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|---|--|---|-----------|--|---|
|  | Company DRAGON OIL (TURKMENISTAN) LTD. | Project EPIC of New Flare System at CPSF | | Contractor ES "SOVDA GURLUSHYK MASLAHAT" |  |
| | | | | Vendor Hunan Standard Steel Co., Ltd |  |
| Contract | Accounted Copy | Date | Signature | Doc. No: CPSF-QA-VND-01-HZ2032-704-01 | |
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DOTL: DRAGON OIL (TURKMENISTAN) LTD




PROJECT: EPIC OF NEW FLARE SYSTEM AT CPSF

DOCUMENT TITLE: INSPECTION AND TEST PLAN COATING

DOCUMENT №: CPSF-QA-VND-01-HZ2032-704-01

CONTRACT №: CFT/45/21/1034




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|------------|-------------|--------------------|-----------------|-----------------|-----------------|
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| A1 | 06.12.2024 | Issued for Review | | | |
| Rev | Date | Description | Prepared | Reviewed | Approved |

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Related terms are defined as follow:

| | |
|----------------|--|
| HOLD | <p>The relevant inspectors shall be informed of time and location of testing and witnessing is required for each unit.</p> <p>Witnessing is mandatory the cycle and written notice through a registered check advice at least 2 week in advance for special inspection or important stages and 24hoursin advance for regular inspection.</p> <p>Customer representative shall sign and seal the reports.</p> |
| Witness | <p>The relevant inspectors shall be informed of time and location of testing through a registered check advice or other kind of official letter which shall be submitted to related parties at least 2 week in advance for special inspection or important stages and 24 hours in advance for regular inspection.</p> <p>However, work may proceed without the presence of the inspector discretion.</p> <p>Customer representative shall sign and seal the reports.</p> |
| Monitor | <p>Work proceeds without the presence and special information of the test.</p> <p>Inspectors reserve the right to attend this activity at any time.</p> |
| Review | <p>Check of certifications and /or documents, with approved procedures, specification and acceptance criteria.</p> <p>Documents reviewed by Customer representative, shall be signed and sealed as reviewed.</p> |
| Perform | <p>Mill performs.</p> |

H-HOLD, **W**-Witness, **M**-Monitor, **R**-Review, **P**-Perform




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Coating Summary:




| Paint Requirement for CFT/45/21/1034 | | | | | | | |
|---|---------------------|---|---|---|--------|--------------------------|--------------------------|
| Description | Surface Preparation | Primer coat | Intermediate Coat | Top Coat | Brand | Color Shade/ RAL code | Total Dry Film Thickness |
| Uninsulated Operating tem up to 120 °C | SA 2.5 | Inorganic Zinc Silicate Jotun Resist 86 Jotun Thinner No. 4 DFT 75µm | Epoxy Polyamide Jotun Penguard FC Jotun Thinner No. 17 DFT 2×100µm | Polyurethane Hard top XP Jotun Thinner No. 10 DFT 75µm | Jotun. | Grey /RAL Code 9018 | 350µm |

Coating Quantity




| No. | Description | Specification | | | | Coating Quantity | | |
|-----|---|------------------|------------|---------------|---------|------------------|--------|--------|
| | | Diameter (mm) | WT (mm) | Length (m) | Kg/m | Pieces | m | Tons |
| 11 | PIPE BE, ASME B36.10M, SCH XS, Material: API 5L GR. B (PSL-2) SAW 100% RADIOGRAPHED Piping class: B013, BORE 1 (DN): 1000 | 1016.00 | 12.7 | 12 | 314.235 | 70.0 | 840.00 | 263.96 |
| 13 | PIPE BE, ASME B36.10M, SCH XS, Material: API 5L GR. B (PSL-2) SAW 100% RADIOGRAPHED Piping class: B013, BORE 1 (DN): 1000 | 1016.00 | 12.7 | 6 | 314.235 | 2 | 12.00 | 3.77 |

