



SPEC Oil and Gas FZCO
Plot # S61001, Jebel Ali Free zone
Dubai, UAE.

TECHNICAL DELIVERY CONDITION

Component Description	Ferritic Alloy Steel Pipe	TDC No: SPEC-TDC-PP-107
Project No.	-	Date:04-Dec.-2020
Item No. / Tag No.	Coded vessels	Rev No:0

1.	Code, Year of Edition	ASME Sec VIII DIV-1 Edition 2017
2.	Specification & Grade	Pipes shall comply with SA-335 Gr.P11/SA-335M Gr.P11, Ed 2017 of ASME Sec.II Part A & API 934-C
3.	Product form	Seamless Ferritic Alloy Steel Pipe.
4.	Manufacture and Supply Condition	As per SA-335 Gr.P11/SA-335M Gr.P11, Ed 2017 of ASME Sec.II Part A
		Requirements of SA-999/SA-999M, Ed 2017 of ASME Sec.II Part A, Specification for General Requirements for Alloy and Stainless Steel Pipe shall be satisfied.
		Hot finished
		All pipe shall be reheated for heat treatment and heat Treatment shall be normalize and temper. Tempering temperature shall be higher than PWHT temperature.
5.	Size and Quantity	As Per MR
		As Per MR
6.	Length SRL or DRL	As Per MR
7.	Product Marking	As per ASME SA-335 Gr.P11/SA-335M Gr.P11, Ed 2017 of ASME Sec.II Part A & SA-999/SA-999M, Ed 2017 of ASME Sec.II Part A.
8.	Impact Test	Yes, according to API 934-C at 0°F (-18°C), for base metal in as-delivered condition and after the simulation cycles for maximum and minimum heat treatment condition. The minimum CVN impact values at 0°F (-18°C) shall be 40 ft-lbs (54 Joules) average of three specimens and 20 ft-lbs (27 Joules) minimum for a single specimen. Percentage shear fracture shall meet 25% minimum. Lateral expansion shall also be reported for information.
9.	Test Report	As per SA-335 Gr.P11/SA-335M Gr.P11, Ed 2017 of ASME Sec.II Part A & SA-999/SA-999M, Ed 2017 of ASME Sec.II Part A & shall be in accordance with EN 10204:2004 type-3.2
10.	Hydrostatic test and / or NDE	Each length of pipe with outside diameter greater than 10 in. [250 mm] and wall thickness less than or equal to 0.75 in. [19 mm], shall be submitted to the hydrostatic test, Pipe of all other sizes shall be subjected to the nondestructive electric test in accordance with material specification ASME SA-335 Gr.P11/SA-335M Gr.P11, Ed 2017 of ASME Sec.II Part A. All mechanical test shall be as SA-335 Gr.P11/SA-335M Gr.P11, Ed 2017 of

[Signature]
04/12/2020



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		ASME Sec.II Part A & SA-999/SA-999M, Ed 2017 of ASME Sec.II Part A	
11.	End use of material	Pressure retaining component for shell and nozzle pipe. Not for coil bending or flattening.	
12.	Special requirements, if any	All materials shall be New. Provide product analysis report.	
13.	Dimensional Tolerance	ASME B36.10M Latest Edition	
14.	Additional Requirements, if any	Copy of material test reports shall be submitted for review and acceptance prior to shipment.	
		Simulated Post Weld Heat Treatment of mechanical test coupons as per API 934-C.	
		Minimum Heat Treatment condition: (Considering PWHT after fabrication in the shop) (As per 3.1.7 API 934-C).	
		Maximum Heat Treatment condition: (Considering 1 PWHT in shop + 1 Potential repair + 1 field PWHT) (As per 3.1.6 API 934- C).	
		Repair by welding on material is Not permitted.	
		Any deviation from this TDC shall be clearly and categorically indicated in the offer. If the vendor does not spell out any deviation, then the vendor's offer is in total conformity with this TDC.	
15.	Packing	Suitable for Safe Transport under preserved condition.	
Prepared By DE		Reviewed By LDE	Approved By EM
Name : Irina Cazacu		Name : Talha Fawad	Name : Marius Anita
Sign:		Sign:	Sign:
Date: 04-Dec-2020		Date: 04-Dec-2020	Date: 04-Dec-2020
			Reviewed By QCM
			Name :Royston Dsouza
			Sign:
			Date: 04-Dec-2020