % molybdenum.

**7.2.1.5.4** A heat treatment sensitivity study simulating chain production conditions shall be applied in order to verify mechanical properties and establish limits for temperature and time combinations. Mechanical properties and establish limits for temperature and time combinations shall be confirmed.

**7.2.1.5.5** The bar manufacturer shall provide evidence that the manufacturing process produces material that is resistant to strain ageing, temper embrittlement and for R4, R4S and R5, hydrogen embrittlement.

All test details and results shall be submitted to the Register.

**7.2.1.6** Recognition of forgings and castings manufacturers. Accessories.

**7.2.1.6.1** Forgings and castings manufacturers intended to supply finished or semi-finished accessories shall be recognized by the Register and shall hold the Recognition Certificate for Manufacturer (refer to 1.3.1.4 and 3.6).

A description of manufacturing processes and process controls shall be submitted to the Register. The scope of recognition is determined by the manufacturer on agreement with the Register.

The Recognition shall be limited to a nominated supplier of forged or cast material.

If an accessory manufacturer wishes to use material from a number of suppliers, a separate recognition shall be carried out for each supplier.

**7.2.1.6.2** The Recognition Certificate for Manufacturer may be issued to a supplier of forgings and castings only after

the successful testing of the completed accessory.

The Recognition Certificate for Manufacturer shall normally be limited to the type of accessory and the designated mooring grade of material up to the maximum diameter or thickness equal to that of the completed accessory used for qualification.

Types of qualified accessories and correspondent material grades shall also be specified in the Recognition Certificate for Manufacturer.

The Certificate shall also specify the maximum diameter of pins for accessories.

Individual accessories of complex geometries are subject to special consideration by the Register.

#### **7.2.1.6.3 Forgings.**

The forging reduction ratio, used in the qualification tests, from cast ingot/slab to forged component shall be recorded. The forging reduction ratio used in production can be higher, but shall not be lower than that qualified.

**7.2.1.6.4** Forgings and castings manufacturers shall submit a specification of the chemical composition of the forged or cast material, which shall be approved by the Register.

For Grade R4, R4S and R5 chain the steel shall contain a minimum of 0.20 % molybdenum.

**7.2.1.6.5** Forgings and castings manufacturers shall provide evidence that the manufacturing process produces material that is resistant to strain ageing, temper embrittlement and for R4, R4S and R5 grades, hydrogen embrittlement.

A heat treatment sensitivity study simulating chain production conditions shall be applied in order to verify

mechanical properties and establish limits for temperature and time combinations. A heat treatment sensitivity study simulating accessory production conditions shall be applied in order to verify mechanical properties and establish limits for temperature and time combinations (cooling after tempering shall be appropriate to avoid temper embrittlement).

All test details and results shall be submitted to the Register.

**7.2.1.6.6** For initial approval CTOD tests shall be carried out on the particular mooring grade of material.

Three CTOD tests shall be carried out in accordance with a recognized standard such as BS 7448, Parts 1 and 2.

The CTOD specimen shall be a standard  $2 \times 1$  single edge notched bend specimen. Test location as shown in Fig. 7.2.1.3.3.

The minimum test specimen size shall be  $50 \times 25$  mm for chain diameters up to 120 mm, and  $80 \times 40$  mm for diameters above 120 mm.

CTOD specimens shall be taken from both the side of the link containing the weld and from the opposite side; apex of crack shall cross the weld metal.

The tests shall be taken at  $-20$  °C and the results submitted for review. Test results shall be provided to the Register for review.

**7.2.1.6.7** Calibration of furnaces shall be verified by measurement and recording of a calibration specimen with dimensions equivalent to the maximum size of link manufactured.

Thermocouples shall be placed both on the surface and in a drilled hole located to the mid thickness position of the calibration block.

**7.2.1.6.8** The requirements of 7.2.1.3.5 are applicable to Grades R4S and R5.

**7.2.1.7** Approval of quality system at accessory manufacturers.

**7.2.1.7.1** In accordance with the requirements of **7.2.1.4**.

## **7.2.2 Materials.**

### **7.2.2.1 General.**

**7.2.2.1.1** These requirements apply to rolled steels, forgings and castings used for the manufacture of mooring chain and accessories for mobile offshore drilling units and fixed offshore platforms.

### **7.2.2.2 Rolled steel bars.**

#### **7.2.2.2.1 Steel manufacture.**

**7.2.2.2.1.1** The steels shall be manufactured by basic oxygen, electric furnace or such other process approved by the Register. All steel shall be killed and fine grain treated. The austenitic grain size shall be 6 or finer in accordance with ASTM E 112.

**7.2.2.2.1.2** Steel for bars intended for R4S and R5 chain shall be vacuum degassed.

**7.2.2.2.1.3** For R4S and R5 chain the following information shall be supplied by the bar manufacturer to the mooring chain manufacturer and the results included in the chain documentation:

a) each heat shall be examined for non-metallic inclusions.

The level of micro inclusions shall be quantified and assessed; to be sure inclusion levels are acceptable for the final product;

b) a sample from each heat shall be macroetched according to ASTM E381 or national equivalent, to be sure there is no injurious segregation or porosity;

c) jominy hardenability data, according to ASTM A255 or national

equivalent, shall be supplied with each heat.

The results of the above tests are to be included in the chain documentation.

**7.2.2.2.2 Chemical composition.**

**7.2.2.2.2.1** For any tests under the Register technical supervision, the chemical composition of ladle samples of each heat shall be determined by the steel maker and shall meet the requirements of the Register-approved specification or a standard.

**7.2.2.2.3 Mechanical properties.**

**7.2.2.2.3.1** One (1) bar of the same nominal diameter is to be presented for test in batches of 50 t or fraction thereof from the same heat.

Test specimens shall be taken from material heat treated in the same manner as intended for the finished chain.

**7.2.2.2.3.2** Each batch of Grade R3S, R4, R4S and R5 steel bars shall be tested for hydrogen embrittlement.

In case of continuous casting, test specimens representing both the beginning and the end of the charge shall be taken.

In case of ingot casting, test samples representing two different ingots shall be taken.

**7.2.2.2.3.2.1** Two tensile test specimens shall be taken from the central region of bar material which has been subjected to the heat treatment cycle intended to be used in production.

A specimen with a diameter of 20 mm is preferred (consideration may be given to a diameter of 14 mm).

**7.2.2.2.3.2.2** One of the specimens shall be tested within a maximum of 3 hours after manufacturing (for a 14 mm diameter specimen, the time limit is 1.5 hours).

Where this is not possible, the specimen shall be immediately cooled to  $-60\text{ }^{\circ}\text{C}$  after machining and kept at that temperature for a maximum period of 5 days.

**7.2.2.2.3.2.3** The second specimen shall be tested after baking at  $250\text{ }^{\circ}\text{C}$  for **4 hours**, alternatively 2 hours for 14 mm diameter specimen.

**7.2.2.2.3.2.4** A slow strain rate  $< 0.0003\text{ s}^{-1}$  shall be used during the entire test (this is approximately 10 minutes for the 20 mm diameter specimen). Tensile strength, elongation and reduction in area shall be reported.

**7.2.2.2.3.2.5** The acceptance requirement for the test is

$$Z_1/Z_2 \geq 0.85,$$

where:

$Z_1$  — reduction of area without baking;

$Z_2$  — reduction of area after baking.

If the requirement  $Z_1/Z_2 \geq 0.85$  is not achieved, the bar material may be subjected to a hydrogen degassing treatment on agreement with the Register. New tests shall be performed after degassing.