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| No. 序号 | Item 项目 | Controlling Requirement for testing 检验控制要求 | Testing Frequency 检验频次 | Testing Methods 检验方法 | Testing Instrument & Equipment 检验仪器设备 | Acceptability Criteria 可接受的标准 | Parties 检验方 | | |
|-----------|---|---|---------------------------|---|--|---|-------------------------------|----------------------------|--------------------------|
| | | | | | | | Report 报告 | Coating Factory 涂敷厂家 | TPI/Client 第三方/业 主 |
| 1.0 | Verification of the Calibration of the Inspection Equipment 检测仪器校准证书的审核 | | | | | | | | |
| 1.1 | Thermometer, Hygrometer 温度计 | AWWA C210-15 | One per shift 每班一次 | Manufacturer’s Recommendation 制造商建议 | N/A 不适用 | N/A 不适用 | Calibration Report 校验证书 | M | / |
| 1.2 | Profile Tester 锚纹测试仪 | AWWA C210-15 | One per shift 每班一次 | Manufacturer’s Recommendation 制造商建议 | N/A 不适用 | N/A 不适用 | Calibration Report 校验证书 | M | / |
| 1.3 | Far Infrared Temperature Measurement Instrument 远红外测温仪 | AWWA C210-15 | One per shift 每班一次 | Manufacturer’s Recommendation 制造商建议 | N/A 不适用 | N/A 不适用 | Calibration Report 校验证书 | M | / |
| 1.4 | Coating Thickness Gauge 测厚仪 | AWWA C210-15 | One per shift 每班一次 | Manufacturer’s Recommendation 制造商建议 | N/A 不适用 | The average of 5 reading shall be within ±5% of the reference value 读数偏 差值参考数值±5%) | Calibration Report 校验证书 | M | / |

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| | | | | | | | Report 报告 | Coating Factory 涂敷厂家 | TPI/Client 第三方/ 业主 |
| 1.5 | Pull-off tester 拉拔测试仪 | AWWA C210-15 | One per shift 每班一次 | Manufacturer's Recommendation 制造商建议 | N/A 不适用 | N/A 不适用 | Calibration Report 校验证证书 | M | / |
| 1.6 | Holiday Detector 漏点检测仪 | AWWA C210-15 | One per shift 每班一次 | Manufacturer's Recommendation 制造商建议 | N/A 不适用 | Travel speed: Between 0.2 and 0.3 meter per second Voltage:100V per mil of coating thickness (1500V maximum) (测试速度每 秒 0.2-0.3 米, 检漏电压 每密耳涂层厚度用 100 伏 电压检测, 最大检测电压 1500 伏) | Calibration Report 校验证证书 | M | / |

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| | | | | | | | Report 报告 | Coating Factory 涂敷厂家 | TPI/Client 第三方/业 主 |
| 2.0 | Raw Material Reception and Manufacturer’s Documentation （原材料接收和制造商资料） | | | | | | | | |
| 2.1 | Steel Pipe 钢管 | AWWA C210-15 &Rev 01 CFT 1034 painting Proposal check list- HSCO | Every Pipe 每根管 | Visual Measurement 目测 | N/A 不适用 | The steel pipe meets the contract requirements, the packaging and marking are intact, and the documents are complete 钢管符合合同要求，包装和标识完好，单据齐全 | Manufact urer 生产厂家 | RH | M |
| 2.2 | Inorganic Zinc Silicate 环氧富锌底漆 Jotun Resist 86 Jotun Thinner No. 4 | AWWA C210-15 &Rev 01 CFT 1034 painting Proposal check list- HSCO | Every Batch 每一批 | Visual Measurement 目测 | N/A 不适用 | The coating match the order; the packaging and labeling are intact, within valid expiry date and the documents are complete 涂料与订单相符合；钢包标签完好，有效期内，单据齐全 | Jotun | RM | / |
| 2.3 | Epoxy Polyamide 环氧中间漆 Jotun penguard FC Jotun Thinner No. 17 | AWWA C210-15 &Rev 01 CFT 1034 painting Proposal check list- HSCO | Every Batch 每一批 | Visual Measurement 目测 | N/A 不适用 | The coating match the order; the packaging and labeling are intact, within valid expiry date and the documents are complete 涂料与订单相符合；钢包标签完好，有效期内，单据齐全 | Jotun | RM | / |
| 2.4 | Polyurethane 聚氨酯面漆 Jotun Hard top XP Jotun Thinner No. 10 | AWWA C210-15 &Rev 01 CFT 1034 painting Proposal check list- HSCO | Every Batch 每一批 | Visual Measurement 目测 | N/A 不适用 | The coating match the order; the packaging and labeling are intact, within valid expiry date and the documents are complete 涂料与订单相符合；钢包标签完好，有效期内，单据齐全 | Jotun | RM | / |

