This booklet has since the main revision (April 2009) been amended, most recently in October 2009. See the reference to "Amendments and Corrections" on the next page.
FOREWORD

DET NORSKE VERITAS (DNV) is an autonomous and independent foundation with the objectives of safeguarding life, property and the environment, at sea and onshore. DNV undertakes classification, certification, and other verification and consultancy services relating to quality of ships, offshore units and installations, and onshore industries worldwide, and carries out research in relation to these functions.

DNV Offshore Codes consist of a three level hierarchy of documents:

— Offshore Service Specifications. Provide principles and procedures of DNV classification, certification, verification and consultancy services.
— Offshore Standards. Provide technical provisions and acceptance criteria for general use by the offshore industry as well as the technical basis for DNV offshore services.
— Recommended Practices. Provide proven technology and sound engineering practice as well as guidance for the higher level Offshore Service Specifications and Offshore Standards.

DNV Offshore Codes are offered within the following areas:

A) Qualification, Quality and Safety Methodology
B) Materials Technology
C) Structures
D) Systems
E) Special Facilities
F) Pipelines and Risers
G) Asset Operation
H) Marine Operations
J) Wind Turbines
O) Subsea Systems

Amendments and Corrections

Whenever amendments and corrections to the document are necessary, the electronic file will be updated and a new Adobe PDF file will be generated and made available from the Webshop (http://webshop.dnv.com/global/).
Scope of the Offshore Standard
The DNV-OS-E304 replaces Certification Note 2.5 and gives requirements to materials, fabrication process, product quality and certification requirements for production of offshore mooring steel wire ropes and sockets.

Main changes:
— Requirements to forged sockets and duplex stainless steel pins have been included.
— Mechanical tests carried out on test coupons taken from full scale sockets are required.
— Clear division in requirements to steel wire ropes intended for mobile mooring and long term mooring.
— Modification with regard to requirements to corrosion protection for long term mooring.
— Revised requirements to performance criteria of socketing compound for long term mooring.
— More clear requirements to no. of breaking load tests to be carried out for long term mooring.
— General updating with regard to international standards and codes.
— The Approval of Manufacturer programme has been taken out of the standard, for inclusion into the Standards for Certification No.2.9.

• Main changes as of October 2009
Since the previous edition (April 2009), this document has been amended, latest in October 2009. All changes have been incorporated. The changes are considered to be of editorial nature, thus no detailed description has been given.
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CHAPTER 1

INTRODUCTION

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SECTION 1
GENERAL

A. General

A 100 Introduction

101 This Offshore Standard contains criteria, technical requirements and guidance on materials, design, manufacture and testing of offshore mooring steel wire ropes, sockets and pins.

102 The standard has been written for general world-wide application. Governmental regulations may include requirements in excess of the provisions by this standard depending on the size, type, location and intended service of the offshore unit or installation.

103 The objectives of this standard are to:

— provide an internationally acceptable standard of safety by defining minimum requirements for offshore mooring steel wire ropes, sockets and pins
— serve as a contractual reference document between manufacturers and purchasers
— serve as a guideline for designers, suppliers, purchasers and regulators
— specify procedures and requirements for offshore mooring steel wire ropes, sockets and pins subject to DNV certification and classification.

104 This standard is divided into three main chapters:

— Chapter 1: Section 1 with general information, scope, definitions and references
— Chapter 2: Sections 1 and 2 with technical provisions
— Chapter 3: Sections 1 to 4 giving specific procedures and requirements applicable for certification and classification in accordance with this standard. Also, requirements to design verification are given.

B. Normative References

B 100 General

101 The standards in Table B1 include provisions which, through reference in this text, constitute provisions of this offshore standard. Latest issue of the standards shall be used unless otherwise agreed.

102 Other recognised standards may be used provided it can be demonstrated that these meet or exceed the requirements of the standards in Table B1.

103 Any deviations, exceptions and modifications to the design codes and standards shall be documented and agreed between the supplier, purchaser and verifier, as applicable.

B 200 Reference documents

201 Applicable reference documents are given in Table B1.

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<table>
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<th>No.</th>
<th>Title</th>
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<td>ASTM E709</td>
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<td>ASTM A586</td>
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C 100 Verbal forms

101 Shall: Indicates requirements strictly to be followed in order to conform to this standard and from which no deviation is permitted.

102 Should: Indicates that among several possibilities one is recommended as particularly suitable, without mentioning or excluding others, or that a certain course of action is preferred but not necessarily required. Other possibilities may be applied subject to agreement.

103 May: Verbal form used to indicate a course of action permissible within the limits of the standard.

104 Agreement, agreed or by agreement: Unless otherwise indicated, agreed in writing between manufacturer and purchaser.

C 200 Terms

201 Purchaser: The owner or another party acting on his behalf, who is responsible for procuring materials, components or services intended for the design, fabrication or modification of a unit or installation.

202 Manufacturer: The party who is contracted to be responsible for planning, execution and documentation of manufacturing.

