

STAINLESS STEEL WORKSHOP

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STAINLESS STEEL WORKSHOP

1 Identification Data

SC Confind SRL Campina is one of the leading suppliers of machinery, equipment and services in the oil and natural gas industry with over 20 years experience in developing complex equipment.

2 Workshop Scope

The stainless steel workshop was recently set up inside Confind, in order to provide the conditions necessary for the execution of stainless steel equipment for various industries. After signing the partnership with the French company Cofely Endel (GDF Suez), at the beginning of 2014, the manufacturing sector has been dedicated to manufacturing equipment required by French customers, used in food, pharmaceutical or nuclear areas. Thus, Confind specialists experience in producing various equipment for the oil and gas industry could be transferred and used in the above mentioned fields that require more restrictive conditions regarding hygiene, handling equipment and their protection against contamination. In the workshop with an area of 500 sqm, Confind has the capacity to produce atmospheric vessels, pressure vessels, isometric, stainless steel components etc.

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3 Equipment

The workshop is equipped with equipment dedicated exclusively to this sector of production activity. The main devices and equipment are:

4 roll hydraulic plate bending machine model MG MH208 for stainless steel plates, having capacity to roll stainless steel plates thickness 10 mm, width of plate of 2000 mm, provided with movable support system that permits rolling of shells with diameters of 2900 mm roller tables to position and handle the steel plates.

Welding bench type Exter 12 V 10, for longitudinal mechanized welding of stainless steel or carbon steel shells by TIG process:

- Welding maximum length: 1250 mm;
- Welding of diameters of min. 210 mm, max. 1900 mm.
- Thickness of weldable materials: 0,5 – 8 mm.

Megacycle M control box, for management of the automatic longitudinal displacement.

Welding column perpendicular on the shell, for welding head positioning order to perform circular welds in automatic mode;

Oscilarc III – magnetic oscillator of the welding arc

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3 | Equipment

Inventor type welding power SF – FRO Prestotig 310, water cooling, multiprocessing: TIG and MMA, welding in current and pulsating, complete welding cycle, to equip the two automatic welding systems.

TIG torches type MEC4 QC2M, to equip the two automatic welding systems

Automatic feed roller conveyor ROTAMATIC ST2W-2F, for rotating cylindrical parts with diameters from 300 to 2500 mm, speed 12-120 cm/min.

Equipment for manual welding TIG:

- PRESTOTIG II 310G/COOLERTIG II DC: 3 pcs.;
- Jackle: 1 pc.
- SAFMIG 400 BLX

Vacuum handling device FREZER

High capacity insults exhausters.

Bridge crane with motor driven by converter.

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3 | Equipment

To solve chemical treatments required by the stainless steel equipment, a pickling / passivation line by immersion the parts has been arranged, provided with 5 tubs that allow processing of parts with large dimensions: 1800 mm length and 1200 mm diameter.

4 | Works Performed / Ongoing works

In the stainless steel workshop of Confind, the stainless steel parts (plates, caps, flanges, manholes etc) are welded by TIG process. In this process, the arc burns between a wolfram electrode and the part to be welded (hence the name Tungsten Inert Gas). This electrode does not have a role of filler material; as such, it wears very slow compared to a coated electrode. TIG process is carried out by melting the two components to be welded. Optionally, in some cases, it is necessary to use a filler material in order to achieve a joint geometry and better mechanical characteristics. TIG process advantage is that it can be used in most weldable materials (carbon and alloy steels, aluminum, copper, nickel and alloys between them).

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4 | Works Performed / Ongoing works

So far there have been achieved more orders requested by Cofely Endel for the French market:

70 pressure vessels for brewery equipment. For these vessels, the technical requirements were added specific aesthetic demands, as the facilities wherfrom these vessels are part will be shown to the public.

1 pressure vessel used for sterilization of spices, a very complex work, with triple mantle. It is about a vessel that has a monitored facility for mixing spices, which are sterilized by heating at a temperature of 150 °C and a pressure of 3 bars.

There is in execution at present a 6 cm vessel used in the nuclear industry. Other projects are in the contracting phase.