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| No. 序号 | Item 项目 | Controlling Requirement for testing 检验控制要求 | Testing Frequency 检验频次 | Testing Methods 检验方法 | Testing Instrument & Equipment 检验仪器设备 | Acceptability Criteria 可接受的标准 | Parties 检验方 | | | | | | | | | | | | | | | | | | | | | |
|--------------------------------|---|--|-----------------------------------|--|--|--|---|-----------------------------|--------------------------|--------------------|-----------------------------|-----------------|---------|----------|---------------|---------------|-----------------|---------------------|---------|------------------|----------------|---------------------|------------|--------------------------------|-------------|-------------------------------------|--|---|
| | | | | | | | Report 报告 | Coating Factory 涂敷厂家 | TPI/Client 第三方/业 主 | | | | | | | | | | | | | | | | | | | |
| 3.0 | PQT 预涂合格检测 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| 3.1 | PQT 预实验 | Rev 01 CFT 1034 painting Proposal check list- HSCO | One for an order 一个订单一 次 | 3 rd Party Lab 第三方 实验室 | 3 rd Party Lab 第三方实验室 | PQT in the presence of Reputed TPI inspector at supplier premises (TUV NORDS/TUV SUD/SGS/BV) PQT shall be notified to DOTL in advance. All required parameters for PQT shall be recorded during coating application (Other test results for PQT shall be carried out in reputed Labs (by sending TPI stamped test coupon to labs and lab verifying TPI stamp and coupon ID) PQT 第三方见证，提前通知业主，所 有参数记录（其它实验截样在第三方 实验室完成，见如下） | Coating Departmen t & 3 rd Party 防腐 厂和第三 方实验室 | P | W | | | | | | | | | | | | | | | | | | | |
| 3.2 | PQT Sample Test in 3 rd party Lab PQT 样品第三方 实验室送检 | Rev 01 CFT 1034 painting Proposal check list- HSCO | One for an order 一个订单一 次 | <table><thead><tr><th>Property</th><th>Test Method</th></tr></thead><tbody><tr><td>Wet film thickness per coat</td><td>ASTM D1212-91</td></tr><tr><td>Dry film thickness</td><td>ASTM D4138-07/ASTM D6132-13</td></tr><tr><td>Total thickness</td><td>ISO2808</td></tr><tr><td>Adhesion</td><td>ASTM D3359-02</td></tr><tr><td>Degree ofCure</td><td>ISO12013-2:2012</td></tr><tr><td>Humidity Resistance</td><td>ISO6270</td></tr><tr><td>Water Resistance</td><td>ISO2812-2:2007</td></tr><tr><td>Surface Preparation</td><td>ISO 8502-9</td></tr><tr><td>Maximum Temperature Resistance</td><td>ASTM D-6944</td></tr></tbody></table> <p>Table 11.1 Tests to qualify Painting Systems</p> | | Property | Test Method | Wet film thickness per coat | ASTM D1212-91 | Dry film thickness | ASTM D4138-07/ASTM D6132-13 | Total thickness | ISO2808 | Adhesion | ASTM D3359-02 | Degree ofCure | ISO12013-2:2012 | Humidity Resistance | ISO6270 | Water Resistance | ISO2812-2:2007 | Surface Preparation | ISO 8502-9 | Maximum Temperature Resistance | ASTM D-6944 | 3 rd Party 第三方实 验室 | | P |
| Property | Test Method | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Wet film thickness per coat | ASTM D1212-91 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Dry film thickness | ASTM D4138-07/ASTM D6132-13 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Total thickness | ISO2808 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Adhesion | ASTM D3359-02 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Degree ofCure | ISO12013-2:2012 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Humidity Resistance | ISO6270 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Water Resistance | ISO2812-2:2007 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Surface Preparation | ISO 8502-9 | | | | | | | | | | | | | | | | | | | | | | | | | | | |
| Maximum Temperature Resistance | ASTM D-6944 | | | | | | | | | | | | | | | | | | | | | | | | | | | |

