Base Load Power Hub (BLPH)

PROCEDURE FOR MATERIALS HANDLING, WAREHOUSING, STORAGE AND PRESERVATION

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1 INTRODUCTION

1.1 PROJECT OVERVIEW

Crosswind, a Shell and Eneco joint venture, was awarded the tender to develop the offshore Hollandse Kust Noord (HKN) wind farm, located 18.5km off the coast of Netherlands near the town of Egmond aan Zee. The consortium plans to have HKN operational in 2023 with an installed capacity of 759MW generating at least 3.3TWh per year. This is sufficient renewable power to supply more than 1 million Dutch households with green electricity.

Offshore wind farms produce intermittent electricity and balancing these dips and peaks and integrating this electricity into the national energy system requires new technologies. For this reason, the offshore wind farm will include several new technologies that could be implemented at full-scale in the future. The new technologies being explored include a floating solar park, a short-duration battery storage as well as long-term storage via green hydrogen produced by water electrolysis and subsequently consumed in a fuel cell. The combination of these individual measures, herein referred to as the Base Load Power Hub (BLPH) will ensure a continuous power supply regardless of the wind situation.

1.1.1 Project Location

The Hollandse Kust Noord (HKN) wind farm is located 18.5km off the coast of the Netherlands near the town of Egmond aan Zee.

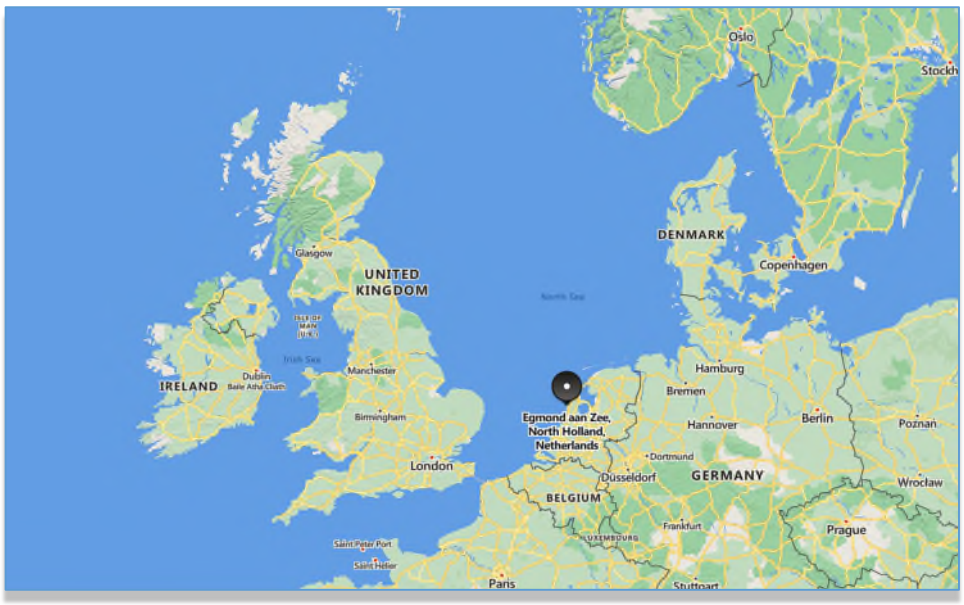


Figure 1 HOLLANDSE KUST NOORD WIND PARK Location Map

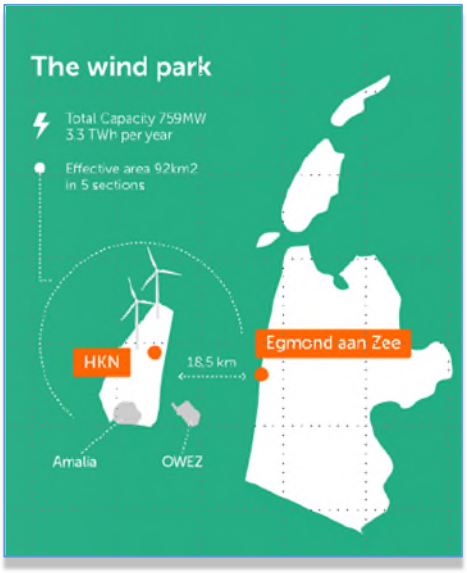


Figure 2 - Wind Park Details

The wind farm will consist of No. 69 x 11.5MW wind turbine generators each to be installed on a dedicated monopile structure. A 70th monopile located on coordinates E 590719.1, N 5841602.3 is reserved for installing the platform accommodating the BLPH. The monopile structure was designed and installed by Van Oord Offshore Wind (VooW) and therefore not part of the BLPH scope.

