



Exploration & Production

GENERAL SPECIFICATION

CORROSION

GS EP COR 901

Technical Assessment of Coating Plants

00	01/2012	First issue
Rev.	Date	Notes

Owner: DEV/TEC	Managing entity: DEV/TEC/COR
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1. Scope

This General Specification defines Company practices and tools to use to perform technical assessment of coating plants.

2. Reference documents

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

Standards

Reference	Title
Not applicable	

Professional Documents

Reference	Title
Not applicable	

Regulations

Reference	Title
Not applicable	

Codes

Reference	Title
Not applicable	

Other documents

Reference	Title
Not applicable	



Total General Specifications

Reference	Title
GS EP COR 220	Three layer polyethylene external coating for pipelines
GS EP COR 221	Three layer polypropylene external coating for pipelines
GS EP COR 222	Fusion Bonded Epoxy (FBE) external coating for pipelines

3. Technical assessment process of coating plants

The technical assessment process of a coating plant is part of the global assessment process of a Supplier, lead by the E&P Purchasing Division.

3.1 Step 1: Gathering of information

To start the technical assessment process, Appendix 1 of this document (Technical Information Analysis Form) shall be sent to the Coater, by the Company.

The Coater shall fill and send back this Form, to the Company, with all the others necessary documents requested.

3.2 Step 2: Data Analysis of Appendix 1 and following actions

After data analysis of Appendix 1, the COR discipline of E&P Technology Division, shall take a decision to proceed or not to the next step of the Coater technical assessment process.

3.2.1 Case 1: Negative result given by the data analysis of Appendix 1

In case of negative result given by the data analysis of Appendix 1, the technical assessment process shall stop at this step. The technical assessment result of the Coater is negative.

3.2.2 Case 2: Positive result given by the data Analysis of Appendix 1 - Audit of Coater production site mandatory

Following positive result of Appendix 1 data analysis, an audit of the Coater production site is deemed mandatory by the COR discipline of E&P Technology Division.

This audit shall be performed by the COR discipline of E&P Technology Division, or by its representative, and will give final result of the Coater technical assessment.

3.2.3 Case 3: Positive result given by the data Analysis of Appendix 1 - Audit of Coater production site not necessary

Following positive result of Appendix 1 data analysis, an audit of the Coater production site, is not deemed necessary, by the COR discipline of E&P Technology Division, to complete the technical assessment process. The technical assessment result of the Coater is positive.



3.3 Step 3: Assessment notification to the Coater

The outcome of step 2 analysis (negative, positive...) is consolidated by the authorized Company entity, together with others parameters (financial, contractual and social responsibility, quality, HSE...) for final decision.

Then, the authorized Company entity will notify the Coater of the outcome of global assessment.

3.4 PQT / PPT to perform during audit of the Coater production site

If an audit of the Coater production site is deemed mandatory, a PQT/PPT shall be performed on 10 pipes, in order to demonstrate the capacity of the Coater to respect the Company requirements.



Appendix 1 Technical Information Analysis Form: Coating Plant - EXCEL spreadsheet



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Appendix 1

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Quick guidelines to use this document : the objective of the following indications, are to the help user to fill the **Technical Information Analysis Form**.

This document has to be sent to the manufacturer to start technical assessment process before any survey at manufacturer location.
The manufacturer has to fill all information requested in all tables.

1) "Production Range" card :

On this card, the manufacturer has to indicate all its production ranges submitted for approval.

After technical assessment, Total or its representative, is able to indicate for which production ranges the manufacturer is finally approved.

2) "Theme I to Theme III" cards :

The manufacturer has to fill all tables of each cards, in order to have a better understanding of its production capacities.

After analysis of manufacturer answers, Total or its representative, can make comments, in blue column, for each manufacturer answers.

3) "Global Synthesis" cards :

On this card all general information (name, address, contact of manufacturer, date of audit, assessment report n°, Total specifications linked,...) written will be automatically pasted in all the others cards.

First section of this card has to be filled by the manufacturer by indicating general informations : name, address, contact, process concerned,...

The three others sections have to be filled by Total of its representative to summarize result and decision after analysis of the

Technical Information Analysis Form.

In the last section, the signature of Total or its representative will be done, in order to validate the analysis result of this Form.