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| | | | | | | | Report 报告 | Coating Factory 涂敷厂家 | TPI/Client 第三方/业 主 |
| 4.0 | Steel Surface Preparation/ Blasting 钢管表面处理 | | | | | | | | |
| 4.1 | Environment Before Blasting 喷砂前的环境条件 | ISO 8502-9 | Once per Shift 每班一次 | Measured with instrument 用仪器测量 | Thermomet er, Hygrometer 温度计，湿 度计 | The pipe surface temperature shall be at least 3℃ above the dew point . The relative humidity of environment <85% 钢管表面温度比露点温度最小高 3℃；相对湿度<85% | Coating Department 防腐厂 | M | / |
| 4.2 | Blasting 除锈 | SA 2.5 | Once per Shift 每班一次 | Measured with instrument 用仪器测量 | Profile Tester 锚纹测试 仪 | Sa 2.5 | Coating Department 防腐厂 | M | M |
| 4.3 | Profile Depth 锚纹深度 | ISO 8502-9 | Once per Shift 每班一次 | Measured with instrument 用仪器测量 | Profile Tester 锚纹测试 仪 | 50-100 μ m | Coating Department 防腐厂 | M | / |
| 4.4 | Imperfection on the appearance after removing rust 除锈后表面缺陷 | ISO 8502-9 | Every Pipe 每支管 | Visual Measurement 目测 | N/A 不适用 | Without burr or welding residue,dust and sediment on the appearance must be cleaned 无毛刺和焊渣，表面附着的灰尘 及磨料清洗干净 | Coating Department 防腐厂 | M | M |

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| | | | | | | | Report 报告 | Coating Factory 涂敷厂家 | TPI/Client 第三方/ 业主 |
| 5.0 | Pipe coating 钢管涂敷 | | | | | | | | |
| 5.1 | Application temperature 涂敷温度 | AWWA C210-15&Rev 01 CFT 1034 painting Proposal check list- HSCO | one time per Shift 每班一次 | Measured with instrument 用仪器测量 | Infrared temperature measurement instrument 红外线测温 仪 | Temperature on the surface of pipe is 3° C higher than the environment dew point. The temperature of mixed epoxy material shall not be Lower than 10° C 钢管温度应该比露点温度高 3° C。 喷涂原料的温度不低于 10° C | Coating Departme nt 防腐厂 | H | / |
| 5.2 | Wet film thickness per coat 湿膜厚度 | ASTM D1212-91 | one time per Shift 每班一次 | Measured with instrument 用仪器测量 | Thickness gauge 测厚仪 | Primer: Jotun Resist 86≥105 μ m Intermediate: Jotun penguard FC≥ 250 μ m, Top: Jotun Hard top XP≥ 105 μ m（RAL 9018） | Coating Departme nt 防腐厂 | H | / |
| 5.3 | Dry film thickness 干膜厚度 | ASTM D4138-07/ASTM D6132-13 | Once per batch 每批一次 | Measured with instrument 用仪器测量 | Thickness gauge 测厚仪 | Primer: Jotun Resist 86≥75 μ m Intermediate: Jotun penguard FC≥ 200 μ m, Top: Jotun Hard top XP ≥75 μ m（RAL 9018） Total thickness≥350 μ m | Coating Departme nt 防腐厂 | H | M |
| 5.4 | Adhension 黏结性能 | ASTM D3359-02 | Once per batch 每批一次 | Instrument 用仪器测量 | Pull-off tester 拉拔测试仪 | ≥5Mpa | Coating Departme nt 防腐厂 | P | / |

