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Jacket Fabrication for Bom bay High Well Platforms

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Synopsis :

Two steel jackets; one for well platforms and the other for living quarters, were designed, fabricated and delivered by Kawasaki Steel Corporation Engineering Division in 1981 to its client: the Oil and Natural Gas Commi ssion of India (ONGC) as one of sizeable orders ever received by Kawasaki Steel of its kind from anywhere. Fabrication sequence, scheduling, man power and production control procedure were elaborately discussed and determined. All the strict requirem ent for qualities described in ONGC's specification were satisfied and two jackets were shipped on time. This paper outlines the following features: (1) Fabrication (2) Fl ap-up of side panels (3) Loading out (4) Welding and dimensional control (5) Nondestructive inspection

The body can be viewed from the next page.

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Table 1 Dimension of jacket and scope of work

Item		SR jacket	SLQ jacket
Jacket	Height (m)	85	86
	Width (m)	Top : 15.5×6.5 Bottom : 27.8×27	Top : 13.7×15.2 Bottom : 35×36
	Weight (t)	1 290	1 497
Pile	Main	$\phi 1\,219 \times t\,32/44.5 \times l\,181/193$ m×4	$\phi 1\,371.6 \times t\,38.1 \times l\,176$ m×4
	Skirt	$\phi 1\,219 \times t\,25/38 \times l\,94$ m×2	$\phi 1371.6 \times t\,38.1 \times l\,107$ m×4

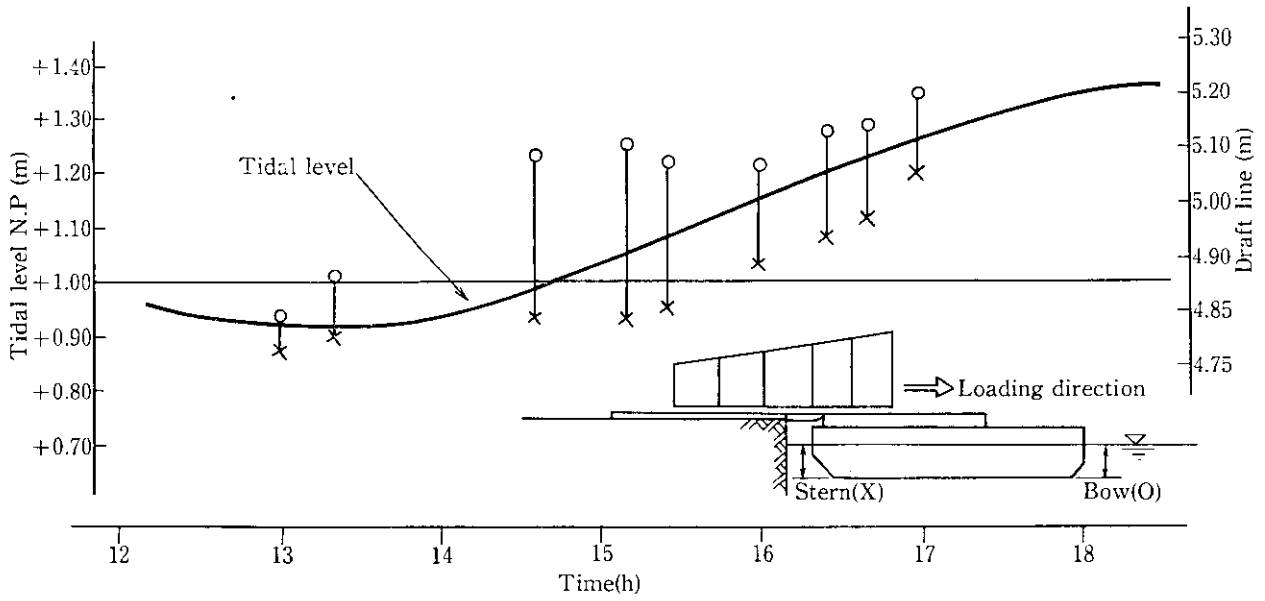| Scope	Fabrication	Design fabrication, transportation

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Fig. 4 Change of tidal level and draft controlled by ballasting

Table 2 An example of measured root gap of T-, K-, and Y-joint

Item	T-joint	K-·Y-joint

| | Average／Number of samples | $2.9\diagup11$ | $4.7\diagup12$ | $3.3\diagup12$ | $3.6\diagup12$ | $3.3\diagup16$ | $3.2\diagup16$ | $4.3\diagup16$ | $5.6\diagup16$ |

Table 4 API RP-2X reject criteria for tubular T-, K-, and Y-joint

Level	A	C	F