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| **طرح نگهداشت و افزایش تولید 27 مخزن** |
| **WALL THICKNESS CALCULATION REPORT** **نگهداشت و افزایش تولید میدان نفتی بینک** |
|  |  |  |  |  |  |  |
| D03 | FEB. 2024 | IFA | M.Noori | M.Fakharian | S.Faramarzpour |  |
| D02 | OCT. 2022 | IFA | M.Noori | M.Fakharian | M.Mehrshad |  |
| D01 | FEB. 2022 | IFA | A.Khosravi | M.Fakharian | M.Mehrshad |  |
| D00 | DEC. 2021 | IFC | H.Shahrokhi | M.Fakharian | M.Mehrshad |  |
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**REVISION RECORD SHEET**

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1. **INTRODUCTION**

Binak oilfield in Bushehr province is a part of the southern oilfields of Iran, is located 20 km northwest of Genaveh city.

With the aim of increasing production of oil from Binak oilfield, an EPC/EPD Project has been defined by NIOC/NISOC and awarded to Petro Iran Development Company (PEDCO). Also PEDCO (as General Contractor) has assigned the EPC-packages of the Project to "Hirgan Energy - Design and Inspection" JV.

As a part of the Project, a New Gas Compressor Station (adjacent to existing Binak GCS) shall be constructed to gather of 15 MMSCFD (approx.) associated gases and compress & transfer them to Siahmakan GIS.

**GENERAL DEFINITION**

The following terms shall be used in this document.

|  |  |
| --- | --- |
| CLIENT:  | National Iranian South Oilfields CLIENT(NISOC)  |
| PROJECT: | Binak Oilfield Development – Surface Fcilities; New Gas Compressor Station |
| EPD/EPC CONTRACTOR (GC): | Petro Iran Development Company (PEDCO) |
| EPC CONTRACTOR: | Joint Venture of : Hirgan Energy – Design & Inspection (D&I) Companies |
| VENDOR: | The firm or person who will fabricate the equipment or material. |
| EXECUTOR:  | Executor is the party which carries out all or part of construction and/or commissioning for the project. |
| THIRD PARTY INSPECTOR (TPI): | The firm appointed by EPD/EPC CONTRACTOR (GC) and approved by CLIENT (in writing) for the inspection of goods. |
| SHALL: | Is used where a provision is mandatory. |
| SHOULD: | Is used where a provision is advisory only. |
| WILL:  | Is normally used in connection with the action by CLIENT rather than by an EPC/EPD CONTRACTOR, supplier or VENDOR. |
| MAY:  | Is used where a provision is completely discretionary. |

1. **SCOPE**

This specification covers the wall thickness calculation for BINAK Compressor Gas Station.

1. **NORMATIVE REFERENCES**

## LOCAL CODES AND STANDARDS

* IPS-E-PI-140 Engineering Standard for Onshore Transportation Pipelines

## INTERNATIONAL CODES AND STANDARDS

|  |  |
| --- | --- |
| * ASME B16.5
 | Pipe Flanges and Flanged Fitting |
| * ASME B16.47
 | Large Diameter Steel Flanges |
| * ASME B31.3
 | Process Piping |
| * ASME B31.4
 | Pipeline Transportation Systems for LiquidHydrocarbons and Other Liquids |
| * ASME B31.8
 | Gas Transmission and Distribution Piping Systems |
| * ASME B36.10M
 | Welded and Seamless Wrought Steel Pipe |
| * ASME B36.19M
 | Stainless Steel Pipe |
| * ASTM A105/A105M
 | Carbon Steel Forgings for Piping Applications |
| * ASTM A106/A106M
 | Seamless Carbon Steel Pipe for High‐Temperature Service |
| * ASTM A153/A153M
 | Zinc Coating (Hot‐Dip) on Iron and Steel Hardware |
| * ASTM A182/A182M
 | Forged or Rolled Alloy and Stainless Steel Pipe Flanges, Forged Fittings, and Valves and Parts for High‐Temperature Service |
| * ASTM A216/A216M
 | Steel Castings, Carbon, Suitable for Fusion Welding, for High‐Temperature Service |
| * ASTM A234/A234M
 | Piping Fittings of Wrought Carbon Steel and Alloy Steel for Moderate and High Temperature Service |
| * ASTM A240/A240M
 | Chromium and Chromium‐Nickel Stainless Steel Plate, Sheet, and Strip for Pressure Vessels and for General Applications |
| * ASTM A312/A312M
 | Seamless, Welded, and Heavily Cold Worked Austenitic Stainless Steel Pipes |
| * ASTM A320/A320M
 | Alloy‐Steel and Stainless Steel Bolting for Low‐Temperature Service |
| * ASTM A333/A333M
 | Seamless and Welded Steel Pipe for Low‐Temperature Service |
| * ASTM A350/A350M
 | Carbon and Low‐Alloy Steel Forgings, Requiring Notch Toughness Testing for Piping Components |
| * ASTM A351/A351M
 | Castings, Austenitic, for Pressure‐Containing Parts |
| * ASTM A352/A352M
 | Steel Castings, Ferritic and Martensitic, for Pressure Containing Parts, Suitable for Low‐Temperature Service |
| * ASTM A358/A358M
 | Electric‐Fusion‐Welded Austenitic Chromium‐Nickel Stainless Steel Pipe for High‐Temperature Service and General Applications |
| * ASTM A403/A403M
 | Wrought Austenitic Stainless Steel Piping Fittings |
| * ASTM A420/A420M
 | Piping Fittings of Wrought Carbon Steel and Alloy Steel for Low‐Temperature Service |
| * ASTM A516/A516M
 | Pressure Vessel Plates, Carbon Steel, for Moderate‐ and Lower‐Temperature Service |
| * ASTM A671/A671M
 | Electric‐Fusion‐Welded Steel Pipe for Atmospheric and Lower Temperatures |
| * ASTM A694/A694M
 | Carbon and Alloy Steel Forgings for Pipe Flanges, Fittings, Valves, and Parts for High‐Pressure Transmission Service |
| * ASTM A860/A860M
 | Wrought High‐Strength Ferritic Steel Butt‐Welding Fittings |
| * ASTM B148
 | Aluminum‐Bronze Sand Castings |
| * API 5L
 | Specification for Line Pipe |
| * MSS SP‐6
 | Standard Finishes for Contact Faces of Pipe Flanges and Connecting‐End Flanges of Valves and Fittings |
| * NACE MR0175‐ISO 15156
 | Petroleum and Natural Gas Industries- Materials for Use in H2S‐Containing Environments in Oil and Gas Production |
| * NACE TM-0284
 | Standard Test Method - Evaluation Of Pipeline And Pressure Vessel Steels For Resistance To Hydrogen-Induced Cracking |
| * NACE TM-0177
 | Laboratory Testing Of Metals For Resistance To Sulfide Stress Cracking And Stress Corrosion Cracking In H2s Environments |