**7.2.2.2.3.3** For all grades, one tensile and three Charpy V-notch specimens shall be taken from each sample selected.

The test specimens shall be taken at approximately  $1/6$  diameter below the surface, as shown in Fig. 7.2.2.2.3.3 and prepared in accordance with the Section 2 requirements.

The results of all tests shall be in accordance with the appropriate requirements of Table 7.2.2.2.3.3.

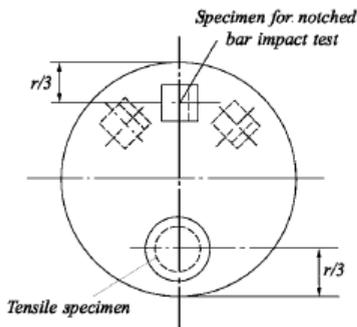


Fig. 7.2.2.2.3.3 Arrangement of specimens. Rod, forging, casting, bar.

Table 7.2.2.2.3.3 Mechanical properties of mooring chain and accessories

Grade	Yield stress, $R_{eH}$ , N/mm <sup>2</sup> , min	Tensile strength, $R_m$ , N/mm <sup>2</sup>	Elongation, $A_s$ , % , min	Reduction in area, $Z$ , % , min	Impact tests, KV		
					Temperature, °C	Average impact energy value, J, min	
						Base metal	Welded joint
R3	410	690	17	50	0	60	50
					-20	40	30
R3S	490	770	15	50	0	65	53
					-20	45	33
R4	580	880	12	50	-20	50	36
R4S	700	960	12	50	-20	56	40
R5	760	1000	12	50	-20	58	42

1. Aim value of yield to tensile ratio: 0.92, max.

At the option of the Register the impact test

(KV) of Grade R3 and R3S may be carried out at either 0 or -20 °C.

3.Reduction in area of cast steel shall be

for Grades R3 and R3S: min 40 %;

for R4, R4S and R5: min 35 % (refer to 7.2.2.4.4).

Aim maximum hardness for R4S is HB330 and for R5 HB340.

**7.2.2.2.4 Dimensional tolerances.**

**7.2.2.2.4.1** Unless otherwise agreed, the diameter and roundness shall be within the tolerances specified in Table 7.2.2.2.4.1

**7.2.2.2.5** Non-destructive testing and repair.

**7.2.2.2.5.1** Non-destructive testing shall be performed in accordance with the standards recognized by the Register.

Non-destructive testing procedures, together with rejection/acceptance criteria shall be submitted to the Register for agreement.

**7.2.2.2.5.2** Non-destructive testing operators shall be appropriately qualified

(to a minimum level II in accordance with recognized standards such as ISO 9712, SNT-TC-1A, EN 473 or ASNT) in the method of non-destructive testing.

Table 7.2.2.2.4.1

Nominal diameter, mm	Tolerance on diameter, mm	Tolerance on roundness, (d <sup>max</sup> — d <sup>min</sup> ), mm
< 25	-0 +1.0	0.6
25-35	-0 +1.2	0.8
36-50	-0 +1.6	1.1
51-80	-0 +2.0	1.5
81-100	-0 +2.6	1.95
101-120	-0 +3.0	2.25
121-160	-0 +4.0	3.00
161-210	-0 +5.0	4.009

**7.2.2.2.5.3** 100 % of bar material intended for either chain or fittings shall be subjected to ultrasonic testing at an appropriate stage of the manufacture.

The bars shall be free of pipe, cracks and flakes.

**7.2.2.2.5.4** 100 % of the bar material shall be tested by magnetic particle or eddy current methods.

The bars shall be free of injurious surface imperfections such as seams, laps and rolled-in mill scale. Provided that their depth is not greater than 1 % of the bar diameter, longitudinal discontinuities may be removed by grinding and blending to a smooth contour.

**7.2.2.2.5.5** The frequency of non-destructive testing may be reduced at the discretion of the Register provided it is verified by statistical means that the required quality is consistently achieved.

#### **7.2.2.2.6** Marking.

**7.2.2.2.6.1** Each bar shall be stamped with the steel grade designation and the charge number (or a code indicating the charge number) on one of the end surfaces.

Other marking methods may be accepted subject to agreement with the Register.

**7.2.2.3** Forged steel.

**7.2.2.3.1** Manufacture.

**7.2.2.3.1.1** Forged steels used for the manufacture of accessories shall be in compliance with the requirements of the Register-approved documentation with specifications and test reports.

Steel shall be manufactured by basic oxygen, electric furnace or such other process as may be specially approved by the Register. All steel shall be killed and fine grain treated. The austenitic grain size shall be 6 or finer in accordance with ASTM E 112.

**7.2.2.3.1.2** Steel for forgings intended for R4S and R5 chain shall be vacuum degassed.

**7.2.2.3.1.3** For steel intended for R4S and R5 accessories the following information shall be supplied by the steel manufacturer to the accessory manufacturer:

a) each heat shall be examined for non-metallic inclusions.

The level of micro inclusions shall be quantified and assessed; to be sure inclusion levels are acceptable for the final product;

b) a sample from each heat shall be macroetched according to ASTM E381 or national equivalent, to be sure there is no injurious segregation or porosity;

c) jominy hardenability data, according to ASTM A255 or national equivalent, shall be supplied with each heat.

The results of the above tests are to be included in the accessory documentation.

**7.2.2.3.2** Chemical composition (refer to 7.2.2.2.2).

**7.2.2.3.3** Heat treatment.

**7.2.2.3.3.1** Finished forgings shall be properly heat treated in compliance with specification submitted and approved.

**7.2.2.3.4** Mechanical properties.

**7.2.2.3.4.1** When properly heat treated, the forgings shall comply with the mechanical properties given in Table 7.2.2.2.3.3.

**7.2.2.3.5** Mechanical tests.

**7.2.2.3.5.1** Forgings for testing are submitted in batches.

For test sampling, forgings of similar dimensions (diameters do not differ by more than 25 mm) originating from the same heat treatment charge and the same heat of steel shall be combined into one test unit.

From each test unit one tensile and three impact test specimens shall be taken and tested.

The specimens shall be located according to Fig. 7.2.2.2.3.3 and the requirements of Section 2.

**7.2.2.3.6** Ultrasonic testing.

**7.2.2.3.6.1** Ultrasonic testing shall be performed in accordance with the standards recognized by the Register. Non-destructive testing procedures, together with rejection/acceptance criteria shall be submitted to the Register for agreement.

**7.2.2.3.6.2** Ultrasonic testing operators shall be appropriately qualified (to a minimum level II in accordance with recognized standards such as ISO 9712, SNT-TC-1A, EN 473 or ASNT) in the method of non-destructive testing.

**7.2.2.3.6.3** 100 % of forgings shall be subjected to ultrasonic testing at an appropriate stage of the manufacture and in compliance with the specification approved by the Register.

**7.2.2.3.7** Marking (refer to 7.2.2.2.6).

**7.2.2.4** Cast steel.

**7.2.2.4.1** Manufacture.

**7.2.2.4.1.1** Cast steels used for the manufacture of accessories shall be in compliance with the requirements of the Register-approved documentation with specifications and test reports.

Steel shall be manufactured by basic oxygen, electric furnace or such other process as may be specially approved by the Register. All steel shall be killed and fine grain treated.

The austenitic grain size shall be 6 or finer in accordance with ASTM E 112.

**7.2.2.4.1.2** Steel for castings intended for R4S and R5 accessories shall be vacuum degassed.

**7.2.2.4.1.3** For steel intended for R4S and R5 accessories the following information shall be supplied by the steel manufacturer to the accessory manufacturer:

a) each heat shall be examined for non-metallic inclusions.