1.1.2 Project Concept

All components included in the BLPH will be integrated onshore on a topsides and installed in an offshore location within the boundaries of the HKN wind farm. At its simplest, the BLPH will store energy during periods of high electricity generation from renewable sources (a wind turbine generator and the floating solar PV farm) and release it during periods of low generation. In practice. It is expected that the energy stored will supplement generation from renewable sources to ensure that at least 1.0MW of power is exported to the electrical grid regardless of wind/solar availability.

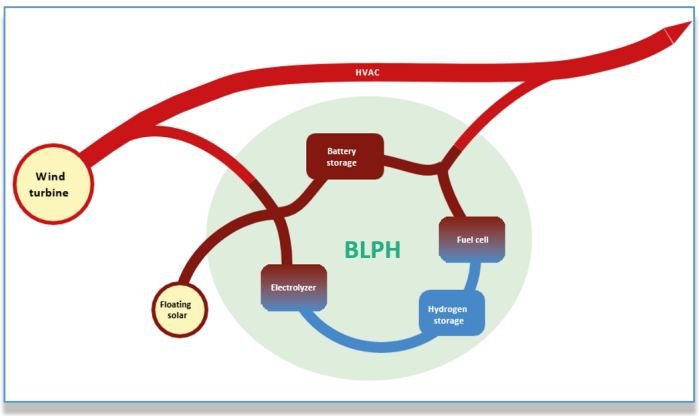


Figure 3 – BLPH Concept

Electricity in the BLPH will be stored in the form of electrons in a battery energy storage system (BESS) as well as converted into green hydrogen via water electrolysis. When the power output from the connecting wind turbine drops to below 1 MWe, the BLPH will return its stored energy to supplement the remaining power output. This will be by discharging the BESS, while stored hydrogen will be converted back into electricity using a fuel cell to extend the discharge duration.

The purpose of the BLPH s to function as a testbed for the integration of energy storage technologies with renewable generation. It is expected that equipment installed on the BLPH will operate as Normally Unmanned Installation for at least two (2) years with no or minimal maintenance and it will have its own independent control room with the ability to communicate with Crosswind's control room.

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2 DOCUMENT SCOPE

This procedure outlines the methodology that the CONTRACTOR will adhere to in managing, storing, and maintaining materials, instruments, and equipment throughout the lifecycle of the BLPH for the HOLLANDSE KUST NOORD WIND PARK Project.

This includes all stages from the procurement phase, through fabrication activities, up to and including the final assembly of the topsides.

The scope of this procedure encompasses:

1. Materials, instruments, and equipment procured by the CONTRACTOR.

2. Company Items, whether managed within the workshop or the yard.

2.1 REFERENCES

Doc. No.	Description
Contract No. CW-I-WP4-2023-05 and all relevant Sections.	
123A90-PML-QHSE-QP-00002	Project Quality Plan
123A90-PML-PM-PL-001	Project Execution Plan

Table 1 - Reference Documents

2.2 DEFINITIONS AND ABBREVIATIONS

COMPANY or Client (CPY):	Crosswind
CONTRACTOR (CTR):	ROSETTI MARINO S.p.A.
PROJECT:	HOLLANDSE KUST NOORD WIND PARK Project

Table 2 - Definitions and Abbreviations

3 RESPONSIBILITIES

Project Quality Manager:

- Ensures the procedure is correctly applied.

Material Coordinator and Logistic Department Personnel:

- Uphold the standards and requirements detailed in this work instruction.

Construction Supervisor:

- Adheres to the guidelines of this procedure.

- Oversees the proper organization and management of the Yard.

- Ensures materials are appropriately handled in both the workshop and yard.

- Minimizes potential damage during handling, fabrication, and erection.

4 ACTIVITIES DESCRIPTION

All activities related to material receiving are to be executed in line with RM Corporate O-PRO-4B-002 "Material Receiving Procedure".

4.1 MATERIAL RECEIVING

The Material Coordinator, together with the Logistic Department personnel, handles the receipt of all incoming materials, instruments, and equipment. They are tasked with storing these items based on their respective categorizations.

During the receiving process, the following checks will be conducted:

- Quantity: Ensuring the correct number of items.
- Integrity: Confirming the items are undamaged and intact.
- Identification: Verifying the items match the specified descriptions.
- Dimension: Measuring to ensure items fit the specified sizes.