## THE PROJECT DOCUMENTS

|  |  |
| --- | --- |
| * + BK-GCS-PEDCO-120-PI-RT-0001
 | Piping Corrosion Study & Material Selection Report |
| * + BK-GCS-PEDCO-120-PI-SP-0001
 | Piping Material Specification |

## ENVIRONMENTAL DATA

Refer to "Process Basis of Design; Doc. No. BK-GNRAL-PEDCO-000-PR-DB-0001”

* 1. **ORDER OF PRECEDENCE**

In case of any conflict between requirements specified herein & the requirements of any other referenced document, this subject shall be reflected to CLIENT and the final decision will be made by CLIENT.

1. **ABBREVIATIONS**

|  |  |
| --- | --- |
| AFC | Approved For Construction |
| AFD | Approved For Design |
| API | American Petroleum Institute |
| ASME | American Society of Mechanical Engineers |
| ASTM | American Society for Testing and Material |
| CL | Class |
| Cr | Chromium |
| C.S. | Carbon Steel |
| EFW | Electric Fusion Welded |
| FF | Flat Faced |
| Gr. | Grade |
| HIC | Hydrogen‐Induced Cracking |
| L.T.C.S. | Low Temperature Carbon Steel |
| MSS | Manufacturers Standardization Society |
| NPS | Nominal Pipe Size |
| PWHT | Post Weld Heat Treatment |
| RF | Raised Face |
| RTJ | Ring Type Joint |
| SAW | Submerged Arc Welding |
| SCH. | Schedule |
| SMLS | Seamless |
| SMYS | Specified Minimum Yield Strength |
| S.S. | Stainless Steel |
| STD | Standard |
| THK | Thickness |

1. **DESIGN**

##  DEFINITION AND TERMINOLOGY

###  CA

Corrosion Allowance (based on Piping Material Specification)

###  DESIGN LIMITS

Design Pressure / Design Temperature limits given in piping classes (based on Piping Material Specification) and are applied in Wall Thickness Calculation Table

## PIPING WALL THICKNESS CALCULATIONS

###  GENERAL

Based on ASME Codes for Pressure Piping Systems B31, there are three main different codes which are applicable in this project regard to Wall Thickness Calculation as follow.

###  PIPES WHICH ARE SUBJECTED TO REQUIREMENTS OF ASME B31.3

This codes deals with the pipes that are typically found in Petrochemical, Oil refineries, Gas Plants, Cryogenic Plants and related terminals.

**Pressure Design of Pipes**

Piping wall thickness calculation process follows the following formula:

 tmil = tm / ((100-M)/100)= tm /0.875

$$t\_{m}=t+c$$

Where:

tmil= Calculated wall thicknessconsidering Mill Tolerance

M= Mill Tolerance=12.5

tm = Minimum required thickness including mechanical, corrosion, and erosion allowances.

C = Sum of mechanical allowances (groove and thread depth) plus corrosion and erosion allowances.

t = Pressure designed thickness calculated as following formula if $t<{D}/{6}$

$$t=\frac{PD}{2(SEW+PY)}$$

Where:

P = Internal Design Gauge Pressure. The design pressure of each component in a piping system shall be not less than the pressure at the most severe condition of coincident internal or external pressure and temperature (minimum or maximum) expected during service.

D = Outside Diameter of Pipe

S = Stress Value for Material from Table A-1 of ASME B31.3 code.

Stress valve is indicated in that table as Basic Allowable Stress at metal Temperature. This value can easily be extracted with base of material and design metal temperature.

E = Quality Factor, A factor deals with the manufacturing (Cast, Welded, Seamless) of the components. The factors can be extracted from table A-1A for components manufactured by casting method and Table A-1B for the components manufactured by welding or seamless methods. According to the project specification casting method cannot be used for piping components except valves. So the factor E is extracted only from Table A-1B.

W = Weld Joint Strength Reduction Factor. That says welded joint strength may decrease during operation because of the temperature. This factor can be extracted from Table-302.3.5 of ASME B31.3.

Y = Coefficient Value deals with the effect of dimension on a component. That can be extracted from Table 304.1.1 of ASME B31.3 if t$<{D}/{6}$ .

 For $t\geq {D}/{6}$

 $Y=\frac{d+2c}{D+d+2c}$

1. **APPENDIXES**

APPENDIX 1

PIPING WALL THICKNESS CALCUALATION NOTE