The level of micro inclusions shall be quantified and assessed; to be sure inclusion levels are acceptable for the final product;

b) a sample from each heat shall be macro etched according to ASTM E381 or national equivalent, to be sure there is no injurious segregation or porosity;

c) jominy hardenability data, according to ASTM A255 or national equivalent, shall be supplied with each heat.

The results of the above tests are to be included in the accessory documentation.

**7.2.2.4.2** Chemical composition (refer to 7.2.2.2.2)

**7.2.2.4.3** Heat treatment.

**7.2.2.4.3.1** All castings shall be properly heat treated in compliance with specifications submitted and approved.

**7.2.2.4.4** Mechanical properties.

**7.2.2.4.4.1** The castings after heat treatment shall comply with the mechanical properties given in Table 7.2.2.2.3.3.

The acceptance requirement for reduction in area is, however, reduced to 40 % for grades R3 and R3S, and 35 % for grades R4, R4S and R5.

**7.2.2.4.5** Mechanical tests.

**7.2.2.4.5.1** For test sampling, castings shall be combined into one test unit.

These castings shall be of similar dimensions and originate from the same heat treatment charge and the same heat of steel.

From each test unit one tensile and three impact test specimens shall be taken and tested.

The specimens shall be located according to Fig. 7.2.2.2.3.3 and the requirements of Section 2.

**7.2.2.4.6** Ultrasonic testing.

**7.2.2.4.6.1** Ultrasonic testing shall be performed in accordance with the standards recognized by the Register. Non-destructive testing procedures, together with rejection/acceptance criteria shall be submitted to the Register for agreement.

**7.2.2.4.6.2** Ultrasonic testing operators shall be appropriately qualified (to a minimum level II in accordance with recognized standards such as ISO 9712,

SNT-TC-1A, EN 473 or ASNT) in the method of non-destructive testing.

**7.2.2.4.6.3** 100 % of castings shall be subjected to ultrasonic testing at an appropriate stage of the manufacture and in compliance with the specification approved by the Register.

**7.2.2.4.7** Marking (refer to 7.2.2.2.6).

**7.2.2.5** Materials for studs.

**7.2.2.5.1** Studs intended for stud link chain cable shall be made of steel corresponding to that of the chain or in compliance with specification submitted and approved by the Register.

In general, the carbon content shall not exceed 0.25 % if the studs shall be welded in place.

## **7.2.3 Design and chain manufacture.**

**7.2.3.1** Design.

**7.2.3.1.1** Drawings accompanied by design calculations, giving the detailed design of chain and accessories made by, or supplied through, the chain manufacturer shall be submitted to the Register for approval.

Drawings shall be submitted by the supplier or the manufacturer of the chain and its accessories. Typical designs are given in ISO 1704.

For studless chain the shape and proportions shall comply with the requirements of the present Section.

Other studless proportions shall be specially approved by the Register. It shall be considered that new or non-standard designs of chain, shackles or fittings, may require a fatigue analysis and possible performance, fatigue or corrosion fatigue testing.

**7.2.3.1.2** In addition, for stud link chain, drawings showing the detailed

design of the stud shall be submitted for information.

The stud shall give an impression in the chain link which is sufficiently deep to secure the position of the stud, but the combined effect of shape and depth of the impression shall not cause any harmful notch effect or stress concentration in the chain link.

**7.2.3.1.3** Machining of Renter shackles shall result in a fillet radius minimum 3 % of a nominal link diameter.

**7.2.3.2** Chain cable manufacturing process.

**7.2.3.2.1** General.

**7.2.3.2.1.1** Offshore mooring chains shall be manufactured in continuous lengths by flash butt welding and shall be heat treated in a continuous furnace; batch heat treatment is not permitted.

Thermal processing shall be implemented in the passage furnace. Heat treatment of batches shall not be allowed.

**7.2.3.2.1.2** The use of joining shackles to replace defective links is subject to the written approval of the end purchaser in terms of the number and type permitted.

The use of connecting common links is restricted to 3 links in each 100 m of chain.

**7.2.3.2.2** Chain cable manufacturing process records.

**7.2.3.2.2.1** Records of bar heating, flash welding and heat treatment shall be made available for inspection by the Register.

**7.2.3.2.3** Bar heating.

**7.2.3.2.3.1** For electric resistance heating, the heating phase shall be controlled by an optical heat sensor. The controller shall be checked at least once every 8 hours and records made.

**7.2.3.2.3.2** For furnace heating, the heat shall be controlled and the temperature continuously recorded using thermocouples in close proximity to the bars. The temperature of thermocouples shall be accepted as the temperature of the bar. The controls shall be checked at least once every 8 hours and records made.

**7.2.3.2.4** Flash welding of chain cable.

**7.2.3.2.4.1** The following welding parameters shall be controlled during welding of each link:

platen motion;  
current as a function of time;  
hydraulic pressure.

**7.2.3.2.4.2** The controls shall be checked at least every 4 hours and records made.

**7.2.3.2.5** Heat treatment of chain cable.

**7.2.3.2.5.1** Chain shall be austenitized, above the upper transformation temperature, at a combination of temperature and time within the limits established by the manufacturer.

**7.2.3.2.5.2** When applicable, chain shall be tempered at a combination of temperature and time within the limits established by the manufacturer.

Cooling after tempering shall be appropriate to avoid temper embrittlement.

**7.2.3.2.5.3** Temperature and time or temperature and chain speed shall be controlled and continuously recorded.

**7.2.3.2.6** Mechanical properties.

**7.2.3.2.6.1** The mechanical properties of finished chain and accessories shall be in accordance with Table 7.2.2.2.3.3. The specimens shall be located according to Fig. 7.2.3.2.6.1.

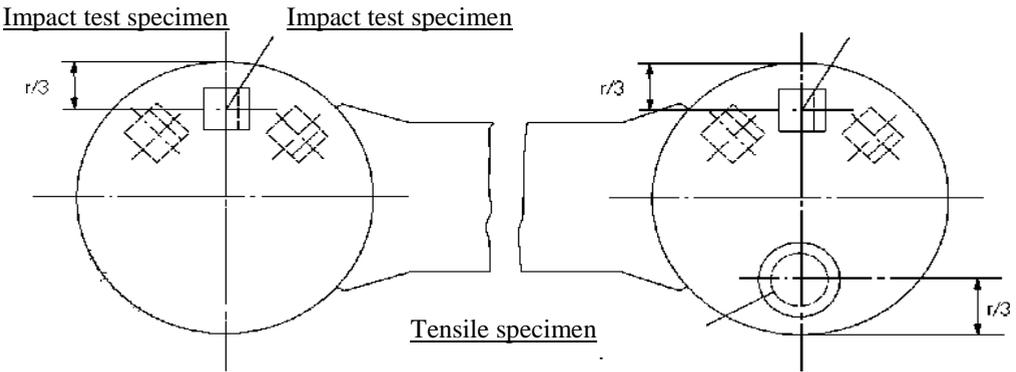


Fig. 7.2.3.2.6.1  
Arrangement of specimens. Links of chain

**7.2.3.2.7** Proof and breaking test loads.

**7.2.3.2.7.1.** Chains and accessories shall withstand the proof and break test loads given in Table 7.2.3.2.7.1.

**7.2.3.2.8** Non-destructive testing.

**7.2.3.2.8.1** All finished chains shall have a proper quality to be ensured by the manufacturer.

Each link shall be subjected to non-destructive testing in compliance with 7.2.4.5 using the Register-approved procedures.