All details from the receiving process are subsequently logged into the Corporate ERP system. This includes:

- Alignment with specific Purchase Order (PO) line items.
- Status updates on materials and certificates, specifying if they were accepted or not.
- Inclusion of unique identifiers, such as shortcodes, heat numbers, or tags.

4.2 QUARANTINE AREA

Items identified as non-conforming or damaged during the receiving inspection will be processed in accordance with RM's corporate procedure.

Specific actions include:

- Identification: Any non-conforming or damaged materials or equipment will be directed to designated quarantine areas.
- Area Marking: Quarantine areas, both inside and outside, will be clearly marked. This can be achieved using fencing or red/white tape for easy distinction.
- Labelling: Every item within a Quarantine Area will be labelled to facilitate quick reference regarding the material's status.

4.3 HANDLING OPERATION

Handling operations, whether conducted in the workshop or at the yard, employ various equipment like cranes, forklifts, trucks, or other systems, adhering to the guidelines below:

- Safety Compliance: All handling operations must align with established safety protocols to prevent accidents and ensure the well-being of personnel.

- Equipment Adequacy: Ensure the equipment used has sufficient capacity to handle the materials without strain or risk of malfunction.
- Efficient and Safe Lifting Gear: Utilize slings that are both safe and efficient, minimizing the risk of accidents during handling operations.

When dealing with specific types of materials, further precautions are necessary:

- Painted Materials: These should be handled with care, utilizing lifting lugs or soft slings that prevent damage to the coatings.
- Stainless Steel and Exotic Materials: These require careful handling to prevent cross-contamination or any form of damage. Only use equipment and attachments like soft slings, clamps, and hooks that are compatible with these materials.
- Cross-contamination Prevention: Strictly prohibit the use of carbon steel or other contaminating/incompatible materials in areas where stainless steel is being applied or welded.
- Storage Considerations for Stainless Steel: Designate storage areas specifically for stainless steel, ensuring no contact with carbon steel or other ferrous materials that could cause contamination. This includes prevention of exposure to ferrous dust.

4.4 STORAGE

To ensure the longevity and integrity of materials, instruments, and equipment, the following storage guidelines must be adhered to:

- General Requirements: All items should be stored in alignment with the Project specification and any specific instructions provided by the supplier.
- Classification-Based Storage: The storage method utilized must be adapted based on the classification level of the items in question. Regardless of the classification, all items must be stored securely, following best industry practices and manufacturer guidelines to prevent deterioration or contamination.
- Preservation Details: refer to section 5
- Segregated Storage: Items intended for different orders must be stored separately to avoid confusion and streamline the retrieval process.
- Dissimilar materials must be stored distinctly to prevent cross-contamination.
- Company Items: These should be stored and managed as per instructions supplied by the Company

4.4.1 Storage levels

To ensure proper protection, durability, and ease of access, materials are divided into two distinct storage levels based on their attributes and preservation requirements. Each level is tailored to the specific needs of the items it encompasses, aiming to minimize damage and maximize longevity. Detailed below are the classifications and requirements for each of these storage levels:

Level A

This level includes :

- E&I cable trays
- pipe fitting, flanges and hubs
- piping valves
- telecom equipment
- instrumentation equipment and accessories
- electrical equipment
- pumps
- HVAC equipment
- Extinguishers

Material, instruments, equipment, parts or components included in this level must be stored in well-ventilated and weather-proof premises.

Storage at yard of material, instruments and equipment may be carried out in containers or in prefabricated mobile air-conditioned warehouse provided that it meets COMPANY specifications or manufacture requirements.

Level B

This level includes:

- pipes
- plates
- tubular and section (structural)
- beams
- prefabricated structural components.
- vessels
- cranes

Material, equipment, parts or components included in Level B may be stored in open areas provided that they are protected from mechanical impact and from contamination (e.g. as required for stainless steel items).

Area identification labels will be arranged outside selected areas for easy reference of topsides material location.

Storage areas must be situated in order to prevent flooding and materials must be isolated from the floor so as to permit air circulation.

Where possible, pipes must be stored on wooden pallet and shall be stored using timber to avoid contact with unpainted metal to metal.

End caps will not be removed prior to fabrication. If removed by accident, end caps are to be reinstated.

Storage at yard or other areas for material, instruments and/or equipment included in Level A may be carried out in prefabricated warehouses or with plastic cover protection providing storage meets already defined requirements, Client's specifications or Manufacturer's data book.

Receiving and storage of painting materials shall be carried out according to a dedicated procedure issued for the project.