203 Non-destructive testing (NDT): Visual inspection, radiographic testing, ultrasonic testing, magnetic particle testing, penetrant testing and other non-destructive methods for revealing defects and irregularities.

204 Mobile mooring: Anchoring at a specific location for a period less than 5 years.

205 Long term mooring: Mooring of a unit at the same location for more than 5 years.

206 Unit: Is a general term for an offshore installation such as ship-shaped, column-stabilised, self-elevating, tension leg or deep draught floater.

207 Stranded rope: Assembly of several strands laid helically in one (single-layer rope) or more (rotation-resistant or parallel-closed rope) layers around a core or centre e.g. 6 × 19, 6 × 36, 6 × 61.

208 Spiral rope: Assembly of at least two layers of wires laid helically over a centre round wire, built-up strand or parallel-lay strand, with at least one layer of wires being laid in the opposite direction, i.e. contra-lay, to that of the outer layer(s) e.g. spiral strand, half locked coil, full locked coil.

209 Wire tensile strength grade: Level of requirement of tensile strength of a wire and its corresponding range, designated by the value according to the lower limit of tensile strength and used when specifying wire and when determining the calculated minimum breaking load or calculated minimum aggregate breaking load of a rope.

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<thead>
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CHAPTER 2

TECHNICAL PROVISIONS

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SECTION 1
GENERAL

A. Introduction

A 100 Steel wire rope constructions

101 Steel wire rope segments of mooring lines could be of various constructions as shown in Figure 1. Other type of constructions may also be used if relevant experience can be documented.

102 The stranded rope constructions include a number of strands wound in the same rotational direction around a centre core to form the wire rope. The number of strands and wires in each strand (e.g. 6 × 19, 6 × 36, 6 × 61) are governed by required strength and bending fatigue considerations for the wire rope. This construction generates torque as tension increases.

103 The torque balanced spiral rope constructions (spiral strand, half locked and full locked coils) do not generate significant torque with tension changes. These constructions use layers of wires (or bundles of wires) wound in opposing directions to obtain the torque balanced characteristics. The half locked and full locked coil constructions consist of one or more layers of shaped wires over the basic spiral rope construction resulting in a design more resistant to the ingress of corrosion media. The shaped layer(s) of wires will also prevent any outer wire fracture from unwinding. These constructions will normally give higher load capacity related to nominal diameter due to the increased metallic area, compared to other constructions.

Figure 1
Steel wire rope constructions

a) Six strand
b) Spiral strand
c) Half locked coil
d) Full locked coil

A 200 Corrosion protection measures

201 A common design requirement is that wire rope segments in mooring lines are to be protected against corrosion attacks throughout the design life. The wire rope is therefore assumed to be fully protected such that its fatigue life approaches that in air. This is normally ensured by the following measures or combinations thereof:

— Sacrificial coating of wires.
— Application of a blocking compound on each layer of the strand during stranding. The compound should fill all
crevices in the wire rope, strongly adhere to wire surfaces and have good lubricating properties.
— Surface sheathing of the wire rope by an extruded plastic jacket in order to prevent ingress of sea water and flushing out of blocking compound.

202 The ends of each wire rope segment are normally to be terminated with sockets. Resin shall be used for pouring the sockets. For long term mooring the sockets should be provided with bend stiffeners (bend limiting devices). This is to protect the wire ropes from bending during installation operations when the bending radiuses are close to the minimum allowed value. To prevent water ingress in the socket a sealing system may be incorporated in the device.

A 300 Guidance for choice of wire rope construction

301 For long term mooring spiral ropes are normally used. These ropes maximise the available steel area and provide high strength to size ratio, high axial stiffness and limited rotation under load (i.e. torque balanced as mentioned above). Further, these constructions are considered to have high corrosion resistance since a lower proportion of steel wire area is exposed and the ingress of water to the centre of the rope is more difficult than with stranded ropes. Also, the closed and compact design of these ropes are very suitable to jacketing for added corrosion protection. Within this type of ropes half locked and full locked coil constructions have a higher wear resistance than spiral strands because of the compact, near cylindrical surface. However, these are stiffer constructions and may, depending on the number of shaped wire layers, require more care during handling and installation. Locked coil ropes also require a larger bending radius than other constructions.

302 For mobile mooring stranded ropes are most commonly used. However, due to their flexibility, they may also be used in long term mooring systems as for example the upper short segment which is subject to winching damage, fairlead bending fatigue and splash zone corrosion. In these mooring systems stranded ropes may be considered as a “consumable” item which can be replaced every few years, whereas the lower segments are not intended to be replaced.

303 Type of rope construction and extent of corrosion protection must be a case to case evaluation depending on factors like design life, level of bending stresses, environmental conditions, position of the wire rope segment in the mooring system and possibilities for replacement of the wire rope segment.

