



# 25% HYDRAULIC TENSIONING COVERAGE PROCEDURE

V:2023.1

# 25% Hydraulic Tensioning Coverage Procedure

January 2023

**1.0 Purpose**

- 1.1 To safely tension a flanged connection utilizing 25% hydraulic tensioner coverage.

**2.0 The requirements contained within this procedure are applicable to IPS★ITCS and affiliates**

- 2.1 Pre-Job Review
- 2.2 Review job requirements and perform a job walk down with the customer.
- 2.3 Verify with the Customer Contact, conditions are as stated on the Pre-Job Assessment form.
- 2.4 Air requirements
  - 2.4.1 100 cfm and 100 psi air connection
  - 2.4.2 How much air hose will be needed to reach the job site
  - 2.4.3 If the air supply is not within a reasonable distance from the job site, an air compressor may be required so that an adequate amount of air is available to power pneumatic tools
- 2.5 Permits
  - 2.5.1 What types of permit(s) will be required
  - 2.5.2 Who approves, signs, and receives the permit(s)
- 2.6 Decontamination of equipment, if applicable.
  - 2.6.1 Does the customer have a means of decontaminating equipment and tools that may come in contact with chemicals or radioactive material?
  - 2.6.2 If hazardous waste is generated, does the plant have areas for disposal:

**3.0 Procedure**

- 3.1 Verify with the Customer Contact, conditions are as stated on the Pre-Job Assessment.
- 3.2 Complete and review Job Safety Environmental Analysis (JSEA) with all participating employees.
  - 3.2.1 A plant JSEA is acceptable in lieu of the IPS★ITCS JSEA as long as all Safety points are covered.
- 3.3 Determine required tension pump pressure by one of the following methods: Use Manufactures tension data charts. Use a Tension Calculation Worksheet.
- 3.4 Complete an Elongation Calculation Worksheet, (if ultrasonic measurements will be taken) and Follow the Ultrasonic Bolt Measurement procedure before proceeding with torquing operations.
- 3.5 Visually check that the flange has been correctly assembled and the correct is in place
- 3.6 Visually check that the studs have been lubricated correctly.
- 3.7 Secure the bolted joint by tightening all nuts snugly using standard hand wrenches
  - 3.7.1 Be sure that the bolts and nuts have been assembled correctly with extra length of stud (equivalent of one nominal diameter as minimum) protruding through one nut for tensioner attachment.

- 3.8 Determine the number of tensioner heads being utilized.
  - 3.8.1 There should be enough tensioner heads to cover 25% of the fasteners.
- 3.9 Using an approved marking tool (paint marker, crayon, etc.) begin to letter stud locations on the flange according to the letter of sequence for 25% coverage passes.
  - 3.9.1 Begin the lettering sequence with letter the (A) followed by (B), (C) and (D) in a clockwise direction then (A) then (B), (C) and (D) and continue in a clockwise direction until all fasteners have been lettered.
- 3.10 Install hydraulic tensioner heads at equally spaced intervals around the bolt circle beginning with fasteners lettered (A).
  - 3.10.1 When mounting the hydraulic tensioner head on the stud extension, it is important that the hydraulic piston is fully collapsed into the tensioner body.
  - 3.10.2 Tensioners shall not be mounted on to studs with a washer on the same side of the stud as the tensioner.
- 3.11 Assemble interconnecting hose harness and connect to pump.
- 3.12 Begin this tensioning sequence by pressurizing the tensioning system to the (B) pressure (as predetermined in the Technical Tensioning Calculation Worksheet for the joint.)
  - 3.12.1 Note: Use only the (B) pressure from Technical Tensioning Calculation Worksheet will be used for this joint. (A) Pressure is not applicable in this procedure.
- 3.13 While holding the predetermined pressure constant, use a tommy bar to screw down the nut to the face of the flange.
- 3.14 Slowly release the oil pressure until the gauge reads zero.
- 3.15 At this point, the tensioner pistons will be partially extended and must be pressed back into the tensioner bodies prior to re-pressurizing the tensioners to the tensioners to the targeted (B) pressure.
  - 3.15.1 Continue to repeat 3.12 thru 3.15 until there is no further movement of the nuts.
- 3.16 Re-position the tensioner heads at equally spaced intervals around the bolt circle beginning with fasteners lettered (C).
- 3.17 Continue to repeat 3.12 thru 3.16 until there is no further movement of the nuts
- 3.18 Re-position the tensioner heads at equally spaced intervals around the bolt circle beginning with fasteners lettered (B).
- 3.19 Continue to repeat 3.12 thru 3.16 until there is no further movement of the nuts
- 3.20 Re-position the tensioner heads at equally spaced intervals around the bolt circle beginning with fasteners lettered (D).
- 3.21 Continue to repeat 3.12 thru 3.16 until there is no further movement of the nuts
- 3.22 Re-position the tensioner heads on the first (A) sequence and repeat steps 3.12 thru 3.16 until no further nut rotation is possible in both (A) and (C) Studs.