Receiving and storage of Passive Fire-Proofing materials shall be carried out according to a dedicated procedure issued for the project.

Welding consumables shall be stored in a controlled environment as per the manufacturer's instructions.

5 PRESERVATION

The requirements for preservation are to apply and maintain the preservation condition and operability of systems, equipment and piping spools, before taken into use.

5.1 PRESERVATION PHASES

5.1.1 Supplier Phase

During this phase, the Supplier must:

a) Identify and describe all preservation needs.

b) Conduct initial preservation.

c) Prepare procedures for storage and maintenance during construction, including methods for preservation removal. This must be part of the preservation dossier.

5.1.2 Construction Phase

Contractor is in charge of:

a) Understanding vendor-specific preservation procedures.

b) Inspecting equipment on arrival and noting any anomalies from initial preservation.

c) Assigning proper storage based on vendor specifications.

d) Organizing preservation tasks from equipment arrival to Module departure.

e) Attaching filled preservation labels to equipment.

f) Conducting preservation upkeep as per standards and added supplier directives.

g) Logging preservation tasks.

h) Generating preservation reports.

5.2 INITIAL PRESERVATION

Initial preservation should adhere to the specified storage conditions for the relevant duration. Suppliers must identify any unique preservation needs for specific equipment during storage and construction, and provide detailed procedures or requirements accordingly.

5.3 PRESERVATION MAINTENANCE

Maintenance requirements for preservation are outlined in the preservation checklists. These checklists cater to mechanical/piping, electrical, and instrument disciplines.

The mechanical checklist encompasses HVAC, piping, insulation, surface protection, structural, architectural, and safety equipment. Meanwhile, the instrument checklist extends to fire and gas equipment, telecommunications, and computer-related devices.

Preservation efforts for materials, equipment, and machinery will span from their arrival on-site through storage, installation, and commissioning. Extra attention is required for preservation post-commissioning. Preservation during this phase should either follow the practices adopted in earlier project phases or align with the manufacturer's instructions.

5.4 INTERVAL

Checklist intervals range between 1-24 weeks. Preservation plan intervals are set for each equipment type, adhering to vendor specifications. If preservation is compromised due to construction, commissioning, or any other factors, it must be restored or replaced.

5.5 INSPECTION OF EQUIPMENT UPON ARRIVAL

Upon delivery, the preservation condition of all equipment should be inspected. Any discrepancies must be addressed as per requirements.

For internally preserved, hermetically sealed equipment packages equipped with humidity detectors, only external inspections are needed during storage, unless specified by the supplier. Damaged protective coatings incurred during transit should be repaired or replaced. Surfaces in need of coatings, lubricants, or rust preventatives should be appropriately treated and shielded. Equipment containing fluids, or surfaces necessitating liquid-based protection like Glycol/water or acid-free oil with a corrosion inhibitor, must be distinctly marked. Comprehensive protection is essential for the internals of equipment, including instrumentation, electrical components, and telecommunications.

5.6 STORAGE

Contractor is responsible for maintaining the equipment's integrity during off-loading, handling, storage, and the construction phase, ensuring care and cleanliness suited to the equipment's nature and function. Only equipment prepped by the supplier can be stored outdoors.

Specialized or sensitive equipment, prone to degradation without proper storage and preservation (such as electrical, telecommunications, and instrumentation devices), must be kept in designated storerooms that are heated, well-ventilated, clean, and dry.

All storage conditions must meet the supplier's specifications.

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5.7 CONSTRUCTION / WEATHER PROTECTION

Throughout the fabrication, installation, and construction stages, a temporary non-flammable protective roof with side coverings should be established around equipment skids and special equipment. Adequate preservation measures should be implemented to shield critical equipment from potential hazards such as localized hot work, falling objects, and contamination during the integration phase.

5.8 SAIL-AWAY PRESERVATION

The structure will be securely fastened to the barge through welding, and the barge will be ballasted and adjusted for sea tow, facilitating transfer to the offshore location. All unattached items must be properly anchored. Openings in loose pipes/spools should be fully sealed using plastic caps or equivalents. Bare metal components of carbon steel should be shielded with grease or a similar substance to deter corrosion. The employment of spring hangers and temporary supports for piping systems and equipment will be assessed by Engineering to ensure protection during transit.

5.9 DISCIPLINE REQUIREMENTS

The following special instructions will be converted and managed with check lists. In the event that the vendor already defines checklists in its procedure, these must be used.

