



NORDSEETAUCHER GmbH

International Diving Contractor



**Qualified
Professional
Underwater Pipeline
Wet Welding**

Shielded Metal Arc-Welding

Brankampweg 9, D-22949 Ammersbek, Germany
E-Mail: info@nordseetaucher.eu; Internet: www.nordseetaucher.de
Phone: +49 4102 2318-0; Fax: +49 4102 231820;
Mobile: +49 172 4300598

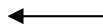
Hohe Bleichen 5, D-20354 Hamburg, Germany
E-Mail: info@impac.de; Internet: www.impact.de
Phone: +49 40 355440-0; Fax: +49 40 340500
Mobile: +49 162 1093444

presents

Qualified Professional Underwater SPM Pipeline Repair



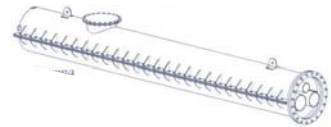
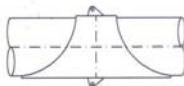
Welding



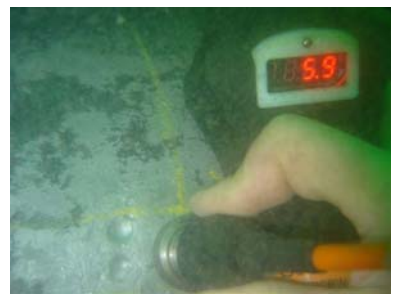
Clamp



Ultrasonic Test



The repair method was to cut out the damaged pipe sections and weld pipe spools to the 12" and 14" lines. The 8" line was repaired by off-the-shelf screwed-on clamps. The 36" carrier pipe repair consisted of half shells with appropriate seals bolted together.



IMPAC and Nordseetaucher have awarded the contract for the pipeline repair. All lines were successfully NDT and pressure tested and they are back in service.

PetroSA's pipeline is running from an onshore tank farm in Mossel Bay, South Africa, to a loading buoy 2.5km off the coast. The pipeline was damaged by a dragging anchor during a vessel manoeuvre in 20 - 25m water depth. The line consists of a bundle of 3 product pipes (8", 12" and 14") protected by a 36" carrier pipe.

Hyperbaric dry welding involves setting up a habitat around the welding point and the actual welding process is performed in a dry hyperbaric atmosphere. In contrast, hyperbaric wet welding takes place under direct contact with the surrounding water. With the vast improvements that have been made over the past years to welding process management and welding fillers, it is now possible to produce qualified wet welding work of best quality.