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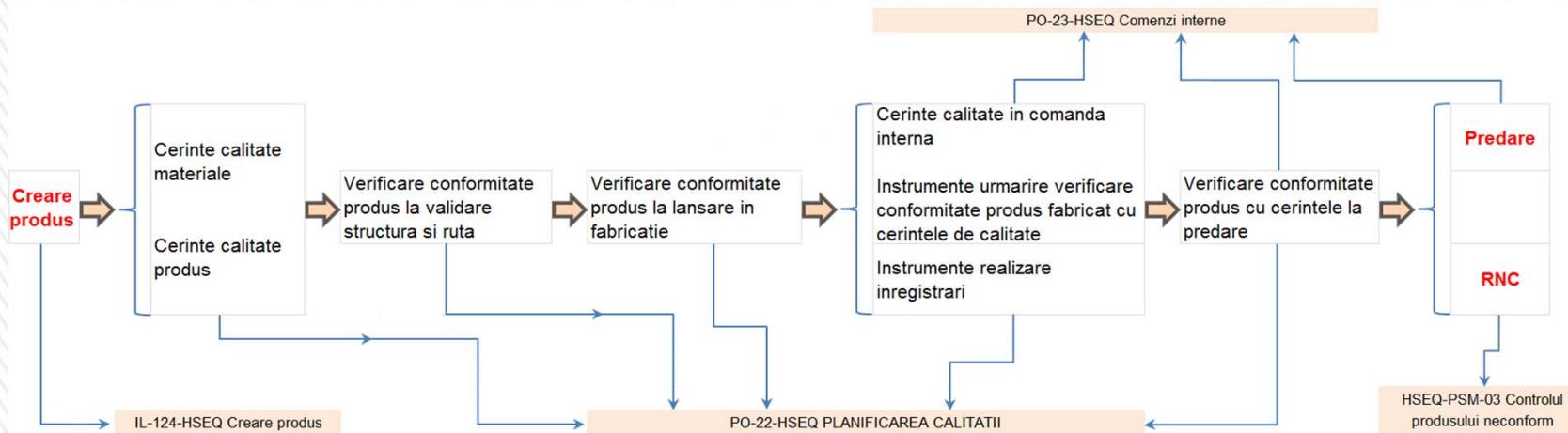
5 | HSE Management System (Health, Safety, Environment)

The Stainless Steel Workshop activities are based on a system that provides ongoing proactive management of production processes in the sector in a sustainable manner, in conditions of maximum safety for workers, community and environment. HSE sustainability aims to planning, implementation, verification and execution of all works by evaluating in detail the potential impacts and social risks since the earliest orders stages until final products achievement. Specifically, in case of the Stainless Steel Workshop, HSE sustainability means to involve Confind management in the production processes of this sector so as to avoid any risk, to minimize costs, protect the surrounding environment and work environment, reduce waste and to find alternative sources of electricity generation. involvement of senior management of the company must be found in improving communication and dialogue with all employees of the manufacturing sector in the economic development of the Stainless Steel Workshop while improving quality of life for all its workers. The Company's management is aware that one of the most valuable business resources of Confind is the company's staff, namely the Stainless Steel Workshop workers. Therefore, attracting professional elites is a key objective of the company, which entailed selecting and hiring best specialists in welding and rolling of plates and other stainless steel parts and assemblies.

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6 | QA/QC Management System

Due to the use of an Integrated Management System, supported by the certifications EN ISO 14001 and 9001, OHSAS 18001 and SA 8000, based on the requirements and records available/operated in the Enterprise Information System (SIE) used in Confind, traceability and transparency ensure complete manufactured products and their documentation, ensuring quality and production of the finished product perfectly verifiable.



Defining quality requirements for products manufactured and verifying their compliance during the execution of the product and its delivery time are guaranteed by the regulations imposed in Enterprise Information System (SIE) through IL-124-HSEQ Create the product and PO-23-HSEQ-PUTTING INTO PRODUCTION, PLANNING, TRACKING AND DELIVERY OF ORDERS, PO-22-HSEQ QUALITY PLANNING and HSEQ-PSM-03 Control of Nonconforming Product in the above-mentioned flowchart.

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6 | QA/QC Management System

Quality assurance is a priority for our company, the quality of our products and services making a difference from the competition. For areas where this workshop is meant to work, tracking quality in terms of compliance with technical specifications, but also the visual quality of the products is done primarily by using staff who proved to be more sensitive to these strict criteria, in addition to a proper professional training. The Inspection and Testing Plans used to manufacturing of each product contain steps very carefully checked by our clients. The specifics of working with COFELY ENDEL GDF SUEZ and manufacturing of equipment delivered to the French market also imposed adapting our company to the French manufacturing standards and norms, as CODAP 2010 - for pressure vessels, or RCC-M - for the nuclear industry, beside the current accreditations (ASME, IIW). To fulfill customer requirements for product testing, CONFIND uses all the own NDE laboratory resources, using any technique required by the client: RX, PT, MT, UT both testing and inspection during the manufacturing process, as well as final inspection and testing.

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7 | Photographic Documentation