5.9.1 Special Instruction for Electrical and Electronic Equipment

a) All electrical and electronic equipment exposed to humidity shall be protected with desiccant or vapour corrosion inhibitor.

b) Special precaution to be taken on electrical heaters. To be specified in supplier's preservation instruction.

c) Executor is responsible to check that anti-condensation heaters on electrical equipment are activated as soon as safely connected electrically.

d) Shafts on electrical motor and mechanical seal shall be protected with grease tape, silicon-based lubricant and vulcanising tape or equal.

e) All non-terminated cable ends shall be sealed with heat shrink or shrinking shroud.

f) All spare cable entrances in panels and boxes shall be plugged.

g) All space/motor heaters on motors, generators, panels, etc. should be energized as soon as installation phase is completed.

h) Gaskets/O-rings on electrical and electronic equipment shall be greased with acid free Vaseline or equal.

5.9.2 Special Instruction for Instrument Equipment

a) Instrument equipment containing electronics shall be protected with desiccant or vapour corrosion inhibitor. All instrument panels, cabinets, boxes, etc. containing electronic components, relays, etc. shall be sealed with heavy duty tape after the installation of silica gel bags (1.8 kg silica gel per cubic meter of internal volume). If sealing by tape is not practical then heavy weight polyethylene sheeting, itself sealed, shall be used.

b) Individual instruments shall be preserved by either enclosing the instrument together with silica gel bags in a sealed heavy duty polyethylene bag or by inserting a silica gel bag within the instrument housing, reaffixing the housing cover and sealing the joint with heavy duty tape. Instruments with screwed dome covers (e.g. d/p cells), screw fixing covers (e.g. junction boxes) and hinged doors (e.g. local controllers) shall be preserved by the latter technique while instruments such as air supply regulators shall be preserved using the former (polyethylene bag). In lieu of silica gel bags for protecting electronic equipment in sealed enclosures, vapour-phase inhibitors may be used where applicable. Manufacturer's recommendations shall be followed.

c) Computers, video units and telecommunications equipment preservation shall be achieved by storing the equipment in a carefully controlled environment, e.g. vacuum packing. Manufacturer shall be consulted to establish appropriate systems for specialised equipment.

d) Batteries shall be stored on electrically nonconductive surfaces. Manufacturer shall be consulted on battery shelf life and proper storage conditions.

e) All openings in hydraulic/pneumatic tubing shall be provided with steel caps or solid shank steel plugs of metallurgy equal to the metallurgy of the component being capped or plugged. Non-metallic plugs shall not be used.

f) Gaskets/O-rings on instrument equipment shall be greased with glycerine gel or equal.

g) All non-terminated cable ends shall to be sealed with heat shrink or shrinking shroud.

h) All spare cable entrances in panels and boxes shall be plugged.

5.9.3 Special Instruction for Mechanical Equipment

a) Open flexible hose connections shall be plugged with blinds or caps.

b) When units are installed and pipes hooked up, all hook up flanges shall have 1mm galvanized dust blind with ample size red painted spade handle fitted.

c) Greased bearings shall be greased. Check supplier information.

d) Insulated units, where insulation is exposed to damage during storage installation shall be adequately protected.

e) All ends that have been bevelled for welding shall be provided with closure designed to prevent foreign material and damage to the bevel.

f) All threaded openings shall be provided with steel caps or solid-shank steel plugs of metallurgy equal to the metallurgy of the component being capped or plugged.

g) All valves shall be preserved in both open and closed position, valves supplied for stock to be preserved for long term storage, all exposed valves spindles shall be covered with grease tape (Denso), Teflon-based lubricant and vulcanising tape or equal.

h) Gate valves shall be stored and installed in closed position; globe and ball valves shall be placed in open position.

i) Special connections such as hubs, compact flanges etc. shall have protection that cover seal areas properly from mechanical damages.

j) Pipes with treaded ends to be supplied with thread protectors, of similar material, fitted.

k) Pumps and motor shafts shall be turned 1¼ turns weekly where possible. Activity is mandatory if required by Supplier

l) Ensure that all HVAC ducting is cleaned internally before installation. All open ends to be sealed post installation.

m) AHU and Extract units open ends should be sealed prior to arrival at site.

5.9.4 Special Instruction for Corrosion Resistant Alloy (CRA) Material

Definition : "Corrosion Resistant Alloy" – non ferrous material different from carbon steel.

