

TYPE 10 REPAIR

VIRONMENTAL	
EMERGENCY REPAIRS FOR RED HILL TANKS	
D REPAIR DRAWINGS	
File:7r046	
Quadrant: B	
Plate: 10	
Date: 5/4/98	

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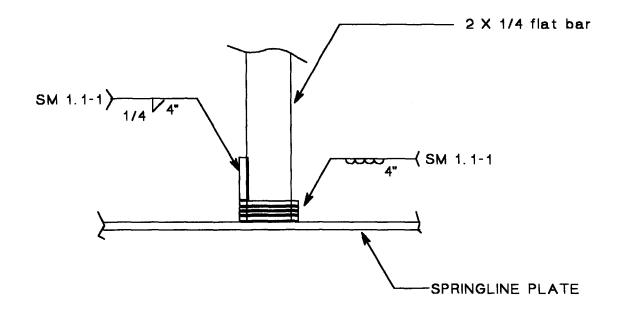
Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

Repair Record

Tank No.:	Repair No.: 046 Type: 10 Location: B10 - A
	Pinhole indication in fillet weld - Grind out defect, weld repair, and perform P.T.
5	2"

Sketch of Repair Area

Weld Repair			
WPS No.: 5M 1.1-1	_		
Welder ID: John M	<i>lals</i> h		
NDT Performed:	Visual	Vacuum Box	Dye Penetrant
Rework Required: D/A	**************************************		
Repair Acceptable:			Date Accepted: 4-15-98
Coating Repair			
Coating Type: EPOX	<u>Y</u>		
Surface Preparation:	Primer Coat:	Intermediate Coat:	Final Coat:
NDT Performed:	Visual:	DFT:	Average DFT: 8-15 mily
Rework Required: N/A			
Repair Acceptable:	Zohell		Date Accepted: 4-17-98



TYPE 10 REPAIR

MID ATLANTIC ENVIRONMENTAL		
EMERGENCY REPAIRS FOR RED HILL TANKS		
Tank #7 RECOMMENDED REPAIR DRAWINGS		
Repair No. • 047	File:7r047	
Upper Dome	Quadrant: B	
Course A	Plate: 11	
Drawn by: Tom Kitchen	Date: 5/4/98	

Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

Repair Record

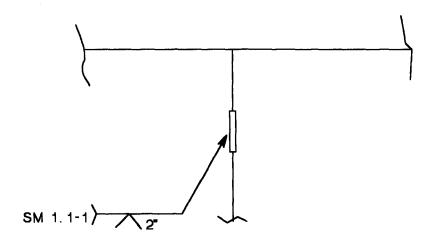
Tank No.: 7 Repair No.: 047 Type: 10 Location; BII-A
Pinhole indication in fillet weld-Grind out defect, weld repair, and perform P.T.
Sketch of Repair Area
Weld Repair
WPS No.: SM 1.1 - 1
Welder ID: John Walsh
NDT Performed: Visual Vacuum Box Dye Penetrant
Rework Required: 1/A Repair Acceptable: Date Accepted: 4-15-98

Coating Repair

Coating Type:	POK	<u>′ </u>				
Surface Preparation:	<u> </u>	Primer Coat:	<u>/</u>	Intermediate Coat: _	Final Coat:	<u> </u>

NDT Performed: Visual: Visual: DFT: Average DFT: 8-15 m/s

Repair Acceptable: Date Accepted: 4-17-79

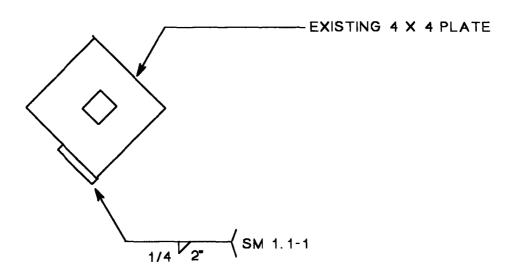


TYPE 9 REPAIR

MID ATLANTIC EN	/IRONMENTAL
EMERGENCY REPAIRS F	OR RED HILL TANKS
Tank #7 RECOMMENDE	D REPAIR DRAWING
Repair No.: 048 File:7R048	
CYLINDER	Quadrant: B
Course: 18	Plate: 11
Drawn by: Tom Kitchen	Date: 5/4/98

Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

Tank No.: 7 Repair No.: 048 Type: 9 Location; BII -8
Pinhole indication in fillet weld - Grind out defect, weld repair, and perform P.T.
K Z Z Z Z Z Z Z Z Z Z Z Z Z Z Z Z Z Z Z
Charles & Description
Sketch of Repair Area
Weld Repair
WPS No.: SM 1 - 1
Welder ID: John Wash
NDT Performed: Visual Vacuum Box Dye Penetrant
Rework Required: ν/μ
Repair Acceptable: Quinting Date Accepted: 4-15-98
Coating Repair
Coating Type: EPOXY
Surface Preparation: Primer Coat: Final Coat: Final Coat:
NDT Performed: Visual:
Rework Required: NA
Repair Acceptable: Date Accepted: 4-17-9 &



TYPE 10 REPAIR

MID ATLANTIC ENVIRONMENTAL		
EMERGENCY REPAIRS FOR RED HILL TANKS		
Tank #7 REPAIR DRAW!	NG	
Repair No. : 049	File:7R049	
CYLINDER	Quadrant: B	
Course: 15	Plate: 9	
Drawn by: Tom Kitchen	Date: 5/4/98	

Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

Repair Record

Tank No.: 7 Repair No.: 049 Type: 10 Location: 39-15
Pinhole indication in fillet weld - Grind out defect, weld repair, and perform P.T.
5
2" × PT
Sketch of Repair Area
Weld Repair
WPS No.: SM 1 - 1
Welder ID: John Walsh
NDT Performed: Visual Vacuum Box Dye Penetrant
Rework Required: P/A
Repair Acceptable: Plan Zaulell Date Accepted: 4-15-98
Coating Repair

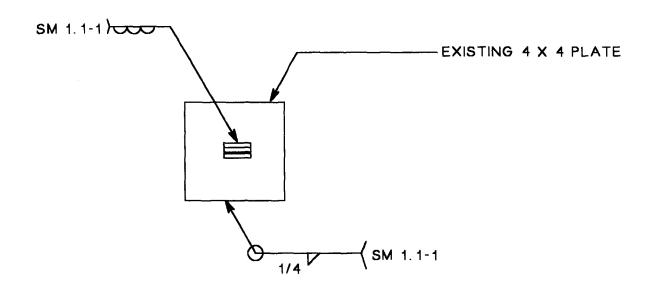
Coating Type: EFOXY

Surface Preparation: _____ Primer Coat: _____ Intermediate Coat: _____ Final Coat: _____

NDT Performed: Visual: Visual: DFT: Average DFT: 8-15 m/s

Rework Required: ν/μ

Repair Acceptable: Date Accepted: 4-17-98



TYPE 10 REPAIR

/IRONMENTAL	
EMERGENCY REPAIRS FOR RED HILL TANKS	
NG	
File:7R050	
Quadrant: B	
Plate: 11	
Date: 5/4/98	

Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

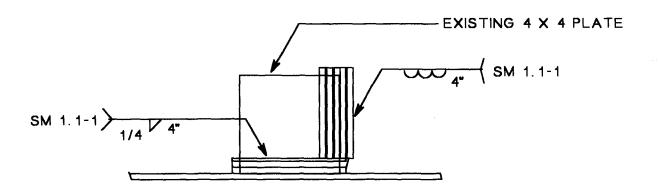
Repair Record

Tank No.: 7 Repair No.: 050 Type: 10 Location: B11-28
Pinhole indication in fillet weld - Grind out defect, weld repair, and perform P.T.
Sketch of Repair Area
Weld Repair
WPS No.: SM 1.1-1
Welder ID: John Walsh
NDT Performed: Visual Vacuum Box Dye Penetrant
Rework Required: ν/A
Repair Acceptable: Date Accepted: 4-15-98
Coating Repair
Coating Type: EPOXY
Surface Preparation: Primer Coat: Intermediate Coat: Final Coat:
NDT Performed: Visual: DFT: Average DFT: 8-15 m/s

Date Accepted: 4-17-98

Rework Required:

Repair Acceptable:



TYPE 10 REPAIR

MID ATLANTIC ENVIRONMENTAL		
EMERGENCY REPAIRS FOR RED HILL TANKS		
Tank #7 REPAIR DRAWI	NG	
Repair No.: 051	File:7R051	
CYLINDER	Quadrant: B	
Course: 28	Plate: 8	
Drawn by: Tom Kitchen	Date: 5/4/98	

