

	<b>PROJECT</b>		<b>Standby SRU &amp; Additional Tanks</b>		
	<b>CLIENT</b>		<b>IOCL Paradip Refinery</b>		
JOB SPECIFICATION FOR AIR BLOWING OF PIPING AND EQUIPMENT	<b>Project No.</b> 080557C001	<b>Document No.</b> 080557C-000-JSC-0093-006		<b>Rev. No.</b> 0	Page 1 of 14

# JOB SPECIFICATION FOR AIR BLOWING OF PIPING AND EQUIPMENT

0	04/12/2019	ISSUED FOR IMPLEMENTATION	KMK	TNVS	TNVS	JMC
<b>REV.</b>	<b>DATE</b>	<b>DESCRIPTION</b>	<b>PREPARED</b>	<b>CHECKED</b>	<b>APPROVED</b>	<b>AUTHORIZED</b>

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## 1. Introduction:

**INDIAN OIL CORPORATION LIMITED (IOCL)** has awarded Fax of Acceptance (FOA) dated 29<sup>th</sup> August 2019 to M/s. Technip India Limited (TPIL) for Consultancy services (PMC/EPCM services) for overall project management, FEED Review / FEED, Detailed Engineering, Procurement & expediting services, Tendering & award, Construction Management & Supervision, Assistance in start-up, Commissioning & performance test runs for installation of a Standby SRU of 525 TPD capacity and execution of Additional tanks for Paradip Refinery, Odisha, India.

## 2. Definitions & Abbreviations

Abbreviation	Definition /Expanded form
IOCL/ CLIENT	Indian Oil Corporation Limited
PMC/ CONSULTANT	Technip India Limited
LICENSOR	Party selected by IOCL for process technology ownership for any UNIT
CONTRACTOR	Party whose services are obtained for performing the works specified as part of LSTK / packages.
EPCM	Engineering, Procurement & Construction Management Services.
LSTK	Lump Sum Turn Key portion of the work to be executed by CONTRACTOR
FEED	Front End Engineering Design
AUTHORISED REPRESENTATIVE	IOCL's/ CONSULTANT's representative authorized to act for and on behalf of them.
VENDOR	Any third party supplying the equipment/materials for setting up the Plant
PROJECT	Indicates Standby SRU and Additional tanks Project, Paradip Refinery
UNIT	Indicates any particular portion of the project to be built which can be Process related or Utilities/Offsites related
SRU	Sulphur Recovery Unit

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### 3. General

The purpose of air blowing is to eliminate from piping and equipment all foreign matter such as metal pieces, welding slags, sand, earth, bolts, tools, etc. which may otherwise plug pipes, control valves and orifices and cause serious damage to moving parts of equipment.

### 4. Scope

The scope of this procedure is to establish the guidelines for Air Blowing of Piping and Equipment. The detailed plan, procedure and method statement along with pre-commissioning system / loop marked drawings shall be submitted by the LSTK Contractor to the OWNER/ PMC.

### 5. Preliminary Activities

LSTK CONTRACTOR shall provide the following, as detailed within blowing instructions

1. Oil free dry air.
2. Temporary pressure gauge up to 10 bar g.
3. Air hoses rated for maximum pressure as per compressor specification.
4. Safety latches for hoses handling.
5. Temporary spools, prefabricated as per requirements to fit permanent components.
6. Temporary gaskets.
7. Suitable quick connectors for hoses handling (e.g. Chicago coupling).
8. Quick opening valves for temporary use, as per attachments.



Prior to starting air blowing, several preliminary activities should be undertaken. These include the following:

- Identify pipe circuit and prepare it for cleaning, e.g. determine air inlets and outlets, install temporary bypasses, jump-overs, blind disks, etc.;
- Disconnect pump, turbine, compressor intake and discharge lines and cover casing nozzles to prevent entry of cleaning medium;
- Remove orifice plates;
- Remove any in-line service strainers;
- Remove or blank or bypass control valves and safety valves;
- Blank and protect instrument connections;
- Disconnect line inlet connections to exchangers and protect relevant nozzles to avoid entrance of foreign materials inside the equipment. Once has been verified that blowing is properly accomplished, reconnect lines and blow air through exchanger to next section of circuit. Take care that air velocity inside the exchanger does not exceed limits specified in equipment data sheet. Never blow air through a plate exchanger;

Note: Blowing through any equipment must be approved by OWNER / PMC.