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COATER			
Coater Name xxx	Activity and Process of Audited Workshop xxx	Audit Date xxx	
Coater Head Office Address xxx	Coater contacts (name, function, email, phone,...) 		
Name & Address of Audited Workshop xxx			
TOTAL OR REPRESENTATIVE COMPANY TEAM - TO BE FILLED BY TOTAL OR REPRESENTATIVE			
Total Project Concerned xxx	Total or Representative Responsible for Technical Information Analysis (Name, Function, Service) 		
Objectives of the Technical Information Analysis			
TECHNICAL INFORMATION ANALYSIS / TECHNICAL ASSESSMENT RESULT (FOR THE PRODUCTION RANGE CONSIDERED) - TO BE FILLED BY TOTAL OR REPRESENTATIVE			
Result of Information Analysis of GS EP COR 901 - Appendix 1, filled by the Manufacturer			
	Yes / No	Comments	
Level of information is appropriate			
On site Audit Requested			
Result of Technical Assessment of Manufacturer (to be filled if on site audit is not deemed necessary)			
	Decision *	Comments	
Satisfactory			
Reserves to close to be satisfactory			
Not satisfactory			
Notes : * : Tip when appropriate			
CONCLUSIONS OF TECHNICAL INFORMATION ANALYSIS / GENERAL COMMENTS			
SIGNATURE OF TOTAL OR REPRESENTATIVE TEAM			
NAME	DATE	NAME	DATE

THIS TECHNICAL INFORMATION ANALYSIS DOESN'T REPLACE THE PQT / PPT THAT HAVE TO BE PERFORMED FOR EACH NEW PROJECT



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XXX	XXX	XXX

ACTUAL PRODUCTION RANGE / APPROVED PRODUCTION RANGE OF THE COATER

To list all the actual production ranges of the coater and select and comment the approved ones.

			To be completed by the coater		To be completed by Total or representative Company	
Type	Code	Designation	Actual maximum diameter and base materials (carbon steel and stainless steel)		Approved maximum diameter and base materials (carbon steel and stainless steel)	
Coating	5514	Pipeline coating applicators				
	5523	Subsea thermal coating applicators				



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COATER		
Name & Address of Audited Workshop XXXX	Activity and Process of Audited Workshop XXXX	Audit Date XXXX

THEME I - GENERAL ORGANIZATION

All facilities described herein are meant to be permanent in-house facilities only. Any sub-contracted activity must be clearly indicated showing the names and addresses of related Subcontractors. The number, type and status of all listed equipment are subject to thorough checks by the COMPANY representative in charge of the Plant Survey during his visit of the facilities.

Table 1.1.a - General Organization - Surface area (Plot plan to be joined if available)			
Zone	Surface area (m ²)	Description	Comments <i>To be filled by TOTAL or Company representative</i>
Overall			
Covered areas			
Yard areas			
Offices			
Manufacturing workshops			
Laboratory			
Material and extrusion equipment			
Testing workshops			
Warehouses			
Covered storage areas			

Table 1.1.b - General Organization - Manufacturer Management : organization chart to join			
Position	Names	Comments	Comments <i>To be filled by TOTAL or Company representative</i>
Managing Director			
Sales Manager			
Plant / Yard Manager			
Production Manager			
Quality Assurance Manager			
Quality Control Manager			
HSE Manager			
Logistic Manager			
Others			



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Table 1.1.c - General Organization - Personnel					
Quality of Employees	Staff Quantity (coater's personnel)	Contracted Personnel Quantity (personnel from external company which are working at the coater)	Average years of service (staff)	Personnel qualification level (curriculum vitae)	Comments <i>To be filled by TOTAL or Company representative</i>
Commercial department					
Administration					
Project Management					
R&D					
Laboratory					
Procurement					
Expediting / Shipment					
Production					
Quality Inspection Manager					
Quality Inspector (for testing : NDT, DT,...)					
Quality Inspector (on line)					
Quality assurance					
Quality for in-coming material					
Supervisory Personnel					
Management					
HSE employees					
Others					
Total number of Employees					

Table 1.1.d - General Organization - Certification of employees				
Name of employees	Quality of employees (engineers, technicians, supervisors, operators...)	Type of certification (NACE, ACQPA, FROSIO, others,...)	Level of certification	Comments <i>To be filled by TOTAL or Company representative</i>



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Table 1.1.e - General Organization - Communication With Customer / Working Documents Language				
	Language used with customer : YES / NO ?	Which department team (engineering, commercial, production,...) and how many people are able to discuss in other language than mother tongue ?	Documents (testing procedures, drawing, control procedures,...) available in which language ?	Comments <i>To be filled by TOTAL or Company representative</i>
English				
French				
Others				

Table 1.1.f - General Organization - Work Load Status and Commercial data		
Items to check	Description	Comments <i>To be filled by TOTAL or Company representative</i>
Ownership		
Annual turnover in M\$ or M€ (3 previous year)		
Men hour capacity		
Work shift : normal, 2x8, 3x8		
Present and future work load (%)		
Future investment (tools, building, human resources,...)		
Number of international subsidiaries		
Location of international and/or others subsidiaries		

Table 1.1.g - General Organization - References on similar jobs								
Year built	Customer (Total, others,...)	Country of installation	Name / Description of project	Total fabricated pipes length (by coating types)				Comments <i>To be filled by TOTAL or Company representative</i>
				FBE	3xLPE	3xLPP	Others	