**7.2.3.2.9** Dimensions and dimensional tolerances.

**7.2.3.2.9.1** The shape and proportion of links and accessories shall conform to ISO 1704:1991 or the relevant documentation approved by the Register.

**Table 7.2.3.2.7.1** Formulae for calculating test and break loads, weight, and length of the five-link specimen

Load, kN	Grade R3 (stud link)	Grade R3S (stud link)	Grade R4 (stud link)	Grade R4S (stud link)	Grade R5 (stud link)
Test	$0.0148d^2(44 - 0.08d)$	$0.0180d^2(44 - 0.08d)$	$0.0216d^2(44 - 0.08d)$	$0.0240d^2(44 - 0.08d)$	$0.0251d^2(44 - 0.08d)$
Break	$0.0223d^2(44 - 0.08d)$	$0.0249d^2(44 - 0.08d)$	$0.0274d^2(44 - 0.08d)$	$0.0304d^2(44 - 0.08d)$	$0.0320d^2(44 - 0.08d)$
Load, kN	Grade R3 (studless link)	Grade R3S (studless link)	Grade R4 (studless link)	Grade R4S (studless link)	Grade R5 (studless link)
Test	$0.0148d^2(44 - 0.08d)$	$0.0174d^2(44 - 0.08d)$	$0.0192d^2(44 - 0.08d)$	$0.0213d^2(44 - 0.08d)$	$0.0223d^2(44 - 0.08d)$
Break	$0.0223d^2(44 - 0.08d)$	$0.0249d^2(44 - 0.08d)$	$0.0274d^2(44 - 0.08d)$	$0.0304d^2(44 - 0.08d)$	$0.0320d^2(44 - 0.08d)$
Chain weight, kg/m	Studded link = $0.0219d^2$				
Chain weight, kg/m	Studless link The weight shall be calculated for each type of construction and shall be provided for consideration.				

Specimen of the chain being measured	Five links
Maximum	22 <i>d</i>
Minimum	22.55 <i>d</i>

**7.2.3.2.9.2** The following tolerances are applicable to links:

**.1** diameter measured at the crown:

- < 40 mm — 1 mm;
- 40-84 mm — 2 mm;
- 84-122 mm — 3 mm;
- 122-152 mm — 4 mm;
- 152-184 mm — 6 mm;
- 184-210 mm — 7.5 mm.

The plus tolerance may be up to 5 % of the nominal diameter.

The cross sectional area at the crown shall have no negative tolerance;

**.2** diameter measured at locations other than the crown:

the diameter shall have no negative tolerance;

the plus tolerance may be up to 5 % of the nominal diameter.

The approved manufacturer's specification is applicable to the plus tolerance of the diameter at the flash butt weld;

**.3** the allowable manufacturing tolerance on a length of five links shall not exceed 2.5 %, and shall not be negative;

**.4** all other dimensions are subject to a manufacturing tolerance up to 2.5 %, provided always that all parts fit together properly;

**.5** the tolerances for stud link and studless common links shall be measured in accordance with Table 7.2.3.2.9.2-1 and Fig. 7.2.3.2.9.2-1 and Table 7.2.3.2.9.2-2 and Fig. 7.2.3.2.9.2-2 respectively;

**.6** for stud link chains, the studs shall be located in the links centrally and at right angles to the sides of the link. The tolerances are determined in compliance with Table 7.2.3.2.9.2-1 and Fig. 7.2.3.2.9.2-1 provided that the stud fits snugly and its ends be flush against the inside of the link.

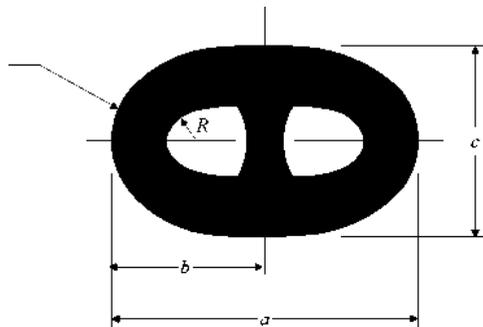


Fig. 7.2.3.2.9.2-1

Studded link — inside radius, R, and outside radius shall be constant.

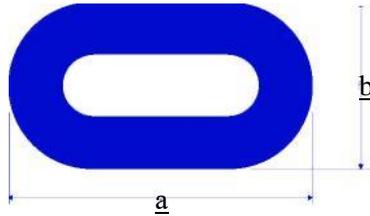


Fig. 7.2.3.2.9.2-2

Studless link — inside radius,  $R$ , and outside radius shall be constant.

**7.2.3.2.10** Stud link chain — welding of studs.

**7.2.3.2.10.1** A welded stud may be accepted for grade R3 and R3S chains.

Welding of studs in grades R4, R4S and R5 chain is not permitted unless specially approved by the Register.

**7.2.3.2.10.2** Where studs are welded into the links this shall be completed before the chain is heat treated.

**7.2.3.2.10.3** The stud ends shall be a good fit inside the link and the weld shall

be confined to the stud end opposite to the flash butt weld.

The full periphery of the stud end shall be welded unless otherwise approved.

**7.2.3.2.10.4** Welding of studs both ends is not permitted unless specially approved by the Register.

**7.2.3.2.10.5** The welds shall be made by qualified welders using the Register-approved procedure and low-hydrogen approved consumables.

*Table 7.2.3.2.9.2-1 Ratio of dimensions, tolerances of studded chains*

Dimensions (Fig. 7.2.3.2.9.2-1), cm	Parameters	Nominal dimension	Negative tolerance	Positive tolerance
a	Link length	6d	0.15d	0.15d
b	Link half length	$a^*/2$	0.1d	0.1d
c	Link width	3.6d	0.09d	0.09d
e	Axis deviation	0 deg	4 deg	4 deg
R	Inside radius	0.65d	0	—

Notes: d — nominal diameter of the chain;

$a^*$  — the actual length of the link.

*Table 7.2.3.2.9.2-2 Ratio of dimensions, tolerances of studless chains*

Dimensions (Fig. 7.2.3.2.9.2-2), cm	Parameters	Nominal dimension	Negative tolerance	Positive tolerance
a	Link length	6d	0.15d	0.15d
b	Link width	3.35d	0.09d	0.09d
R	Inside radius	0.60d	0	—

Notes: 1.d — nominal diameter of the chain.

2. Other dimension ratios are subject to special agreement with the Register.

**7.2.3.2.10.6** The size of the fillet weld shall as a minimum be as per API Specification 2F (refer to Fig. 7.2.3.2.10.6).

**7.2.3.2.10.7** The welds shall be of good quality and free from defects such as cracks, lack of fusion, gross porosity and undercuts exceeding 1 mm.

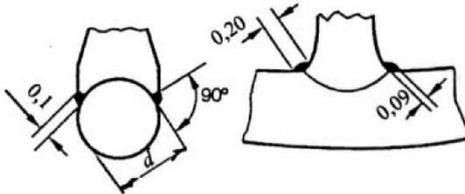


Fig. 7.2.3.2.10.6

**7.2.3.2.10.8** All stud welds shall be visually tested.

In addition, at least 10 % of all welds shall be controlled with the use of magnetic or coloured non-destructive test after a trial load test.

If unacceptable defects are found, all stud welds in that length shall be examined.

**7.2.3.2.11** Connecting common links (splice links).

**7.2.3.2.11.1** Single links to substitute for test links or defective links without the necessity for reheat treatment of the whole length shall be made in accordance with the Register-approved procedure.

Separate approvals are required for each grade of chain and the tests shall be made on the maximum size of chain for which approval is sought.