304 In DNV-OS-E301 Sec.2 Table E2 guidelines for choice of wire rope construction as a function of field design life and possibilities for replacement have been given. However, it should be emphasized that this table is a rough guidance and that there are no distinct limits of use for each construction.
SECTION 2
MATERIALS

A. General

A 100 Scope

101 These requirements apply to steel and plastic materials used for the manufacture of offshore mooring steel wire ropes, sockets and pins.

102 The requirements given in E, F, and G are relevant for steel wire ropes in long term mooring lines.

B. Wires

B 100 Manufacture

101 The steels shall be manufactured by an electric or one of the basic oxygen processes or any other agreed process involving secondary refining.

102 The steels shall be killed and fine grain treated. The austenite grain size of the bar used for drawing of wire shall be 5 or finer in accordance with ASTM E112. The fine grain size requirement shall be deemed to be fulfilled if the steels contain Al, Nb, V or T, either singly or in any combination, as follows: When Al is used singly, the minimum total content shall be 0.020% or, alternatively, the Al to N ratio shall be minimum 2:1. When Al and Nb are used in combination, the minimum total Al content shall be 0.015% and the minimum Nb content shall be 0.010%. When Al and V are used in combination, the minimum total Al content shall be 0.015% and the minimum V content shall be 0.030%.

B 200 Chemical composition

201 The chemical composition shall be in accordance with EN 10016-4 or ISO 16120-4. Equivalent standards may be used subject to agreement.

B 300 Quality and strength

301 The wire shall be of homogenous quality, consistent strength and free from visual defects likely to impair the performance of the rope.

B 400 Wire finish

401 For spiral ropes the wire shall be hot dip coated or equivalent after final drawing. Wires for stranded ropes may be drawn coated or equivalent. In the case of galvanising, the zinc coating shall be continuous and of reasonably uniform thickness and shall comply with EN 1179:1995 grade Z3. Zn-Al alloys shall comply with ASTM B750, with or without Mischmetal.

402 For spiral ropes the minimum weight of zinc coating shall be in accordance with ASTM A586 Class A.

403 Stranded ropes shall at least conform to the standard to which the wire has been manufactured (API 9A/ISO 10425, EN 10264-2, ISO 2243 or equivalent).

C. Sockets and Pins

C 100 Manufacture

101 The steels shall be manufactured as given in B100. The prior austenite grain size of ferrite steel castings and forgings shall be 5 or finer in accordance with ASTM E112.

102 The manufacturer shall ensure that effective manufac-
ture and process controls are implemented in production. Where deviation from the controls occurs and this could produce products of inferior quality, the manufacturer shall investigate to determine the cause and establish countermeasures to prevent its recurrence. Investigation reports to this effect shall be made available to the purchaser on request

C 200 Chemical composition

201 Castings shall comply with the requirements of ASTM A487M Grade4 or equivalent. Grade 10 or equivalent may be used for sockets with large sections subject to agreement.

202 Forgings shall comply with 34CrNiMo6 according to EN 10083-1 or equivalent.

203 Pins may be cast, forged or rolled (wrought). If duplex material is used, it shall comply with EN 10088-2 Grade 1.4462 or ASTM A276 S31083. Super duplex material shall satisfy the requirements given for EN 10088-2 Grade 1.4501 or ASTM A276 S32760.

C 300 Heat treatment

301 Materials shall be heat treated for mechanical properties as specified in C400. Heat treatment shall be carried out in a properly constructed furnace which is efficiently maintained and has adequate means for temperature control and is fitted with recording-type pyrometers. The furnace dimensions shall be such as to allow the whole furnace charge to be uniformly heated to the necessary temperature.

302 Sufficient thermocouples shall be connected to the furnace charge where it is composed of forged or cast components. Normally, thermocouples should be connected by capacitor discharge welding.

303 Records shall identify the furnace used, furnace charge, date, temperature and time at temperature.

304 The manufacturer shall ensure that the specified heat treatment is adhered to. Where deviation from the specified heat treatment occurs, the manufacturer shall ensure that affected products are tested or submitted to reheat treatment and that an investigation is carried out according to C102.

C 400 Mechanical testing

401 Sockets and pins shall be sampled for mechanical testing as detailed in Sec.5 B100.

402 Sample material and test pieces shall be marked to identify them with the products represented.

403 The preparation of test pieces and the procedures used for mechanical testing shall comply with the relevant requirements of DNV-OS-B101.

404 The tensile test value shall satisfy the requirement of the actual material. In addition, the socket materials shall satisfy a Charpy V-notch energy of 50J at -20°C.

405 If the results from tensile testing do not meet the specified requirements, two further tensile tests may be made from the same sample. If both of these additional tests are satisfactory, the test unit may be accepted.

406 If the results from a set of three impact test pieces do not meet the specified requirements, three additional test pieces from the same sample may be tested and the results added to those previously obtained to form a new average. If this new average complies with the requirements and if not more than two individual results are lower than the required average and, of these, not more than one result is below 70% of the specified average value, the test unit may be accepted.
407 Where forgings or castings and the associated test material are submitted to re-heat treatment, they may not be re-austenitised more than twice. All the tests previously performed shall be repeated after re-heat treatment and the results must meet the specified requirements.