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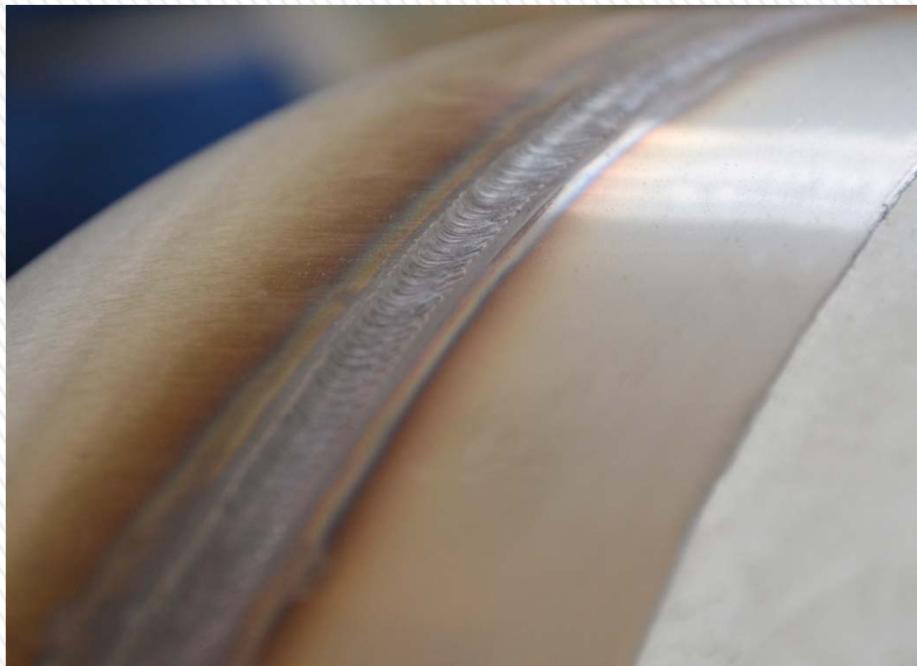
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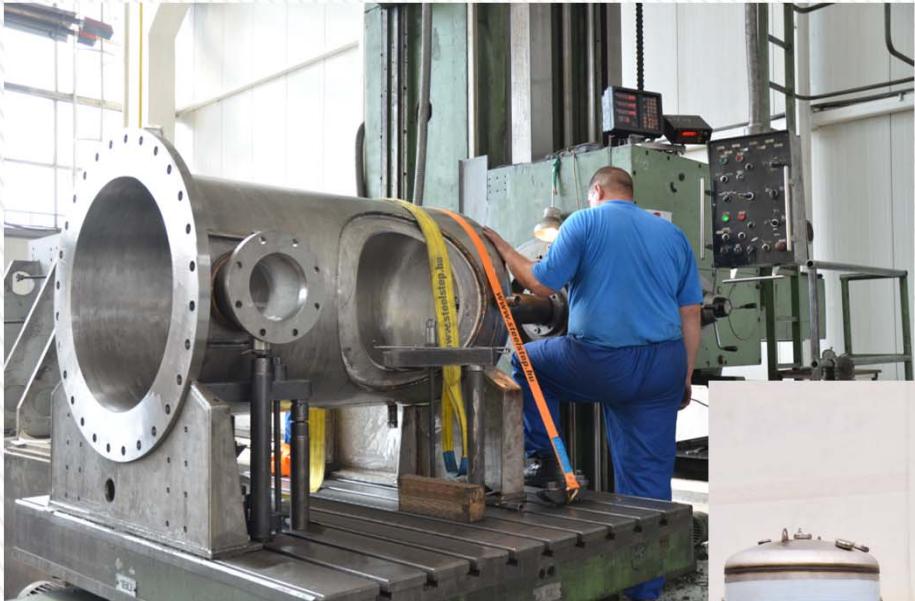
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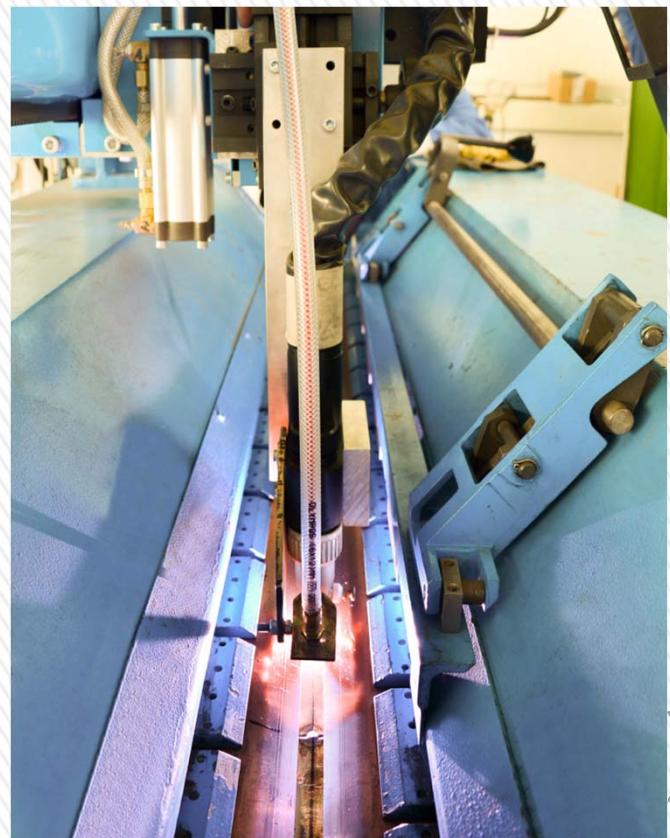
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