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Table 1.1.h - General Organization - R&D Capacity				
Quantity of Permanent Staff	Description of R&D activities	Staff Qualifications	Sub-contracted (if any)	Comments <i>To be filled by TOTAL or Company representative</i>

Table 1.1.i - General Organization - International Standards and Total General Specifications used					
Standards / Total GS	Date of revision	Deviation list		Description / Comments	Comments <i>To be filled by TOTAL or Company representative</i>
		Available for review : Yes / No	Submitted to Company : Yes / No		
GS EP COR 220					
GS EP COR 221					
GS EP COR 222					
ASTM D 570					
ASTM D 1693					
ASTM D 4940					
CSA Z245-20					
ISO 306					
ISO 527-1					
ISO 527-2					
ISO 868					
ISO 1133					
ISO 1183					
ISO 2808					
ISO 2811-1					
ISO 4287					
ISO 4892-2					
ISO 6964					
ISO 8130-6					
ISO 8501-1					
ISO 8502-3					
ISO 8502-6					



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ISO 8502-9					
ISO 8503-4					
ISO 11357-1					
ISO 11357-3					
NF A49-710					
NACE RP0274					
Others					

Table 1 - General Aptitude / Experience / Personnel - List of documents to send by the coater, to Total, in English (or French, if available) languages, with all Tables filled, before on site technical review

List of documents	Documents received : YES / NO ?	Documents available in English (or French) language : YES / NO ?	Comments <i>To be filled by TOTAL or Company representative</i>
Plot plan, layout of the plant			
General Organization Chart			
Quality Control Organization Chart			
Coating procedures (ITP)			
Repair procedures			
Control procedures			
Non-conformities management procedures			
In-coming material inspection procedures			
Supplier evaluation, follow-up and audit procedures			
Quality manual			
ISO, API, PED certificates, others,....			
HSE policy			
Example of audit report : audit made by customer manufacturer or audit made by manufacturer on its sub-suppliers			



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THEME II - MANUFACTURING

All facilities described herein are meant to be permanent in-house facilities only. Any sub-contracted activity must be clearly indicated showing the names and addresses of related Subcontractors. The number, type and status of all listed equipment are subject to thorough checks by the COMPANY representative in charge of the Plant Survey during his visit of the facilities.

Table 2.1.a - Workshop General Organization - Building Bay and Cranes Data of Covered Area / Handling facilities

Bay n°	Bay Dimensions (m x m)	Type of Crane / Handling	Number of Cranes	Capacity (tons)	Height under Hook (m)	Electrical or Manual	Description (certification date,...)	Comments <i>To be filled by TOTAL or Company representative</i>
1								
2								
3								
4								
5								
6								
7								
8								

Table 2.1.b - Workshop General Organization - Cranes Date of Open Air Area / Handling facilities

Type of Crane / Handling	Number of Cranes	Capacity (tons)	Height under Hook (m)	Electrical or Manual	Description (certification date,...)	Comments <i>To be filled by TOTAL or Company representative</i>

Table 2.2.a - Pre-heating - Description of Equipment in Place

Type of Equipment	Description	Quantity	Max. Capacity (meter/min)	Comments / Description	Comments <i>To be filled by TOTAL or Company representative</i>

Table 2.3.a - Blasting - Description of Equipment in Place

Type of Equipment	Description	Quantity	Max. Capacity (meter/min) for Sa3	Comments / Description	Comments <i>To be filled by TOTAL or Company representative</i>



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THEME II - MANUFACTURING

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Table 2.4.a - Dust removal - Description of Equipment in Place					
Type of Equipment	Description	Quantity	Max. Capacity (meter/min)	Comments / Description	Comments <i>To be filled by TOTAL or Company representative</i>

Table 2.5.a - Heating - Description of Equipment in Place				
	Oven n°1	Oven n°2	Oven n°3	Comments <i>To be filled by TOTAL or Company representative</i>
Heating source				
Inside Dimensions (Height x Width x Length) (m)				
Automatic Control or Manual				
Max line speed for 220°C with 12" pipe, WT = 12,7 mm				
Maximum temperature				
Maximum power				
Pipe temperature recording				

Table 2.6.a - Coating - Description of Equipment/Process in Place				
Type of Equipment	Type of Process (lateral or annular, adhesive application by extrusion or by powder spraying) / Description	Temperature	Max. Capacity (meter/min)	Comments <i>To be filled by TOTAL or Company representative</i>
FBE (electrostatic gun)				
PE/PP Adhesive extrusion				
PE/PP Extrusion				

Table 2.7.a - Cooling - Description of Equipment in Place				
Type of Equipment	Description	Cooling Temperature	Maximum water quantity (m³/min)	Comments <i>To be filled by TOTAL or Company representative</i>



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THEME III - PRODUCTS MANAGEMENT (CONTROL, TESTING, INSPECTION, STORAGE)

All facilities described herein are meant to be permanent in-house facilities only. Any sub-contracted activity must be clearly indicated showing the names and addresses of related Subcontractors. The number, type and status of all listed equipment are subject to thorough checks by the COMPANY representative in charge of the Plant Survey during his visit of the facilities.