**C 500 Inspection**

501 Materials are subject to, non-destructive testing (NDT) and measurements of dimensions as detailed in Sec.5. The manufacturers shall prepare written procedures for NDT. NDT personnel shall be qualified and certified in accordance with recognised standards or schemes, e.g. ISO 9712, EN 473, SNT-TC-1A or equivalent. NDT operators shall be qualified to at least level II.

502 NDT shall be performed in accordance with the general practice of recognised standards, e.g.:

- Magnetic particle testing (MT) of forgings: EN 10228-1, ASTM A275, using wet continuous magnetization technique
- Ultrasonic testing (UT) of forgings: EN 10228-3, ASTM A388
- Magnetic particle testing (MT) of castings: ASTM E709, using wet continuous magnetization technique
- Ultrasonic testing (UT) of castings: ASTM A609

503 UT of forgings or castings shall be carried out at an appropriate stage after the final heat treatment for mechanical properties and prior to machining operations that limit effective interpretation of the results of the testing.

**C 600 Repair**

601 Surface defects may be removed by grinding as detailed in Sec.5 B300. The resulting grooves shall have a bottom radius of approximately three times the depth and shall be blended into the surrounding surface to avoid any sharp contours. Complete elimination of the defective material shall be verified by suitable NDT.

602 Except as provided for steel castings, repair by welding is not permitted.

**C 700 Identification**

Each forging or casting shall be suitably identified with at least the following:

- identification number, heat number or other marking that will enable the history of the item to be traced
- steel grade designation.

---

**D. Socketing Compound**

**D 100 General**

101 A resin socketing system shall be used. The following performance criteria shall be met:

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<tr>
<td>Barcol hardness:</td>
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<tr>
<td>Specific gravity:</td>
</tr>
</tbody>
</table>

102 Whenever possible, the pouring of all sockets should be accomplished using one master batch of resin i.e. all the kits shall have the same unique batch number.

---

**E. Surface Sheathing**

**E 100 General**

101 Where required by the purchaser, a medium or high density plastic material preferably polyethylene in accordance with ASTM D 1248 or equivalent shall be used as surface sheathing. Material data shall be documented by the manufacturer.

102 The sheathing should have a light colour in order to improve possibilities for video inspection of the wire rope surface in submerged condition. An axial stripe should be provided on the sheathing to control possible twisting of the wire rope.

---

**F. Bend Stiffener**

**F 100 General**

101 Where required by the purchaser, a plastic material (preferably polyurethane), should be used as bend stiffeners. Material data shall be documented by the manufacturer.

---

**G. Lubricating/Blocking Compound**

**G 100 General**

101 The lubricating/blocking compound shall be stiff but not solid, and shall have good adhesive properties over the actual operating temperature range. The compound shall be compatible with the sheathing material and shall have long term durability with seawater. Further, the compound shall comply with the basic requirements given in ISO 4346 or equivalent standards.
**SECTION 3**

**DESIGN ASSESSMENT**

**A. General**

**A 100 Scope**

101 This section covers requirements to basic documentation and testing procedures in order to perform a design check and issue Design Verification Reports (DVR) for the actual wire rope construction and socket.

**A 200 Basic documentation**

201 The design verification aims at confirming that the proposed wire rope construction and socket design satisfy the specified design conditions, codes and standards.

202 The work consists of review of calculations, drawings and other data supplied by the manufacturer documenting the strength and serviceability of the actual wire rope construction and socket.

203 The following information is required as a minimum:

- list of design codes and standards including purchaser’s specifications
- purchaser supplied design premises including imposed loads and excursions at the end of the line and other relevant design data
- strength and fatigue calculations for the ropes and sockets including dynamic loading
- details of all rope, socket, and plastic materials including mechanical, corrosion resistance and fatigue properties
- details and calculations for corrosion protection methods
- applicable drawings for ropes and sockets including bill of materials
- a summary of service experience where available.

204 It is assumed that materials and rope/socket test data will be made available to the purchaser as and when required.

**B. Design Verification Criteria of Wire Rope**

**B 100 Strength and fatigue analysis**

101 The calculated static strength of the wire rope shall be at least equal to or exceed the minimum certified breaking load.

102 Fatigue calculations should be carried out according to DNV-OS-E301 or equivalent standards subject to agreement.

**B 200 Testing procedures**

201 The conditions for acceptance is that testing of the wire rope construction is found to be satisfactory. For acceptance one break load test from the first manufactured length shall be carried out as follows:

- Prior to the break load test an elastic modulus test shall be performed on the test sample. The sample shall be loaded (cycled) until full stabilisation is reached. The load/extension and permanent stretch shall be recorded and reported.
- Load test of the sample to the minimum certified breaking load.

202 The wire rope construction will be considered to have passed test a) if the permanent elongation of the rope is less than 0.4% for a spiral rope and 0.8% for a stranded rope and test b) if the test sample equals the minimum certified breaking load.