- 3.23 Record all information on Flange Make-Up Data Sheet Form TBS 7000.6
- 3.24 Ensure work area is left in a clean and safe condition and all permits and LO/TO has been signed off.

# Revision History

Rev	Rev Date	Rev By	Approved By	Description
1.0	1/3/2022	Erik DeLaRosa	Shayne Torrans	Initial Procedure
1.1	11.23.2022	Erik DeLaRosa	Shayne Torrans	Format Revision

**Approvals:**

Procedure Owner

\_\_\_\_\_

Print Name

\_\_\_\_\_

Date

\_\_\_\_\_

Signature

# Competency Assessment

No.	Questionnaire	C/NYC
Q1		
A1		
Q2		
A2		
Q3		
A3		
Q4		
A4		
Q5		
A5		

Enclosed Attachments	
Risk Assessment	<input checked="" type="checkbox"/>
Environmental Aspect and Impact	<input checked="" type="checkbox"/>
Training and Competency	<input checked="" type="checkbox"/>
Measure and Evaluation Tools	<input checked="" type="checkbox"/>



# Competency Checklist

To be filled out by Trainer and signed by Employee, Assessor and Supervisor before being returned to the HSEQT Manager for recording purposes.

Procedure	Competency	Date	Competent YES / NO	Employee Signature

(Please tick appropriate box)

This employee is competent in performing the job.

This employee has not attained the competency level.


\*

\* *If the employee has not attained all competency levels, the General Manager must assess the action to be taken, provide an extension of training or alternative action as listed below.*

Alternate action to be taken: \_\_\_\_\_

Signed By	Employee:	_____	Date:	_____
	Trainer:	_____	Date:	_____
	Assessor:	_____	Date:	_____
	Regional Manager:	_____	Date:	_____



# Environmental Aspects and Impacts

## Identified Environmental Aspects and Impacts

The following table is a summary of the likely environmental aspects and impacts that may be identified during site inspections. The significance of each impact needs to be assessed using the Risk Assessment Model.

Activity	Aspect	Impact
<b>Purchasing &amp; Administrative Work</b>	Consumption of goods	Conservation of natural resources
	Consumption of energy (eg. Electrical equipment and facilities)	Release of greenhouse gases and atmospheric pollution; Consumption of natural resources; Habitat loss
	Generation of waste (eg. Paper)	Consumption of space for waste disposal; Habitat loss
<b>Climate Control</b>	Consumption of energy	Release of greenhouse gases and atmospheric pollution; Consumption of natural resources; Habitat loss
	Generation of noise	Disturbance to community; Habitat loss
<b>Cleaning of – offices / vehicles</b>	Storage, use and release of chemicals	Contamination of air, water or soil; Risk to human health
<b>Transport (Fleet vehicles / staff travel)</b>	Consumption of energy	Release of greenhouse gases and atmospheric pollution; Consumption of natural resources; Loss of habitat at all stages of generation; Light pollution
	Consumption of goods (eg. Oil)	Consumption of natural resources; Generation of waste; Habitat loss; Biodiversity impacts
	Generation of waste (eg. Oil)	Consumption of space for waste disposal; Potential contamination of water or soil; Habitat loss
	Exhaust emission	Release of greenhouse gases and atmospheric pollution
	Use of dangerous goods (eg. Batteries)	Potential contamination of air, water or soil; Risk to human health
	Generation of noise	Disturbance to community; Habitat degradation
<b>Operations</b>		

# Risk Assessment

Risk Assessment // insert name here

Step No: Logical sequence	Sequence of Basic Job Steps documented in the Procedure, Work Instruction and project plans. Break down Job into steps.  Each step should be logical and accomplish a major task.	Potential Safety & Environmental Hazards/Impacts at the site of the Job  Identify the actual and potential health and safety hazards and the environmental impacts associated with each step of the job.	Risk Rating  Refer to the risk matrix or HSEQT.PRO. Risk Mgt	Recommended Corrective Action or Procedure  <i>Determine the corrective actions necessary to reduce the risk to as low as reasonably practical (ALARP) refer to HSEQ.PRO.Risk Mgt. The risk must be reduced or controlled to ALARP before work commences.</i>  Document who is responsible for implementing the controls to manage each hazard identified.	Risk Rating refer to the risk matrix or HSEQT.PRO.Risk Mgt
1.					
2.					
3.					
4.					
5.					

# Audit

<b>Process:</b> insert// <b>Procedure:</b> Insert //			Date:	Audited by:
			Location of Audit:	Area Mgr/Supervisor:
Item	Question	Evidence Sited	Comments	Conformance Score 0,3,5
1.				
2.				
3.				
4.				
5.				
6.				
7.				
AUDITOR'S SIGNATURE:  SAFETY REP'S SIGNATURE:		CONFORMANCE SCORE:     / 25  CONFORMANCE %:		0 – Non-Conformance 3 – Continuous Improvement Opportunity 5 – Total Conformance