When a pair of flanges must be opened to allow air flow to blow out, take care that the distance between the two flange faces is not less than 1/6 of pipe diameter;

- Block out spring supports, spring hangers, etc. according to manufacturer's instructions;

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- Verify if temporary supports are required during blowing operation to eliminate any possibility of damage and risk due to unrestrained forces;
- Protect equipment near blowing outlets to prevent damage to fragile devices such as pressure gauge glass, etc.;
- Assure that in the system to be blown no free water is present, to avoid the hammering problems during operation;
- When a vessel is used as air reservoir, remove vessel internals if possible, or Ensure they are not damaged during the operation;
- When a vessel is used as air reservoir, ensure that its relief valve is in normal operation before starting pressurization;
- Convene a meeting with Construction Contractor & CONTRACTOR to finalize all technical and safety aspects prior to starting of air blowing;
- Prepare a specific procedure, to be reviewed and approved by CONTRACTOR/ PMC/OWNER, detailing stepwise all the activities to be performed;
- Prepare the related Job Hazard Analysis for each specific activity.

## 6. Air Blowing Methods

Two methods of air blowing can be used:

### **Continuous Blowing**

Air is blown continuously through the selected pipe circuit from a source (air compressor or via pressurized vessel) to carry away foreign matter.

### **Quick Depressurization**



- The pipe circuit to be air cleaned is pressurized up to maximum allowable pressure.
- Air release is then obtained either by quick opening valve or by rupture disk.

In the first case, air flow rate can be adjusted and in case of emergency the valve closed; in the second case, no air flow control is possible. Quick depressurization causes high air velocity in the pipe circuit, carrying away the foreign matter. Card board -Rupture disks are used mainly to blow large diameter lines. Rupture disks are fabricated at plant site from a variety of materials (paper, plastic, aluminium sheet, etc.). Choice of material depends on disk diameter and pressure at which disk is required to burst. A series of rupture trials, starting with small thickness disks and gradually increasing their thickness, is required before achieving correct disk spec.

## 7. Air Blowing Operations

Once preliminary activities are completed and all safety measures taken, air blowing can start as follows:

- Air blows shall be performed by means of oil free air;
- Blow main header before their connecting lines;
- Avoid dead ends; if this is not possible, clean these separately;
- Check that pressure in the system never exceeds maximum allowable pressure;
- During air blowing clean all low points drains to remove any dirty trapped in;
- With pipes above 10" dia, perform first blowing at a pressure not above 3 bars;

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- If a rupture disk is used, continuously monitor pressure increasing; when rupture disks blows out, stop flow of inlet air to pipe circuit;
- After blowing, reassemble pipe, instrument, fragile devices, etc.; carefully monitor work during this operation;
- After blowing, considerable dirt may have accumulated in corners of valves or nozzles, etc. The only way to clean these areas is by hand, and this step should never be omitted.

## 8. Air Blowing Velocity

During blowing, air velocity should be maintained between 2 to 5 m/sec in order to generate the high force needed to remove all loose matter inside pipe circuit.

Where required, a more precise determination of the necessary air velocity can be performed by using the disturbance factor approach. The Disturbance Factor (R) is defined as:

$$R = Q_c \cdot V_c / Q_d \cdot V_d$$

Where:

$Q_c$  = air mass flow at cleaning conditions (kg/h)

$V_c$  = air specific volume at cleaning conditions (m<sup>3</sup>/kg)

$Q_d$  = normal fluid mass flow at most severe operating conditions (kg/h)

$V_d$  = normal fluid specific volume at most severe operating conditions (m<sup>3</sup>/kg)

Maintaining the Disturbance Factor above 1 will assure that any debris not removed during blowing operation will not be dislodged during normal operation of the line.