203 For the above test, the sample does not require actual production sockets to be fitted.

**C. Design Verification Criteria of Socket**

**C 100 Strength and fatigue analysis**

101 The strength of the socket and pin shall be at least that of the minimum certified breaking load of the rope. The fatigue strength should be evaluated against the design life of the mooring system.

**C 200 Testing procedures**

201 The conditions for acceptance is that testing of the sockets and pins is found to be satisfactory. For acceptance one socket shall be tested. The same methods, procedures and materials shall be used to connect the rope to the socket as those used to produce the rope/socket connection for in-service use. The following test is required:

202 Loading of the socket and pin to the minimum certified breaking load of the wire rope for a duration of 30 seconds followed by MT inspection of the pin and defined critical areas of the socket.

203 The socket will be considered to have passed the test if the following is satisfied:

- a) The pin can be removed from the socket and replaced without unreasonable application of force.
- b) The MT passes the requirements in Sec.5 B200.
SECTION 4
WIRE ROPE MANUFACTURE

A. General

A 100 Scope
101 This section covers tests to be carried out on wires and general manufacturing requirements of wire ropes.

A 200 Quality Plan
201 Prior to manufacturing a Quality Plan shall be established by the manufacturer and accepted by the purchaser. The Quality Plan shall describe activities to be performed, frequency and type of inspection/tests, criteria to be met as well as give reference to applicable controlling documents.

B. Manufacture

B 100 Wire manufacture
101 The wire shall be manufactured to one of the following wire standards or to an equivalent standard:
Round wire – ASTM A603, ASTM A586, EN 12485-10, EN 10264-2, ISO 2232, API 9A/ISO 10425
Shaped wire – EN 10264-3.
102 The minimum tensile strength of the wire shall be the tensile strength grade ordered. The tensile strength grade of the wires shall be maximum 2 160 N/mm². If the upper tensile strength limit is not defined by the wire standard, it shall not exceed the minimum tensile strength by more than 260 N/mm².
103 If any of the specified wire tests fail to meet the actual specification, a further two test samples shall be selected from the same wire bundle and tested. If both tests meet the specification, the wire bundle is accepted as satisfactory.
104 If any of the above tests are performed on wires taken from an already manufactured wire rope, the testing shall follow the requirements of ISO 3178 or equivalent.

B 200 Stranding and closing
201 The wire ropes shall be manufactured in accordance with the assessed and accepted design (see Sec.3). Winding, stranding and closing operations are to be carried out as detailed in the accepted Quality Plan.
202 The core of a stranded rope shall normally be an independent wire rope (IWRC).
203 Each wire rope segment shall be checked for dimensions (length and diameter). The manufacturer shall provide a statement indicating compliance with the purchaser’s requirements.

204 Before welding of individual wires, a welding procedure qualification test shall be carried out. The procedure shall comprise tensile testing of the welded joint. The following requirement applies:
— Tensile strength to be min. 40% of the strength of the wires.

205 In addition, for spiral ropes the following apply:
— No welds of finished wire shall be made in the outer layer of the strand without notifying the purchaser.

Guidance note:
Welds in the outer layer shall be made on the basis of mechanical failure and not material defects. If any recurrent material defect is found to be the reason for outer layer failure, then the entire wire should be removed and replaced.

---e-n-d---of---G-u-i-d-a-n-c-e---n-o-t-e---
— No welds of finished wire shall be made within 5 m of the socket in any layer of wires
— No welds of finished wire shall be closer to another weld than 10 lay lengths in any layer of wires.
— In the event of more than two wire breaks requiring welds, occurring within any layer of wires, no further layers of wire shall be applied without a full investigation into the reasons and with the acceptance of the purchaser to continue.
— The positions of all welds of finished wire shall be recorded and reported to the purchaser for acceptance.
— All repairs shall be recorded in the final wire rope documentation.

206 The lubricating/blocking compound shall be applied on each layer of the strand during stranding providing internal lubrication and preventing water intrusion.

B 300 Surface sheathing
301 If sheathing of the wire rope is required by the purchaser, the process shall be carried out in accordance with the accepted Quality Plan.
302 Process controls should include measurements of overall diameter, sheathing thickness and tolerances, and continuous integrity tests.
303 All repairs shall be carried out in accordance with a repair procedure specification which shall be based on manufacturer’s previous experience and which has produced appropriate repairs and shown satisfactory service performance over a prolonged period of time.
SECTION 5
MANUFACTURE AND ASSEMBLY OF SOCKETS AND ACCESSORIES

A. General

A 100 Scope

101 This section covers mechanical- and non-destructive tests to be carried out on sockets and pins and general manufacturing requirements to the socketing operation and bending limiter.

A 200 Quality plan

201 Prior to manufacturing a Quality Plan shall be established by the manufacturer and accepted by the purchaser. The Quality Plan shall describe activities to be performed, frequency and type of inspection/tests, criteria to be met as well as give reference to applicable controlling documents.