**7.2.3.2.11.2** Manufacture and heat treatment of connecting common link shall not affect the properties of the adjoining links.

The temperature reached by these links shall nowhere exceed 250 °C.

**7.2.3.2.11.3** Each link shall be subjected to the appropriate proof load and non-destructive testing as detailed in Table 7.2.3.2.7.1 and in 7.2.4.5 respectively.

A second link shall be made identical to the connecting common link; the link shall be tested per 7.2.4.4 and 7.2.4.5.

**7.2.3.2.11.4** Each connecting common link shall be marked either:

on the stud for stud link chain or;

on the outer straight length on the side opposite the flash butt weld for studless chain.

This marking shall be in accordance with 7.2.4.7 plus a unique number for the link.

The adjoining links shall also be marked on the studs or straight length as above.

**7.2.4** Testing of finished chain.

**7.2.4.1** General.

**7.2.4.1.1** The present requirements apply to, but are not limited to common stud and studless links, end links, enlarged end links and connecting common links (splice links).

**7.2.4.1.2** All chain shall be subjected to proof load tests, sample break load tests and sample mechanical tests after final heat treatment in the presence of the Register representative.

Where the manufacturer has a procedure to record proof loads and the Register representative is satisfied with the adequacy of the recording system, he need not witness all proof load tests.

The Register representative shall satisfy himself that the testing machines are calibrated and maintained in a satisfactory condition.

Prior to testing and inspection the chain shall be free from scale, paint or other coating. The chain shall be sand- or shot blasted to meet this requirement.

**7.2.4.2 Proof and break load tests.**

**7.2.4.2.1** The entire length of chain shall withstand the proof load specified in Table 7.2.3.2.7.1 without fracture and shall not crack in the flash weld. The load applied shall not exceed the proof load by more than 10 % when stretching the chain.

Where plastic straining is used to set studs, the applied load shall not be greater than that qualified in the initial chain tests during recognition of the manufacturer.

**7.2.4.2.2** A break-test specimen consisting of at least 3 links shall be either taken from the chain or produced at the same time and in the same manner as the chain.

The test frequency shall be based on tests at sampling intervals according to Table 7.2.4.2.2 provided that every cast is represented. Each specimen shall be capable of withstanding the break load specified without fracture and shall not crack in the flash weld.

It shall be considered acceptable if the specimen is loaded to the value specified in Table 7.2.3.2.7.1 and maintained at that load for 30 seconds without breaking and cracking in weldments.

**Table 7.2.4.2.2 Length of a chain link for the selection of specimens for testing**

Chain diameter, mm	Length of a link of the chain, m
Min — 48	91

49-60	110
61-73	131
74-85	152
86-98	175
99-111	198
112-124	222
125-137	250
138-149	274
150-162	297
163-175	322

**7.2.4.2.3** For chain with a diameter in excess of 100 mm, links of the same chain can be used as alternative specimens for tensile strength in agreement with the Register. Upon agreeing, data that confirm the possibility of the use of the alternative shall be provided.

During tests of alternative specimens, each of them shall represent a single casting.

The test frequency shall be in accordance with Table 7.2.4.2.2

**7.2.4.2.4** If the loading capacity of the testing machine is insufficient, another equivalent method shall be agreed with the Register.

**7.2.4.3** Dimensions and dimensional tolerances.

**7.2.4.2.3.1** After proof load testing measurements shall be taken on at least 5 % of the links in accordance with 7.2.3.2.7.1.

**7.2.4.2.3.2** The entire chain shall be checked for the length, five links at a time. By the five link check the first five links shall be measured. From the next set of five links, at least two links from the previous five links set shall be included. This procedure shall be followed for the entire chain length.

The measurements shall be taken preferably while the chain is loaded to 5 to 10 % of the minimum proof load.

**7.2.4.4** Mechanical tests of finished chain material.

**7.2.4.4.1** Links of samples detached from finished, heat treated chain shall be sectioned for determination of mechanical properties. From each test unit one tensile and nine impact test specimens shall be taken and tested:

one specimen for tension testing and one set of test specimens for impact bending: from the section of the link that is opposite to the weld joint;

one set of specimens for shock bending testing: from the curved sections of the link;

one set of specimens for shock bend testing cut from the section across the welded joint with a notch in the fusing line (the cut in the centre).

**7.2.4.4.2** The impact test frequency shall be in accordance with Table 7.2.4.2.2.

Mechanical properties shall comply with requirements of Table 7.2.2.3.3.

**7.2.4.4.3** The frequency of impact testing in the bend may be reduced at the discretion of the Register provided it is verified by statistical means that the required toughness is consistently achieved.

**7.2.4.5** Non-destructive testing.

**7.2.4.5.1** After proof testing, all surfaces of every link and accessories shall be visually tested, and their dimensions and mutual mobility of elements and products shall be rechecked.

Burrs, irregularities and rough edges shall be contour ground. Links shall be free from mill defects, surface cracks, dents and cuts, especially in the vicinity where gripped by clamping dies during flash welding.

Studs shall be securely fastened.

Chain shall be positioned in order to have good access to all surfaces.

**7.2.4.5.2** Non-destructive testing shall be performed in accordance with recognized standards and procedures, together with the Register-approved acceptance/rejection criteria.

Operators shall be appropriately qualified, in the method of inspection, to at least level II in accordance with ISO 9712, SNT-TC-1A, EN 473 or ASNT, or recognized national standards on their basis.

**7.2.4.5.3** Magnetic particle testing approved by the Register shall be employed to examine the flash welded area including the area gripped by the clamping dies. Frequency of examination shall be every link. The relevant procedures and equipment shall be agreed with the Register.

Additionally, 10 % of links shall be tested on all accessible surfaces.

Link surfaces and the surface at the flash weld shall be free from cracks, lack of fusion and gross porosity.

**7.2.4.6** Retest and repair criteria.

**7.2.4.6.1** If the length over 5 links is short, the chain may be stretched by loading above the proof test load specified provided that the applied load is not greater than that approved by the Register for the given chain and that only random lengths of the chain need stretching.

Only randomly selected segments of the chain shall be exposed to stretching.

If the length exceeds the specified tolerance, the over length chain links shall be cut out and 7.2.4.6.2 shall apply.

**7.2.4.6.2** If single links are found to be defective or to not meet other applicable requirements, defective links may be cut out and a connecting common

link inserted in their place. The individual heat treatment and insertion procedure of connecting common links are subject to special agreement with the Register.

Other methods for repair are subject to the written approval of the Register and the end purchaser.

**7.2.4.6.3** If a crack, cut or defect in the flash weld are found by visual testing or magnetic particle testing, it shall be ground down no more than 5 % of the link diameter in depth and streamlined to provide no sharp contours.

The final dimensions shall still conform to the recognized standards and/or other documentation agreed with the Register.

**7.2.4.6.4** If unacceptable interior flash weld defects are detected during ultrasonic testing, the link is subject to replacement in accordance with 7.2.4.6.2.

**7.2.4.6.5** If a link diameter, length, width and stud alignment do not conform to the required dimensions, these shall be compared to the dimensions of 40 more links; 20 on each side of the affected link.

If a single particular dimension fails to meet the required dimensional tolerance in more than 2 of the sample links, all links shall be examined.

Replacement of affected links, refer to 7.2.4.6.2.

**7.2.4.6.6** If a break load test fails, the Register representative carrying out technical supervision shall be informed in a timely manner, the case shall be recorded and the relevant explanations shall be submitted to the Register representative. The instance shall be registered.

Relevant explanations shall be submitted to the Register representative.