## 9. Cleanliness Criteria

For most process and utilities piping, air colour at outlet point is sufficient indication of whether blowing may be considered completed.

In special services (e.g. compressor intake line) a target plate (copper, aluminium, and stainless steel) should be installed at the air outlet point. Cleanliness acceptability is based on the number and size of marks left by entrained material on the plate.

Plate to be used shall be highly polished and installed on the pipe when the exhaust air appears clean.

Plate shall be fixed to a support which keeps it perpendicular to the pipe axis (see Fig. 1).

Plate dimensions shall be: a x b (0.2 x 0.8) diam. (see Fig. 1).

Plate shall be replaced after each air blowing, and then marked with number of flow, stored and used for comparison with other plates.

When the plate surface remains bright, it is possible to count the number of marks left by dirt or rust particles.

When number and size of marks does not increase during two consecutive blowing operations and are in conformity with equipment manufacturer recommendations it may be assumed that pipe circuit is clean.

The acceptability Criteria: marks exceeding 0.5 mm diameter to number not more than 2 per 25 cm<sup>2</sup> of target plate surface.



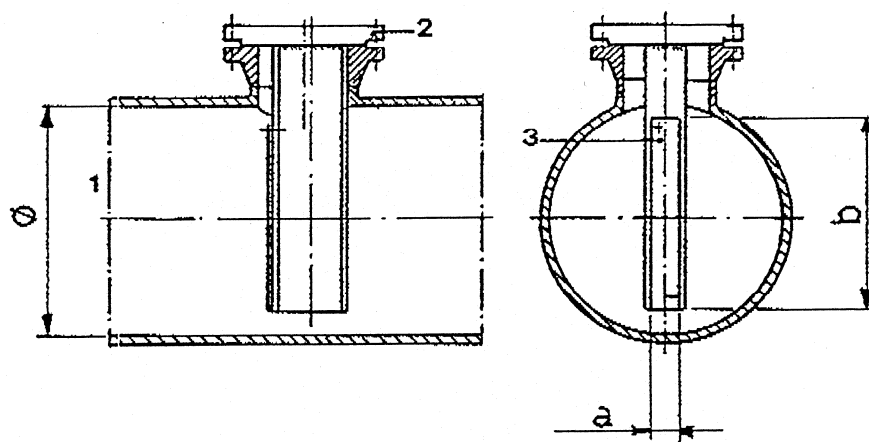


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FIG. 1

### TARGET PLATE INSTALLATION



1. Pipe to be cleaned
2. Plate support
3. Plate

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## 10. Quality Control Report

Test results shall be reported in the relevant Pre-commissioning Quality Control Form or attachment to it and it shall be integral part of the System Dossier.

## 11. HSE Precautions



Air blowing is an intrinsically hazardous operation. Therefore, special safety precautions must be taken to prevent injury to personnel by debris flying from exhaust opening and to prevent environmental pollution.

The hazards that may cause a personnel injury are both debris flying by exhaust opening and high noise caused by both air blow off and by the rupture disk, if it's present.

The following represents minimum precautions:

- Observe and enforce all local codes and regulations to safeguard plant, personnel and the environment;
- Place warning signs and fence the entire blowing area with colour strips barricading.
- Restrict access into air blowing area to authorized personnel only;
- Prevent any persons from entering the exhaust blow area, allowing ample distance in the direction of the blow and considering possible deflection of the blow;
- Vessels used to hold air under pressure must be protected by the installation of dedicated pressure safety valves. The air pressurization of the vessel will never be over its normal operating pressure;
- If the MAWP of the system to be air blown is below the MAWP of source of air, overpressure protection must be provided on the system to be air blown;
- Flexible hoses used for vessel air pressurizing shall be resistant to the air supply design pressure;
- System under blowing shall be properly isolated from connected systems on which other activities may be going on;
- Each valve isolating connecting lines or branches within the system under blowing will be verified to be in the closed position by visually inspecting the valve stem and with the checking of the presence of the blind;
- Instruct personnel in how to monitor air blowing operation and to stop blowing activity when required;
- Ensure that all lines which have been disconnected to allow blowing are strongly secured for personnel protection;
- Instruct involved personnel to monitor air blowing operation and to safely stop blowing activity (stop of the involved system pressurization and successively controlled depressurization of the same) when required;
- Ensure personnel involved in blowing operation wear appropriate personal protective equipment such as gloves, boots, helmets, ears protection (where necessary) and goggles;
- Because high noise is expected, the high noise sign must be displayed;
- Ears protection is mandatory in all noise affected areas and shall consist of two levels, ear plugs and air muffs;
- People working in the area affected by the noise, shall be previously informed to avoid panic coming from unexpected high blast sound (e.g. through a whistle);