B. Sockets and Pins

B 100 General

101 Sockets and pins shall be manufactured in accordance with the assessed and accepted design (see Sec.3).

102 For socket production testing normally one socket from the first production batch shall be sectioned and sample taken as per Figure 1. Additionally, production tests shall be carried out for sockets and pins using test coupons. These test coupons from which test specimens are prepared, shall be of equivalent cross section and be fully representative of the socket and where appropriate, shall not be cut, or partially cut from the socket until heat treatment has been completed. Test material and test specimen shall not be separately heat treated in any way.

103 Test sample for production testing of the pin, shall be cut R/3 from the surface as shown in Figure 2. The longitudinal axis of the test specimens shall be one third radius below the surface. The test sample may also be taken from a prolongation of the pin.

104 Sockets or pins of the same nominal thickness originating from the same heat treatment charge and the same heat of steel, shall be combined into one test unit. Normally, for each test unit one tensile and three Charpy V-notch test specimens shall be taken.

Figure 1
Sampling for mechanical testing of socket

Figure 2
Sampling for mechanical testing of pin
B 200 NDT

201 After heat treatment and machining but before coating (e.g. galvanising) the sockets/pins shall be non-destructively tested.

202 All the sockets/pins shall be 100% visually tested. For castings, the quality of the surface shall be as given in ASTM A703 Item 10.

203 The sockets/pins shall have defined critical areas subject to agreement. All of the sockets/pins shall be examined ultrasonically in critical and non-critical areas in accordance with the standards referred in Sec.2 C500.

204 For castings, ultrasonic indications less than 25 mm apart shall be evaluated as one discontinuity. The ultrasonic acceptance criteria are the following: No planar discontinuities are allowed in any location. In addition, Quality level 1 will be required down to a depth of T/4 from the surface and Quality level 2 for the remainder of the wall thickness. Quality level 3 is required for non-critical areas.

205 For forgings the acceptance criteria shall be in accordance with DNV-OS-302 Ch.2 Sec.1 C600. For duplex stainless steel forgings the acceptance criteria are given in DNV-OS-F101 Appendix D paragraph D500.

206 Specified sockets subject to ultrasonic examination shall in addition, undergo radiographic examination in accordance with ASTM A703 Supplementary requirements S5. Radiographic examination shall not be confined to critical areas of the casting as defined by design high stress including sharp changes of section and feeder locations, also non-critical areas where there is a high probability of finding sand inclusions, shrinkage cavities etc. shall be examined. Number of sockets to be tested shall be according to Table 2. The acceptance criteria are to be severity level 3, or better, for all imperfection categories except that critical areas are to be subjected to the acceptance criteria of ASME Section VIII, Division 1, Appendix 7.

207 All the sockets/pins shall be examined 100% by magnetic particle testing or liquid penetrant testing following the standards given in Sec.2 C500. The acceptance criteria for cast sockets shall be in accordance with ASTM E 125, Severity Degree 2 or better for surface indications Type II through V and 3/16 " max. for Type I except that critical areas shall be subjected to the acceptance criteria of ASME Section VIII, Division 1, Appendix 7. For forged sockets, the acceptance criteria shall be in accordance with DNV-OS-302 Ch.2 Sec.2 C700. For duplex stainless steel forgings the acceptance criteria are given in DNV-OS-F101 Appendix D D500.

B 300 Repairs

General

301 Defects on non-machined surfaces may be removed by grinding to a depth of 5% of the nominal thickness. Grinding is not permitted on machined surfaces, except for slight inspection grinding on plane surfaces in order to investigate spurious indications.

302 Where the repair entails removal of more than 5% of the diameter or thickness on castings, the defective area shall be repaired by welding. The excavations shall be suitably shaped to allow good access for welding. The resulting grooves shall be subsequently ground smooth and complete elimination of the defective material shall be verified by NDT.

303 Weld repairs are classified as major or minor. A weld repair is considered major when the depth of the groove prepared for welding exceeds 25% of the thickness or 25 mm, whichever is smaller. All other weld repairs are considered minor.

304 Major weld repairs require the approval of the purchaser before the repair is commenced. Proposals for major repairs shall be accompanied by sketches or photographs showing the extent and positions of the repairs. A grain refining heat treatment shall be given to the whole casting prior to major repairs.

305 Minor weld repairs must be recorded on sketches or photographs showing the extent and positions of the repairs.

306 All weld repairs shall be done by qualified welders using qualified procedures in accordance with DNV-OS-C401.

307 The welding consumables used shall be of a suitable composition giving a weld deposit with mechanical properties similar to those of the parent castings. Low hydrogen consumables shall be used. Welding consumables shall be stored and handled so as to maintain the hydrogen classification and in accordance with the manufacturer’s recommendations.

308 When repair welding is done after the casting has been heat treated for mechanical properties, the repaired casting shall be given a furnace stress relieving or tempering heat treatment as detailed in the qualified procedure.

309 On completion of heat treatment the weld repairs and adjacent material shall be ground smooth. All weld repairs are subject to NDT as required by B200.