Two additional break test specimens

representing the same sampling length of the chain (refer to Table 7.2.4.2.2) shall be subjected to the break load test.

Based upon satisfactory results of both break tests and the results of the failure investigation, it may be decided what length of chain can be considered for acceptance. Failure of either of both additional tests will result in rejection of the sampling length of the chain represented. For replacement, refer to 7.2.4.6.2.

**7.2.4.6.7** If a proof load test fails, the Register representative carrying out technical supervision shall be informed in a timely manner, the case shall be recorded and the relevant explanations shall be submitted to the Register representative. The instance shall be registered.

Relevant explanations shall be submitted to the Register representative.

In the event that two or more links in the proof loaded length fail, that length shall be rejected.

The above failure investigation shall be carried out especially with regard to the presence in other lengths of factors or conditions (refer to Table 7.2.4.2.2) thought to be causal to failure.

**7.2.4.6.8** In addition to the above failure investigation, a break test specimen shall be taken from each side of the one failed link, and subjected to the breaking test.

Based upon satisfactory results of both break tests and the results of the failure investigation, it may be decided what length of chain can be considered for acceptance.

Failure of either or both breaking tests will result in rejection of the same proof loaded length. Replacement of

defective links shall be in accordance with 7.2.4.6.2.

**7.2.4.6.9** If the results of tensile specimens testing are unsatisfactory, re-tests shall be conducted according to 1.3.2.4.

Failure to meet the specified requirements of either or both additional tests will result in rejection of the sampling length of chain represented and 7.2.4.6.2 shall apply.

**7.2.4.6.10** If the results of impact test specimens testing are unsatisfactory, re-tests shall be conducted according to 1.3.2.4.

Failure to meet the requirements will result in rejection of the sampling length represented and 7.2.4.6.2 shall apply.

**7.2.4.7 Marking.**

**7.2.4.7.1** The chain shall be marked at the following places:

- at each end;
- at intervals not exceeding 100 m;
- on connecting common links;
- on links next to shackles or connecting common links.

**7.2.4.7.2** All the marked links shall be stated on the Certificate, and the marking shall make it possible to recognize leading and tail end of the chain.

In addition to the above required marking, the first and last common link of each individual charge used in the continuous length shall be traceable and adequately marked.

The marking shall be permanent and legible throughout the expected lifetime of the chain.

**7.2.4.7.3** The chain shall be marked on the studs as follows:

- chain grade;
- Certificate number;

Register stamp.

**7.2.4.7.4** The Certificate number may be exchanged against an abbreviation or equivalent. If so, this shall be stated in the Certificate.

**7.2.4.7.5** The chain Certificate shall contain information on number and location of connecting common links.

The Certificate number and replacement link number may be exchanged against an abbreviation or equivalent. If so, this shall be stated in the Certificate.

**7.2.4.8 Documentation.**

**7.2.4.8.1** A complete chain inspection and testing report in booklet form shall be provided by the chain manufacturer for each continuous chain length. This booklet shall include all dimensional checks, test and inspection reports, non-destructive testing reports, process records, photographs as well as any nonconformity, corrective action and repair work.

**7.2.4.8.2** Individual Certificate shall be issued for each continuous single length of chain.

**7.2.4.8.3** All accompanying documents, appendices and reports shall carry reference to the original Certificate number.

**7.2.4.8.4** The manufacturer shall be responsible for storing, in a safe and retrievable manner, all the documentation produced for a period of at least 10 years.

**7.2.5 Testing and inspection of accessories.**

**7.2.5.1 General.**

**7.2.5.1.1** This Section applies to but is not limited to mooring equipment accessories such as detachable connecting links (shackles), detachable connecting plates (triplates), end shackles and swivel

shackles.

**7.2.5.1.2** All accessories shall be subjected to proof load tests, sample break load tests and sample mechanical tests after final heat treatment in the presence of the Register representative.

In case of availability of equipment and methods of fixation and recording of testing with test load values that comply with the provisions of the Register at the manufacturer, the presence of the Register's representative at this testing shall not be necessary.

The Register representative shall satisfy himself that the testing machines are calibrated and maintained in a satisfactory condition.

Prior to testing the Register representative shall satisfy himself that the testing machines are free from scale, paint or other coating. Prior to testing and inspection the chain accessories shall be free from scale, paint or other coating.

**7.2.5.2** Proof and break load tests.

**7.2.5.2.1** All chain accessories shall be subjected to the proof load specified for the corresponding stud link chain.

**7.2.5.2.2** All chain accessories shall be tested at the break load prescribed for the grade and size of chain for which they are intended.

At least one accessory out of every batch or every 25 accessories, whichever is less, shall be tested.

For individually produced accessories or accessories produced in small batches (less than 5), alternative testing will be subject to special consideration.

Alternative testing shall be approved by the Register.

**7.2.5.2.3** A batch is defined, in compliance with 7.2.2.3 and 7.2.2.4, as

accessories that originate from the same heat treatment charge and the same heat of steel.

**7.2.5.2.4** The accessories which have been subjected to the break load test shall be destroyed and not used as part of an outfit, with the exceptions given in 7.2.5.2.5.

**7.2.5.2.5** Where the accessories are of an increased dimension or alternatively a material with higher strength characteristics is used, they may be included in the outfit on agreement with the Register, provided that;

**.1** the accessories are successfully tested at the prescribed breaking load appropriate to the chain for which they are intended;

as well as

**.2** it is verified by procedure tests that such accessories are so designed that the breaking strength is not less than 1.4 times the prescribed breaking load of the chain for which they are intended.

**7.2.5.3** Dimensions and dimensional tolerances.

**7.2.5.3.1** At least one accessory (of the same type, size and nominal strength) out of 25 shall be checked for dimensions after proof load testing.

The manufacturer shall provide a statement indicating compliance with the purchaser's requirements.

**7.2.5.3.2** The following tolerances are applicable to accessories:

**.1** nominal diameter: +5 %, -0 %;

**.2** other dimensions:  $\pm 2$  %.

These tolerances do not apply to machined surfaces.

**7.2.5.4** Mechanical tests.

**7.2.5.4.1** Accessories shall be subjected to mechanical testing as described in 7.2.2.3 and 7.2.2.4.

The specimens shall be taken from proof loaded full size accessories that have been heat treated with the production accessories they represent.

The use of separate representative coupons is not permitted except as indicated in 7.2.5.4.4.

**7.2.5.4.2** Test location of forged shackles.

Forged shackle bodies and forged Kenter shackles shall have a set of three impact tests and a tensile test taken from the crown of the shackle.

Tensile tests on smaller diameter shackles can be taken from the straight part of the shackle, where the geometry does not permit a tensile specimen from the crown.

The tensile properties and impact values shall meet the requirements of Table 7.2.2.2.3.3 in the locations specified in Fig. 7.2.2.2.3.3.

**7.2.5.4.3** Test location of cast shackles.

The locations of mechanical tests of cast shackles and cast Kenter shackles can be taken from the straight part of the accessory.

The tensile properties and impact values shall meet the requirements of Table 7.2.2.2.3.3 in the locations specified in Fig. 7.2.2.2.3.3.

**7.2.5.4.4** The locations of mechanical tests of other accessories with complex geometries shall be agreed with the Register.

**7.2.5.4.5** For individually produced accessories or accessories produced in small batches (less than 5 t), alternative testing can be proposed to the Register. Each proposal for alternative testing shall be detailed by the manufacturer in a written procedure and submitted to the

Register.

**7.2.5.4.6** A batch, in accordance with 7.2.2.3 and 7.2.2.4 is defined as accessories that originate from the same heat treatment charge and the same heat of steel.

