

**SAROS DALGIÇ**  
**SAROS DIVER**  
**HAYRİ ATEŞER**



**QUALITY ASSURANCE SYSTEM**

**P - 21**

**PROCEDURE FOR COFFERDAM WITH REPAIR**

**1 - PURPOSE**

The SAROS DIVER HAYRI ATEŞER procedure for repair of shell plating due to local wastage.

**2- REPAIR PROCEDURE**

- a) Affected tank / space to be made gas free as required by Surveyor and or local regulations.
- b) Suitable cofferdam with efficient watertight seal to be located outside of the shell plating in way of the affected area.
- c) Cofferdam to be secured by welding claming devices (screw bolts) to shell plating.
- d) Seawater to be removed from cofferdam by appropriate means.
- e) Tank / space in which repair to be carried out to be deballasted / emptied.
- f) Affected area to be inspected by surveyor and Saros Diver representative and extent of repair to be agrees upon.
- g) Defect plating to be cropped using suitably radiussed corners.
- h) The insert plate to have appropriate material quality and to delivered with required certificate .
- i) Welding procedure, incliding welding sequence, to be made by Saros Diver and approved by the Surveyor.
- j) Edge preparation of shell plating and insert plate to be made in accordance with approved procedure.
- k) Insert plate to be fitted in place and weld preparation to be checked by Surveyor before welding is commenced.
- l) Full penetration welding to be carried out by certified welders in accordance with the approved procedure.
- m) Cofferdam to removed and outside shell to be ground flush in way of the weld penetration dry backweld from the outside to be performed if required by attending Surveyor video to be made.
- n) Ultrasonic testing of repair weld to be carried out from inside using qualified UT operator
- o) Final visual inspection to be carried out by Surveyor.



DET NORSKE VERITAS



Hellenic Register



Lloyd's Register



RINA



Russian Register



TÜRK LOYDU