B 400 Corrosion protection

401 The sockets shall be protected against corrosion attacks throughout the design life. This shall normally be accomplished by using a combination of coating and anodes.

C. Socketing

C 100 Socketing procedures

101 Socketing procedures shall as a minimum be according to applicable sections of ISO 17558 or equivalent standards. Socketing shall be performed by personnel qualified by the manufacturer and carried out in compliance with procedures and check lists worked out by the manufacturer and evaluated and accepted by the purchaser. Such procedures should as a minimum include:

- minimum bending radius of rope during handling
- control of even distribution of individual wires at rope termination prior to socket pouring
- determination of tolerances for angular and parallel offsets of rope and socket axis
- control of angularity and parallelism of rope and socket axis before casting of resin (i.e. position of socket related to rope).

C 200 Verification of properties

201 Verification of the compressive strength and modulus of elasticity of the socketing compound shall be addressed using ISO 604. The test samples shall be 40 mm cubes cast in multicavity moulds. The resin cubes shall be post cures at 80°C for two hours prior to testing.

202 For each socket pour a minimum sampling of six cubes shall be taken during the pouring process. One of these cubes shall be used to determine the Barcol hardness (EN 59) and the specific gravity of the mix (Note: Different sample sizes may be used for the Barcol test only e.g. 70 mm cube or 70 mm diameter disc.) The remaining five cubes can be used to deter-
mine the compressive strength and compressive modules. As a minimum, however, values for compressive strength and compressive modulus shall be established for the first three socket pours, the middle three socket pours and the near final three socket pours. The results shall comply with the properties specified in Sec.2 D100. Samples not tested shall be stored for a period to be agreed between the manufacturer and purchaser and purchaser.

D. Bend Stiffener

D 100 General

101 If bend stiffeners are required by the purchaser, they shall be manufactured in accordance with the accepted Quality Plan.
SECTION 6
TESTS OF STEEL WIRE ROPE INTENDED FOR LONG TERM MOORING

A. General

A 100 Scope
101 This section covers requirements to testing of wire ropes intended for long term mooring in order to determine that the minimum certified breaking load of the wire rope has been equalised.

A 200 Description of tests
201 The tests shall be carried out according to recognised standard such as ISO 3108 or equivalent.
202 The type of tests required are described in Sec.3 B200 and C200. Normally, the following 3 tests shall be performed:
   — one modulus/load to MBL test assembly (test sockets may be used on each end)
   — one open socket production type test assembly
   — one closed socket production type test assembly.

203 Regarding the production type test assemblies, the rope samples shall be fitted in one end with a socket identical to the approved design and using the same methods, procedures and materials as those used to produce the rope/socket connection for in-service use.
204 The number of tests may be reduced to 2 if the modulus/load to MBL test is combined with one of the production type test assemblies.
205 In the event that all of the sockets are of the same type (open or closed), a minimum of two tests from different manufactures, shall be required one of which shall be a type test.
206 In the case of only a small number of wire ropes ($\leq 3$) to be delivered, the number of tests may be reduced to one by agreement.
207 Test acceptance criteria are given in Sec.3 B200 (wire rope) and C200 (socket).
SECTION 7
TESTS OF STEEL WIRE ROPE INTENDED
FOR MOBILE MOORING AND TOWING

A. General

A 100 Scope

101 This section covers requirements to testing of wire ropes intended for mobile mooring and towing in order to determine that the minimum certified breaking load of the wire rope has been achieved.

A 200 Description of tests

201 Every manufactured length of wire rope shall be subjected to a breaking load test. However, in the case that the manufactured lengths are produced on the same machine with the same machine settings, according to the same wire rope design and by using wires to the same wire specification, the number of break load tests may be reduced after special consideration and in agreement with the Purchaser.

202 The breaking load shall be determined by testing to destruction a sample cut from the finished wire rope. The test length shall be taken as at least 30 times the rope diameter between the grips. The actual breaking load shall not be less than given in Table 4 for the dimension concerned. For other wire rope constructions and/or diameters the breaking load shall be in accordance with the requirements of a recognised national or international standard subject to agreement.

203 If facilities are not available for pulling the complete section of six strands ropes to destruction, the breaking load may be determined by testing separately 10% of all wires from each strand. The breaking load of the rope is then considered to be:

\[ S_{mb} = f t k_1 \] (kN)

\( f \) = average breaking load of one wire (kN)
\( t \) = total number of wires
\( k_1 \) = lay factor as given in Table 3.