**7.2.5.4.7** Mechanical tests of pins shall be taken as per Fig. 7.2.2.2.3.3 from the mid-length of a sacrificial pin of the same diameter as the final pin.

For oval pins the diameter taken shall represent the smaller dimension.

Mechanical properties can be determined on the extended pin.

The extended part of the pin shall be of the same diameter as the ready pin and shall consist of the tested metal and the buffer part located on one side (refer to Fig. 7.2.5.4.7).

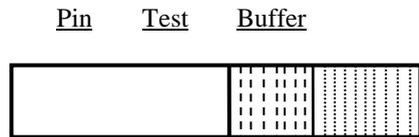


Fig. 7.2.5.4.7 Buffer and test piece location

The length of the buffer part of the pin, which shall be removed after the final heat treatment, shall at least be equal to the diameter of the pin.

**7.2.5.5** Non-destructive testing.

**7.2.5.5.1** After proof load testing all chain accessories shall be subjected to a close visual testing. Special attention shall be paid to machined surfaces and high stress regions.

All non-machined surfaces shall be sand or shot blasted to permit a thorough examination.

All accessories shall be checked by magnetic particles or dye penetrant.

**7.2.5.5.2** Testing shall be performed in accordance with the standards and procedures recognized by the Register including acceptance/rejection criteria which shall be submitted to the Register for review.

Operators shall be appropriately qualified, in the method of inspection, to at least level II in accordance with recognized standards such as ISO 9712, SNT-TC-1A, EN 473 or ASNT.

**7.2.5.5.3** The manufacturer shall provide a statement that non-destructive testing has been carried out with satisfactory results.

This statement shall include a brief reference to the techniques and to the operator's qualification.

**7.2.5.6** Test failures.

**7.2.5.6.1** In the event of a failure of any test the entire batch represented shall be rejected unless the cause of failure has been determined and it can be demonstrated to the Register representative's satisfaction that the condition causing the failure is not present in any of the remaining accessories.

**7.2.5.7 Marking.**

**7.2.5.7.1A** chain grade shall be marked on each accessory.

**7.2.5.7.2** The Certificate number may be exchanged against an abbreviation or equivalent. If so, this shall be stated in the Certificate.

**7.2.5.8 Documentation.**

**7.2.5.8.1** A complete inspection and testing report in booklet form shall be provided by the manufacturer for each order.

This booklet shall include all dimensional checks, test and inspection reports, non-destructive testing reports, process records as well as any

nonconformity, corrective action and repair work.

**7.2.5.8.2** Each type of accessories shall be covered by the manufacturer's separate Certificate.

**7.2.5.8.3** All accompanying documents, appendices and reports shall carry reference to the original Certificate number.

**7.2.5.8.4** The manufacturer shall be responsible for storing, in a safe and retrievable manner, all documentation produced for a period of at least 10 years.

**7.2.6** Chafing chain for single point mooring arrangements.

**7.2.6.1 General.**

**7.2.6.1.1** The present requirements apply to chafing chains (approximately 8 m) of a 76 mm diameter to be connected to hawsers for the tethering of oil tankers to single point moorings, FPSO and similar uses.

**7.2.6.2 Approval of manufacturing.**

**7.2.6.2.1** Recognition of manufacturers.

The chafing chain shall be manufactured by works recognized by the Register in accordance with 7.2.1.3.

**7.2.6.3 Materials.**

**7.2.6.3.1** The materials used for the manufacture of the chafing chain shall meet the requirements of 7.2.2.2.

**7.2.6.4** Design, manufacturing, testing and certification.

**7.2.6.4.1** The chafing chain shall be designed, manufactured, tested and certified in accordance with the requirements of 7.2.3, 7.2.4 and 7.2.5, except that batch heat treatment is permitted.

**7.2.6.4.2** The arrangement of the end connections shall be of an approved type.

**7.2.6.4.3** The common link shall be of the stud link type — Grade R3 or R4.

**7.2.6.4.4** A chain of the chain set shall withstand breaking loads:

for Grade R3 is 4,884 kN;

for Grade R4 is 6,001 kN.

In this case, documented evidence of satisfactory testing of a similar diameter mooring chain in the prior 6 month period

may be submitted to the Register for approval.

**7.2.6.4.5** The chain lengths shall be proof load tested in accordance with 7.2.4.2.

Test load value:

for Grade R3 is 3,242 kN;

for Grade R4 is 4,731 kN.

## 8 REQUIREMENTS FOR MANUFACTURE OF ANCHORS

### 8.1 GENERAL

**8.1.1** The present requirements apply to anchors and the materials used in their manufacture which are subject to technical supervision.

The Section requirements also apply to the recognition of manufacturers, to manufacture and testing, as well as to survey of:

anchors produced from cast or forged steel;

anchors fabricated by welded rolled steel plate and bars.

**8.1.2** Anchors are divided into high holding power (HHP) anchors and super high holding power (SHHP) anchors.

**8.1.3** The types of anchor covered include:

**.1** ordinary anchors:

stockless anchors;

stocked anchors;

**.2** HHP anchors;

**.3** SHHP anchors, not exceeding 1,500 kg in mass.

Any changes to the anchor design made during manufacture shall be preliminary agreed with the Register.

**8.1.4** Anchors and components thereof shall be made at the manufacturers

recognized according to the requirements of 1.3.

### 8.2 MATERIALS

#### 8.2.1 Materials for anchors.

All anchors shall be manufactured from materials meeting the requirements given below.

**8.2.1.1** Cast steel anchor flukes, shanks, swivels and shackles shall be manufactured and tested in accordance with the requirements of 3.8 for castings of welded structures.

The steel shall be fine grain treated with aluminium.

If test programme B is selected according to 8.4.2.1 then Charpy V-notch (KV) impact testing is required.

Special consideration shall be given to the use of materials for swivel castings.

**8.2.1.2** Forged steel anchor pins, shanks, swivels and shackles shall be manufactured and tested in accordance with the requirements of 3.7.

Shanks, swivels and shackles shall comply with the requirements for carbon and carbon-manganese steels for welded structures.

Special consideration shall be given to the use of materials for swivel castings.

**8.2.1.3** Rolled billets, plate and bar for fabricated steel anchors shall be manufactured and tested in accordance with the requirements of 3.2.

**8.2.1.4** Rolled bar intended for pins, swivels and shackles shall be manufactured and tested in accordance with the requirements of 3.2 or 3.7.

**8.2.2** In addition to the requirements of 8.2.1, the material of super high holding power (SHHP) anchors shall meet the following requirements:

welded steel anchors — 3.2 of the present Part;

Section 4, Part XIV “Welding”;

cast steel anchors — 3.8 of the present Part;

shackles — 3.7, 3.8 of the present Part.

The steel grade for welded anchors of high holding power shall be selected in accordance with the requirements of 1.2.1, Part II “Hull” for category II members.

The level of requirements in impact tests of the welded joint shall meet the relevant requirements for a base metal (refer to Section 4, Part XIV “Welding”).

The impact energy value required for the shackle material shall meet the requirements of 7.1 for Grade 3 steel.

The impact energy value (*KV*) for the material of anchor castings shall be not less than 27 J at 0 °C.

## **8.3 MANUFACTURE OF ANCHORS**

### **8.3.1 Tolerance.**

If not otherwise specified in standards or on drawings and in specifications, the following tolerance shall be applied.