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- Before pressurizing with air walk down through the system to check its proper alignment and integrity;
- During system pressurization check again for its integrity (no major leaks);
- The preventive measures identified as per typical JHA shall be followed.

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## 12. Attachment



### Attachment 1: Typical Job Hazard Analysis for Air Blowing of Piping and Equipment

COMPANY	AREA
JOB: AIR BLOWING	DATE OF ANALYSIS
NUMBER	TOTAL NUMBER OF JHA
BRIEF DESCRIPTION AND CONSIDERATION : AIR BLOWING	

STEP	HAZARD	PREVENTIVE MEASURE
Preparation / Secure Area	Slips Trips Falls Personnel Injuries	<ul style="list-style-type: none"> <li>– Instruct involved personnel what to do, how to monitor operation, how to safe stop the activity if needed</li> <li>– Housekeeping: keep work area clean</li> <li>– Remove all trip hazards</li> <li>– Inspect affected area to ensure it does not conflict with other activities.</li> <li>– Place warning signs</li> <li>– Barricade area with pre-commissioning tape [black/yellow]</li> <li>– Air releasing points must be barriered for adequate distance such as the release air pressure is at a safe level. Consider possible deflection of the blow.</li> <li>– Keep non-essential persons clear. Restrict access to authorized personnel only.</li> <li>– Appropriate PPE to be worn at all times (during all the steps of the job)</li> </ul>
Disconnect/ Reinstate Lines  Install Spade/Blinds  Open/Close Manway	Personnel Injury  Muscle Strains  Equipment Damage	<ul style="list-style-type: none"> <li>– Before opening pressurized line/vessel, ensure all pressure in line are safely bled off</li> <li>– Select correct tools for job</li> <li>– Mechanical lifting devices are to be used to prevent manual handling injuries</li> <li>– When manual handling is required, correct manual handling techniques is to be used</li> <li>– The use of two people or a team to lift heavy items should also be considered</li> <li>– Use proper scaffold or platform when working at height. A full body harness is to be worn at all times, with a lanyard attached securely to an anchor point.</li> <li>– Positive isolate system under blowing from connected systems by means of valve or blind</li> <li>– Apply lock out / tag out procedure to each isolating valve</li> </ul>

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STEP	HAZARD	PREVENTIVE MEASURE
Connection Of Temporary Air Hose/Line	Personnel Injury	<ul style="list-style-type: none"> <li>– All temporary line/hose must be rated for the working pressure (compressor shut off).</li> <li>– Temporary air hoses should be run in such a manner that they do not create a hazard for other workers</li> <li>– All valves isolated while making connection</li> <li>– All connections to be checked for tightness and security so air, with correct hose clamps and safety pins, cannot escape injuring personnel</li> </ul>
Compressor Blowing System	Personal Injury Equipment Malfunction	<ul style="list-style-type: none"> <li>– The air compressor used to flush the lines is to be in a safe condition, fit for purpose and fitted with all working safety devices.</li> <li>– All moving parts of the air compressor must be properly guarded. If electrical power is used, all electrical connection and cable must be in good condition</li> <li>– Compressor have to been given an inspection to ensure it meets safety requirements</li> <li>– Vessels used to hold air under pressure must be protected by the installation of dedicated pressure safety valves. The air pressurization of the vessel will never be over the normal operating pressure of the system</li> <li>– Safety Latch using has to be maximised to secure hoses to temporary or permanent connections as applies</li> </ul>