At the current revision of this procedure, it includes :

- Stainless Steel (ie: AISI 316)
- UNS S31803 Duplex
- UNS S32750 Superduplex
- UNS S32760 Superduplex
- HIP Superduplex UNS S32505
- INCONEL 625
- Cupro-Nickel
- Titanium B-265 Grade 2
- Titanium B-861 Grade 2

a) All components shall be stored in dedicated area for CRA handling only, under cover or shall be suitably protected if in the open.

b) Welding consumables storage : The minimum requirements for the care, storage and handling of consumables shall be those of the selected consumable manufacturer. Care shall be taken to void contamination by moisture pick-up, oxidation, dirt, grease, oil or any other debris. Electrodes and filler wires, which show evidence of damage or deterioration and shielding gases, which show signs of contamination, shall not be used. Different grades of consumables & different project consumables shall be stored by type and identified by labelling system on the storage shelves.

c) The storage areas selected for exotic materials must be arranged to avoid damage and contamination.

d) Avoid any contacts with carbon steel or any other ferrous metal materials and ferrous dust that might contaminate it. Wood or plastic shall be used to prevent contact.

e) Wooden supports adopted for storage shall be free from nails and/or any other carbon steel and ferrous material. Carbon steel metal supports eventually used shall be painted (by primer

application) to avoid contamination. Furthermore, a proper shimming (by rubber, plywood or stainless steel plates) shall be adopted, locally, where CRA material will be in touch with the primed carbon steel support.

f) All materials shall be kept in storage until the working areas and equipment are ready to receive them.

g) CRA Materials shall be properly divided and stored by item/grades wherever possible.

h) All exotic material items arriving at site shall be stored/moved/inspected with the minimum disturbance to protective packaging, which should not be removed until necessary.

i) Avoid any action that could damage permanently the pipe (i.e: walking-over low wall thickness piping/ heaping and piling-up without any supporting system). Particular attention shall be paid for high ductility material which can be easily deformed, such as Cu.Ni. .

j) As far as possible, the prefabrication / coupling and welding operations of CRA piping, shall be carried out inside a segregated area, called White Area, dedicated exclusively to that specific purpose and identified as such. Any carbon steel or ferrous material contact areas shall be masked or painted.

k) White Area shall be cleaned of any contaminant and its suitability verified prior to start prefabrication. In case it is necessary to work the CRA material outside the dedicated White Area, this activity shall be carried out in the same way as recommended per the erection stage.

l) Shop dirt, marking crayons and ink, and materials having an oil or grease base should be removed from the CRA material surface by vapour degreasing or swabbing with suitable solvents. Paint and other materials not soluble in degreasing solvents may be removed using alkaline cleaners or special proprietary compounds. Alkaline cleaners containing sodium sesqui silicate, or sodium carbonate, shall not be used. Residues shall be removed by wire brushing and scrubbing with water. All solvents, inks, markers, etc. shall be chloride free.

m) Where surface contamination by iron is suspected a ferroxyl, test shall be performed. When iron contamination is present, or the surface oxidised or not supplied pickled, surfaces to be welded shall be cleaned with either iron-free abrasives or pickled with a solution of hydrofluoric acid/nitric acid solution followed by rinsing in potable water and then acetone and left to dry.

5.9.5 Special Instruction for Company provided equipment.

For the company provided equipment (Bess, Electrolyser, fuel cell, vessels), instructions as provided by the suppliers must be adhered to.

The Company (CPY) shall provide these instructions 3 weeks in advance of the anticipated delivery date to the site to allow the Contractor to familiarize with such instructions for the purposes of:

- Organizing the reception activities (handling and integrity verification),
- Preparing the appropriate storage area,
- Anticipating any preservation requirements during storage.

Subsequently, these instructions will guide the handling for installation and the subsequent preservation.

Based on the receipt date of such equipment at the yard, which will be communicated by CPY, a representative from CPY will be invited to attend the handling activities and to verify the integrity of the equipment. Any shortages or damages should be recorded and presented to the CPY representative. Resolutions to identified issues should be agreed upon. In the event that the client's representative is not present, they must be immediately informed of the issues encountered, and a report, accompanied by appropriate photographs, must be forwarded within 24 hours of arrival at the yard.

5.10 REMOVAL OF PRESERVATION

Preservation shall be maintained through construction and commissioning. Should it be necessary to remove any preservative to allow the testing or inspection of an item, Executor shall reapply preservatives upon completion, according to Supplier requirements.

Provision shall be made for the proper disposal of oils, greases, solvents, protective coverings, etc. to prevent pollution and other hazards, and shall fully comply with the Company's environmental requirements.

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