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| 6.0 | Testing Offline 线下实验 | | | | | | | | |
| 6.1 | Appearance 外观 | AWWA C210-15&Rev 01 CFT 1034 painting Proposal check list- HSCO | Every Pipe 每只管 | Visual Measurement 目测 | N/A 不适用 | The epoxy shall be generally smooth and free of sharp protrusions. The epoxy shall have no blisters,cracks, bubbles, delaminations, or any other visible defects. There shall be no wet or sticky areas in the epoxy. 环氧树脂应光滑，无尖锐突出物。 环氧树脂不得有气泡，裂纹，分层或任何其他可见缺陷。环氧树脂中不得有潮湿或粘性区域 | Coating Department 防腐厂 | P | M |
| 6.2 | Cure 固化 | AWWA C210-15&Rev 01 CFT 1034 painting Proposal check list- HSCO | Once per batch 每批一次 | Visual Measurement 目测 | N/A 不适用 | Per Juton Instruction 符合油漆厂家要求 | Coating Department 防腐厂 | P | / |
| 6.3 | Dry film thickness 干膜厚度 | AWWA C210-15 &Rev 01 CFT 1034 painting Proposal check list- HSCO | Once per batch 每批一次 | Measured with instrument 用仪器测量 | Thickness gauge 测厚仪 | ≥350 μ m | Coating Department 防腐厂 | H | M |

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|-----------|---|--|------------------------------|---|--|---|------------------------------|----------------------------|--------------------------|
| | | | | | | | Report 报告 | Coating Factory 涂敷厂家 | TPI/Client 第三方/ 业主 |
| 6.4 | Electrical continuity inspection 电火花检测 | AWWA C210-15 | Every Pipe 每支管 | Measured with instrument 用仪器测量 | Holiday Detector 漏点检测仪 | The Voltage should be recommended by the epoxy manufacturer, No Holiday 无漏点; 供货商推荐电压值 | Coating Department 防腐厂 | H | M |
| 6.5 | Marking 标识 | As Contract/ PI required 根据合同要求 | Every Pipe 每支管 | Visual Measurement 目测 | N/A 不适用 | As Contract/ PI required 根据合同要求 | Coating Department 防腐厂 | P | M |
| 6.6 | Cut Back 预留长度 | AWWA C210-15 | Every Pipe 每支管 | Measured with instrument 用仪器测量 | N/A 不适用 | 150mm±20mm | Coating Department 防腐厂 | P | / |
| 7.0 | Package&Storage 存储 | | | | | | | | |
| 7.1 | Package 包装 | AWWA C210-15&Rev 01 CFT 1034 painting Proposal check list- HSCO | Every Pipe 每支管 | Visual Measurement 目测 | N/A 不适用 | As customer's request 根据客户要求 | Coating Department 防腐厂 | P | M |
| 7.2 | Storage 存储 | AWWA C210-15&Rev 01 CFT 1034 painting Proposal check list- HSCO | Every Pipe 每支管 | Visual Measurement 目测 | N/A 不适用 | Put steel pipes on the sleepers,and the distance from the bottom of coated pipe to land is 150mm 底层防腐管离 地面距离不低于 150mm | Coating Department 防腐厂 | P | M |

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|---|--|---|-----------|--|---|
|  | Company DRAGON OIL (TURKMENISTAN) LTD. | Project EPIC of New Flare System at CPSF | | Contractor ES "SOVDA GURLUSHYK MASLAHAT" |  |
| | | | | Vendor Hunan Standard Steel Co., Ltd |  |
| Contract | Accounted Copy | Date | Signature | Doc. No: CPSF-QA-VND-01-HZ2032-704-01 | |
| CFT/45/21/1034 | No. | | | Page 12 of 12 | |

| No. 序号 | Item 项目 | Controlling Requirement for testing 检验控制要求 | Testing Frequency 检验频次 | Testing Methods 检验方法 | Testing Instrument & Equipment 检验仪器设备 | Acceptability Criteria 可接受的标准 | Parties 检验方 | | |
|-----------|----------------|---|------------------------------|----------------------------|--|---|------------------------------|----------------------------|--------------------------|
| | | | | | | | Report 报告 | Coating Factory 涂敷厂家 | TPI/Client 第三方/业 主 |
| 8.0 | Document 文件 | | | | | | | | |
| 8.1 | Document 文件 | Meet contract requirement 满足合 同要求 | Every Order 每个订单 | N/A 不适用 | N/A 不适用 | Qualification Test Report signed by Inspector 质量检测报告第三方签字 | Coating Department 防腐厂 | H | H |