<table>
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<th>Table 3 Lay factor ( k_1 )</th>
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<th>Table 4 Test loads and masses for six strand steel wire ropes</th>
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<td>Rope with fibre core (FC)</td>
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<table>
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<tr>
<th>Construction groups</th>
<th>Nominal diameter (mm)</th>
<th>Minimum required breaking strength in kN</th>
<th>Approximate mass (kg/100 m)</th>
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Rope with independent wire-rope core (IWRC)
### Table 4 Test loads and masses for six strand steel wire ropes (Continued)

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<th>Construction groups</th>
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<th>Approximate mass (kg/100 m)</th>
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SECTION 8
IDENTIFICATION AND RECORDS

A. General

A 100 Identification

101 All parts shall be clearly marked and identifiable to ease quality control, handling, assembly and installation.

102 Each wire rope segment shall be marked at each end with a unique identifier traceable to appropriate certification.

A 200 Records

201 The socket manufacturer shall maintain traceable records of the following and present them to the purchaser on request:

— steelmaking process and chemical composition
— heat treatment
— mechanical testing
— inspection
— repair.

202 Each wire rope segment shall be supplied with one certificate. The certificate should refer to the following:

— purchase order No.
— design verification reports
— sheathing process reports (if relevant)
— 3.2 Inspection Certificates for the sockets including the resin
— 3.2 Inspection Certificates for the individual wires.

203 In addition the certificate should contain the wire rope construction and rope built up and a statement saying that the wire rope has been manufactured and inspected and found to be in accordance with this standard.
CHAPTER 3

CERTIFICATION AND CLASSIFICATION

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SECTION 1
CERTIFICATION AND CLASSIFICATION - REQUIREMENTS

A. General

A 100 Introduction
101 As well as representing DNV’s recommendations on safe engineering practice for general use by the offshore industry, the offshore standards also provide the technical basis for DNV classification, certification and verification services.

102 A complete description of principles, procedures, applicable class notations and technical basis for offshore classification is given by the DNV Offshore Service Specifications for classification, see Table A1.

Table A1 DNV Offshore Service Specifications

<table>
<thead>
<tr>
<th>No.</th>
<th>Title</th>
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<tr>
<td>DNV-OSS-101</td>
<td>Rules for Classification of Offshore Drilling and Support Units</td>
</tr>
<tr>
<td>DNV-OSS-102</td>
<td>Rules for Classification of Floating Production and Storage Units</td>
</tr>
</tbody>
</table>

A 200 Certification and classification principles

201 Mooring steel wire ropes and sockets will be certified or classified based on the following main activities:

— design verification
— approval of manufacturers
— survey during manufacture.

A 300 Assumptions

301 Any deviations, exceptions and modifications to the design codes and standards given as recognised reference codes shall be documented and approved by DNV.

302 Aspects of the design and construction provisions of this standard which are stated to be specially considered, agreed upon, or may be accepted, are subject to DNV approval when the standard is used for classification purposes.

303 DNV may accept alternative solutions found to represent an overall safety level equivalent to that stated in the requirements of this standard.

A 400 Documentation requirements

401 Documentation requirements shall be in accordance with the NPS DocReq (DNV Nauticus Production System for documentation requirements) and DNV-RP-A201.

B. Certification and Classification Requirements

B 100 General

101 The following requirements shall be applied in conjunction with the technical requirements in Ch.2 of this standard when used for certification or classification purposes.

B 200 Information to be supplied by the purchaser

201 The purchaser shall supply the manufacturer with all information necessary to ensure correct material and certification. This applies particularly where optional or additional conditions are specified.

B 300 Design verification

301 Mooring steel wire ropes and sockets shall be designed according to requirements given in Ch.2 Sec.3. Where designs differ from this, the drawings and calculations shall be submitted to DNV for approval.

Guidance note:

Design requirements are given in DNV-OS-E301.

302 Design approval shall be documented by design verification report (DVR), type approval certificate or approval letter.

B 400 Approval of manufacturers

401 Steel wire ropes and sockets shall be manufactured at works which have been approved by DNV. Approved manufacturers are published on DNV Exchange on the Internet.

402 In order to be approved, the manufacturer shall demonstrate and submit documentation to the effect that the necessary manufacturing, testing and inspection facilities and procedures are available and are supervised by qualified personnel. The manufacturer shall also carry out a test programme and submit the results.

403 Detailed programmes for approval are given in Standards for Certification No.2.9.

B 500 Survey during manufacture

501 Survey during manufacture of mooring steel wire ropes and sockets shall be based on attending tests and inspections, monitoring manufacturing, and review of records.

B 600 Certification of sockets

601 Sockets shall be delivered with DNV certificates giving the following particulars for each test unit which has been accepted:

— purchaser's name, order number and unit identification, where known
— manufacturer's name
— number and dimensions of sockets
— identification marking of sockets
— heat number and chemical composition
— results of mechanical tests
— details of heat treatment of test material
— results of any supplementary and additional test requirements specified.

B 700 Certification of mooring steel wire ropes

701 Mooring steel wire ropes shall be delivered with DNV certificates giving the following particulars for each test unit which has been accepted:

— purchaser's name, order number and unit identification, where known
— manufacturer's name
— description of products and dimensions
— type of wire rope construction and method of manufacture
— surface sheathing (if relevant)
— identification marking
— results of break load test and mechanical tests
— confirmation of dimensional measurements and inspections

702 Materials for wires shall be delivered with the manufacturer’s certificates or test reports.