Table 3.1.a - In-coming Material Management - Material Storage			
Type of Storage	Dimension	Material Stored	Comments <i>To be filled by TOTAL or Company representative</i>
Covered storage yard			
Open storage yard			
Warehouse			

Table 3.1.b - In-coming Material Management - Storage Conditions		
Storage Conditions for :	Description / Comments	Comments <i>To be filled by TOTAL or Company representative</i>
FBE		
PE		
PP		
Non conform raw material		
Others		

Table 3.2.a - Inspection, Testing and Quality Control - Non Destructive Testing Equipment							
Type of test / control	Equipment type	Range capability	Quantity of Equipment	Calibration of Equipment updated ?	Testing procedures and international standards (availability, issuance, updating)	Recording and traceability	Comments <i>To be filled by TOTAL or Company representative</i>
Pipes Temperature : pre heating							
Pipes Temperature : after induction heating							
Pipes Temperature : after cooling							
Thickness							
Degree of surface cleanliness							
Salt contamination on prepared surface							
Dust level on prepared surface							
Roughness							
Pipes travel speed							
Gel time (FBE)							
Extrusion temperature (adhesive and PE/PP top coat)							
Residual magnetic intensity							
DSC							
Elongation at break : adhesive							
Elongation at break : PE/PP							
Others							



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THEME III - PRODUCTS MANAGEMENT (CONTROL, TESTING, INSPECTION, STORAGE)

All facilities described herein are meant to be permanent in-house facilities only. Any sub-contracted activity must be clearly indicated showing the names and addresses of related Subcontractors. The number, type and status of all listed equipment are subject to thorough checks by the COMPANY representative in charge of the Plant Survey during his visit of the facilities.

Table 3.2.b - Inspection, Testing and Quality Control - Destructive Testing Equipment								
Type of test / control	Equipment type	Range capability	Number of Equipment	Calibration of Equipment updated ?	Testing procedures and international standards (availability, issuance, updating)	Testing sub-contracted ? If yes, indicate the name of sub-contractor	Recording and traceability	Comments <i>To be filled by TOTAL or Company representative</i>
Impact resistance								
Hardness								
Peeling force								
Coating homogeneity								
Indentation								
Elongation								
Flexibility								
Cathodic disbonding (23, 65 & 80°C)								
Others								

Table 3.2.c - Inspection, Testing and Quality Control - Raw Material Chemical Analysis Equipment								
Type of test / control	Equipment type	Range capability	Number of Equipment	Calibration of Equipment updated ?	Testing procedures and international standards (availability, issuance, updating)	Testing sub-contracted ? If yes, indicate the name of sub-contractor	Recording and traceability	Comments <i>To be filled by TOTAL or Company representative</i>
FBE :								
Moisture content								
DSC								
Gel time								
Density								
Adhesive :								
Vicat softening point								
Melting point								
PE/PP :								
Density								
Carbon black content								
Vicat softening point								
Melting point								
Thermal ageing								
UV ageing								
PE : Stress cracking								
Others								



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THEME III - PRODUCTS MANAGEMENT (CONTROL, TESTING, INSPECTION, STORAGE)				
<i>All facilities described herein are meant to be permanent in-house facilities only. Any sub-contracted activity must be clearly indicated showing the names and addresses of related Subcontractors. The number, type and status of all listed equipment are subject to thorough checks by the COMPANY representative in charge of the Plant Survey during his visit of the facilities.</i>				
Table 3.3.a - Finished Goods Management - Goods Storage				
Type of Storage	Dimension	Material Stored	Comments <i>To be filled by TOTAL or Company representative</i>	
Covered storage yard				
Open storage yard				
Warehouse				
Table 3.3.b - Finished Goods Management - Storage Conditions				
Storage Conditions for :	Description / Comments	Comments <i>To be filled by TOTAL or Company representative</i>		
Table 3.3.c - Finished Goods Management - Shipping Facilities				
Type	Maximum Dimension (m)	Maximum Capacity (weight in tons)	Comments	Comments <i>To be filled by TOTAL or Company representative</i>
Railroad siding with spur in yard				
Road / Trucking				
Water				
Table 3 - Procurement Practices - Coater's Suppliers List / Source of Materials				
Material	Suppliers	Number of audits / year	Comments (follow-up procedures, approval,...)	Comments <i>To be filled by TOTAL or Company representative</i>
FBE				
PE Adhesive				
PE				
PP adhesive				
PP				
Repaired products				