The clearance either side of the shank within the shackle jaws shall be:

3 mm — for small anchors up to 3 t in weight;

4 mm — for anchors from 3 t to 5 t in weight;

6 mm — for anchors from 5 t to 7 t in weight;

12 mm — for anchors 7 t and over in weight.

The shackle pin shall be a push fit in the eyes of the shackle which shall be chamfered on the outside to ensure a good tightness.

The shackle pin to hole tolerance shall be no more than 0.5 mm for pins up to 57 mm and 1.0 mm for pins of larger diameter.

The trunnion pin shall be a snug fit within the chamber and be long enough to prevent horizontal movement.

The gap shall be no more than 1 % of the chamber length.

The lateral movement of the shank shall not exceed 3° (refer to Fig.8.3.1).

Fig. 8.3.1

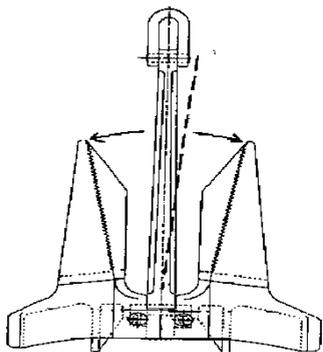
### **8.3.2 Welding of anchors.**

Welded structures of fabricated anchors shall be done in accordance with procedures approved by the Register.

Welding shall be carried out by qualified welders holding a Certificate of Approval Test for Welder (refer to Section 5, Part XIV “Welding”).

Welding consumables shall be approved by the Register.

Non-destructive testing shall be carried out in accordance with the



requirements of Section 3, Part XIV “Welding”.

### 8.3.3 Heat treatment

Components for cast and forged anchors shall be properly heat treated; fully annealed; normalized or normalized and tempered in accordance with the requirements of 3.7 and 3.8.

Fabricated anchors may require heat treatment for stress relief after welding.

The heat treatment for stress relief shall be carried out in accordance with the documentation approved by the Register.

The temperature in heat treatment shall not exceed the tempering temperature for the base metal.

### 8.3.4 Non-destructive testing.

All parts of the anchor surface shall have a clean surface consisting with the method of anchor components manufacture.

No cracks, notches and other defects that would impair the anchor performance are acceptable.

### 8.3.5 Repairs.

Any necessary repairs to forged and cast anchors shall be agreed with the Register and carried out in accordance with the requirements of Sections 7 and 8.

Repairs to fabricated anchors shall be agreed with the Register representative

and carried out by qualified welders recognized by the Register.

Repair welding shall follow the same parameters and the same welding procedures used in construction.

### 8.3.6 Anchor assembly.

Assembly and fitting shall be done in accordance with the Register-approved documentation.

Securing of the anchor pin, shackle pin, etc. by welding shall be done in accordance with the documentation approved by the Register.

## 8.4 TESTING AND ISSUE OF DOCUMENTS

### 8.4.1 Proof load testing.

Proof load testing shall be carried out by an approved testing facility.

Proof load testing for ordinary, high holding power and super high holding power anchors shall be carried out in accordance with the pertinent requirements of Section 3, Part IV “Technical Supervision during Manufacture of Products” of the Rules for Technical Supervision during Construction of Ships and Manufacture of Materials and Products for Ships.

### 8.4.2 Product tests.

#### 8.4.2.1 Product test programme.

The Register can request that one of the programmes below be applied to the material of each component product.

#### 8.4.2.2 Drop test.

Each anchor fluke and shank shall survive dropping from a height of 4 m on to a steel slab without fracturing. The steel slab shall have an adequate thickness to resist the impact of the dropped component.

**Table 8.4.2.1-1 Applicability of programmes for various components**

Tests	Components		
	Cast parts	Forged parts	Welded parts
Programme A	+	-	-
Programme B	+ <sup>1</sup>	+	+

<sup>1</sup> The average impact value during tests for impact bending (KV) at 0 °C shall comply with the requirement of 27 J.

**Table 8.4.2.1-2 Type of testing depending on the testing programme**

Programme A	Programme B
Drop test.	-
Hammering test	-
Inspection.	Inspection.
Non-destructive testing	Non-destructive testing
-	Large non-destructive testing

**8.4.2.3 Hammering test.**

After the drop test, hammering tests shall be carried out on each anchor fluke and shank, which is slung clear of the ground, using a non-metallic sling, and hammered to check the soundness of the component. A hammer of at least 3 kg mass shall be used.

The sound of the material shall be controlled.

**8.4.2.4 Visual testing.**

After proof load testing, visual testing of all accessible surfaces shall be carried out.

**8.4.2.5 Non-destructive testing.**

After proof load testing, non-destructive testing shall be carried out in accordance with the requirements of Tables 8.4.2.5-1 and 8.4.2.5-2.

**8.4.2.6 Large non-destructive testing.**

After proof load testing, large non-destructive testing shall be carried out in

accordance with the requirements of Table 8.4.2.6.

**Table 8.4.2.5-1 Non-destructive surface control for high holding power (HHP) anchors**

Control Location	Testing method
Outer surfaces of castings	PT or MT
Interior surfaces of castings	PT or MT
Repair welding location	PT or MT
Forged parts	-
Welded parts	PT or MT

PT — the capillary control method.  
MT — the magnetic particle test.

**Table 8.4.2.5-2 Non-destructive control for super high holding power (SHHP) anchors**

Control Location	Testing method
Outer surfaces of castings	PT or MT and UT
Interior surfaces of castings	PT or MT and UT
All surfaces of castings	PT or MT
Repair welding location	PT or MT
Forged parts	-
Welded parts	PT or MT

PT — the capillary control method.  
MT — the magnetic particle test.  
UT — ultrasound testing.

**8.4.2.7 Repair criteria.**

If defects are detected by non-destructive testing, repairs shall be carried out in accordance with 8.3.5.

Fractures and other defects being the results of a drop test or hammering test repairs are not permitted and the component shall be rejected.

**Table 8.4.2.6 Large non-destructive control for high holding power (HHP) and super high holding power (SHHP) anchors**

Control Location	Testing method
Outer surfaces of castings	PT or MT and UT
Interior surfaces of castings	PT or MT and UT
All surfaces of castings	PT or MT
Randomly selected area	UT
Repair welding location	PT or MT
Forged parts	-
Welded parts	PT or MT

PT — the capillary control method.

MT — the magnetic particle test.

UT — ultrasound testing.

**8.4.3** Mass and dimensional inspection.

Unless otherwise agreed, the verification of mass and dimensions is the responsibility of the manufacturer.

The Register's representative is only required to monitor this inspection.

The mass of the anchor shall exclude the mass of the swivel, unless this is an integral component.

**8.4.4** Retests.

Retests shall be carried out in accordance with the requirements of 1.3.2.4.

**8.4.5** Marking.

Anchors which meet these requirements shall be stamped on the shank and the fluke.

The marking on the shank shall be approximately level with the fluke tips. On the fluke, these markings shall be approximately at a distance of two thirds from the tip of the bill to the centre line of the crown on the right hand fluke looking from the crown towards the shank.

The markings shall include:

mass of anchor;

identification number (e.g. test report No. or certificate No.);

Register stamp;

manufacturer's mark.

The fact that the flukes and the shank have been made by moulding shall be additionally indicated.

The unique cast identification shall be cast on the shank and the fluke.

**8.4.6** Documents to be issued to anchor.

The Register issues the certificate for anchors meeting the present requirements which shall contain the following data:

manufacturer's name;

type of anchor;

mass of anchor;

fluke and shank identification numbers;

category (grade) of metal;

proof load testing;

heat treatment;

Register stamp.

**8.4.7** Painting.

Anchors shall not be painted until all tests and inspections have been completed