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STEP	HAZARD	PREVENTIVE MEASURE
Introducing Air To System For Blowing And Cleaning Of Lines	Personnel Injury	<ul style="list-style-type: none"> <li>– Ensure that blow off points are barricaded with yellow and black pre-commissioning tape so personnel are not near the escaping air or could be struck by debris.</li> <li>– Before air introducing each isolating valve connecting lines or branches within the system shall be verified to be in the closed position by visually inspecting the valve stem or with the checking of the presence of the blind.</li> <li>– Before pressurizing with air walk down through the system to check its proper alignment and integrity.</li> <li>– During first air introducing, to verify the tight close of each isolation valve, an open bleeder or existing opening downstream of the isolation valve shall be monitored until it has been assured as positive shut off</li> <li>– During system pressurization check again for its integrity.</li> <li>– Air to be introduced slowly to allow for close inspection for leaks</li> <li>– Blowing Activities to be supervised by precommissioning engineer</li> <li>– Care is to be taken that waste from blowing off points does not impact on other activities.</li> <li>– Care to be taken no foreign materials can be expelled injuring personnel.</li> <li>– If high noise is expected, the high noise sign, and hearing protection must be used</li> <li>– When needed, minimize disturbance to persons and to environment by using supporting devices for low noise blowing</li> <li>– Request permission for air blowing at night due to high noise levels</li> <li>– To avoid panic coming from unexpected high blast sound, previously inform people working in the area affected by noise</li> </ul>
Blowing Complete/ Clean Up And Re-Instatement	PERSONNEL INJURY	<ul style="list-style-type: none"> <li>– All temporary air supply to be removed to avoid someone turns on valve</li> <li>– Care is to be taken to ensure that the correct lock and tag are removed</li> <li>– All yellow and black barricade tape is to be removed at completion of the task</li> <li>– Job site to be restored to original</li> <li>– Clean up for next worker is safe from injury</li> <li>– The area is to be left clean and tidy with all rubbish and debris removed.</li> </ul>
Environmental aspects	Noise Waste	<ul style="list-style-type: none"> <li>– Programmed activities to minimise disturb</li> <li>– Clean the area after discharge, contain debris.</li> </ul>

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### Attachment 2: Pre-commissioning QCF

## PRECOMMISSIONING – QUALITY CONTROL REPORT

### PIPING / EQUIPMENT

### CLEANING



<b>MC PACKAGE:</b>		<b>UNIT:</b>		<b>SYSTEM:</b>				
<b>Cleaning method</b>	<b>W : WATER FLUSHING</b>		<b>S : STEAM BLOWING</b>		<b>M : MECHANICAL</b>			
	<b>A : AIR BLOWING</b>		<b>H : HYDROJETTING</b>		<b>CLEANING</b>			
	<b>O :</b>							
LINE No./ EQUIPMENT NO.	P&ID No.	CLEANING METHOD	REMARKS	DATE	WITNESSING			
					SUB CONTRACTOR	CONTRACTOR	OWNER	THIRD PARTY

**NOTE:**

QCR ACCEPTANCE				
INSPECTORS	SUBCONTRACTOR	CONTRACTOR	PMC	OWNER
NAME				
SIGNATURE				
DATE				

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### FLUSHING / BLOWING -BOX UP SUMMARY RECORD

QUALITY CONTROL FORM : PC-FLBX

DATE:

<p><b><u>FLUSHING - DRYING:</u></b> This is to certify that the following described system / sub system has been thoroughly cleaned by flushing / blowing / card board blasting &amp; properly dried.</p>			
SYSTEM NO :		SUB SYSTEM NO. :	
Medium :		FLUSHING LOOP NO. :	
LOOP No.:			
	Performed by:	Checked by:	
Name:			
Signature:			
Date:			
	CONTRACTOR	PMC	OWNER
<p><b><u>BOX UP:</u></b> Reinstatement checks for the above system / sub system is completed and the same is mechanically ready for leak test.</p>			
	Performed by:	Checked by:	
Name:			
Signature:			
Date:			
	CONTRACTOR	PMC	OWNER

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