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Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

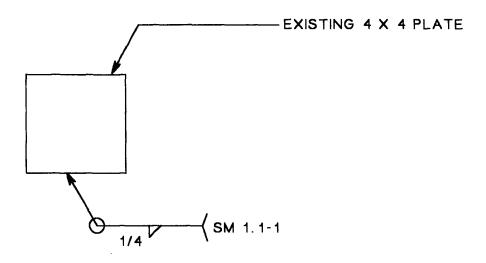
Repair Record

Pinhole indication in fillet weld-Grind out defect, weld repair, and perform P.T.	Tank No.: Re	epair No.: 051	Туре:	Location: B8-28
	N LIV	2 — 4" — — — — — — — — — — — — — — — — —	Gri and	ind out defect, weld repair,

Sketch of Repair Area

Weld Repair			
WPS No.: SM 1, 1 - 1			
Welder ID: John Wal	sh		
NDT Performed:	Visual	Vacuum Box	Dye Penetrant
Rework Required: U/A			
Repair Acceptable:	Bothell	_	Date Accepted: 4-15-98
Coating Repair			
Coating Type: EPOXY			
Surface Preparation: Pr	imer Coat:	Intermediate Coat: _	Final Coat:
NDT Performed: Vi	sual:	DFT:	Average DFT: 8-15 mils
Rework Required: U/A			
Repair Acceptable:	zohell_		Date Accepted: 4-17-98

Inspected 3/29/98 by JF & TK



TYPE 10 REPAIR

MID ATLANTIC ENVIRONMENTAL		
EMERGENCY REPAIRS FOR RED HILL TANKS		
Tank #7 REPAIR DRAW	NG	
Repair No. 1 052	File:7R052	
CYLINDER	Quadrant: B	
Course: 28	Plate: 7	
Drawn by: Tom Kitchen	Date: 5/4/98	

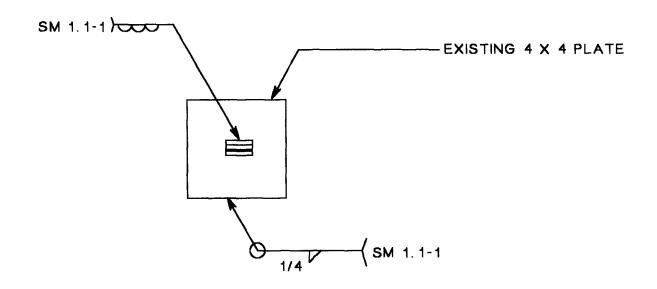
Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

Repair Record

Tank No.:	Repair No.: 052 Type: 10 Location: 37-28
1 4"	Pinhole indication in fillet weld - Grind out defect, weld repair, and perform P.T.

Sketch of Repair Area

Weld Repair			
WPS No.: SM 1.1-1			
Welder ID: John Wa	ulsh		
NDT Performed:	Visual	Vacuum Box	Dye Penetrant
Rework Required: N/A			
Repair Acceptable:	Zahell	_	Date Accepted: 4 - 15 - 98
Coating Repair			
Coating Type: EPOX	Υ		
Surface Preparation:	Primer Coat:	Intermediate Coat:	Final Coat:
NDT Performed:	Visual:	DFT:	Average DFT: 8-15 mil,
Rework Required: ν/Δ			·
Repair Acceptable:	Zadull_	1	Date Accepted: 4-17-99



TYPE 10 REPAIR

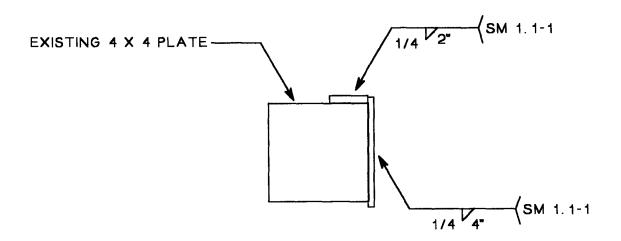
	,		
MID ATLANTIC ENVIRONMENTAL			
EMERGENCY REPAIRS FOR RED HILL TANKS			
Tank #7 RECOMMENDE	D REPAIR DRAWING		
Repair No.: 053	File:7R053		
CYLINDER	Quadrant: B		
Course: 28	Plate: 6		
Drawn by: Tom Kitchen	Date: 5/4/98		

Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

Repair Record

Tank No.: 7 Repair No.: 053 Type: 10 Location; B6-28
Pinhole indication in fillet weld-Grind out defect, weld repair, and perform P.T.
Sketch of Repair Area
Weld Repair
WPS No.: SM 1. 1 - 1
Welder ID: John Walsh
NDT Performed: Visual Vacuum Box Dye Penetrant
Rework Required: N/A
Repair Acceptable: Date Accepted: 4.15.98
Coating Repair
Coating Type: EPOXY
Surface Preparation: Primer Coat: Intermediate Coat: Final Coat:
NDT Performed: Visual: DFT: Average DFT: 8-15 m/
Rework Required: V/R

Date Accepted: 4-17-98



TYPE 10 REPAIR

MID ATLANTIC ENVIRONMENTAL		
EMERGENCY REPAIRS FOR RED HILL TANKS		
Tank #7 RECOMMENDE	D REPAIR DRAWING	
Repair No.: 054	File:7R054	
CYLINDER	Quadrant: B	
Course: 28	Plate: 5	
Drawn by: Tom Kitchen	Date: 5/4/98	

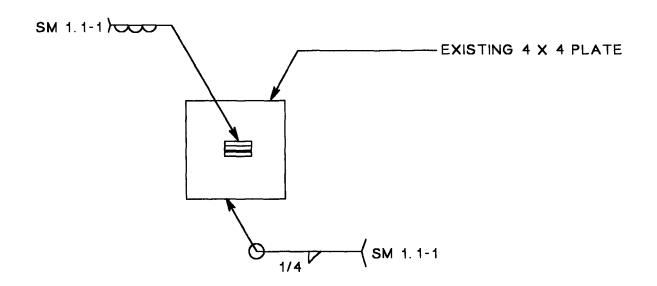
Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

Repair Record

Tank No.: 7 Repair No.: 054 Type: 10 Location: 85-28
Pinhole indication in fillet weld - Grind out defect, weld repair, and perform P.T.
Sketch of Repair Area
Weld Repair
WPS No.: SM [.] - [
Welder ID: John Walsh
NDT Performed: Visual Vacuum Box Dye Penetrant
Rework Required: ν/α
Repair Acceptable: Date Accepted: 4-15-98
Coating Repair
Coating Type: EPOXY
Surface Preparation: Primer Coat: Intermediate Coat: Final Coat:
NDT Performed: Visual: DFT: Average DFT: 8-15 miles
Rework Required: U/A

Repair Acceptable: _

Date Accepted: 4-17-98

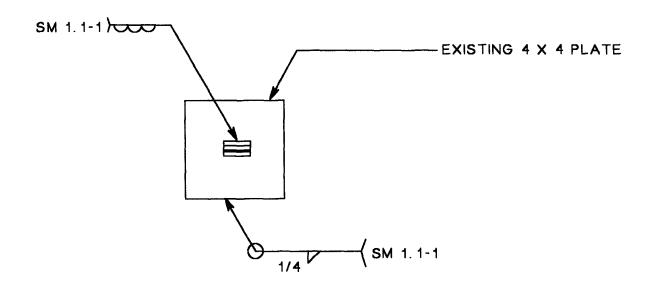


TYPE 10 REPAIR

MID ATLANTIC ENVIRONMENTAL			
EMERGENCY REPAIRS FOR RED HILL TANKS			
Tank #7 RECOMMENDED REPAIR DRAWING			
Repair No.: 055	File:7R055		
CYLINDER	Quadrant: A		
Course 28	Plate: 4		
Drawn by: Tom Kitchen	Date: 5/4/98		

Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

Tank No.: 7 Repair No.: 055 Type: 10 Location: B4-28
Pinhole indication in fillet weld-Grind out defect, weld repair, and perform P.T.
Sketch of Repair Area
Weld Repair
WPS No.: SM 1.1 - 1
Welder ID: John Walsh
NDT Performed: Visual Vacuum Box Dye Penetrant
Rework Required: ν/ν
Repair Acceptable: Date Accepted: 4-15-98
Coating Repair
Coating Type: EPOXY
Surface Preparation: Primer Coat: Intermediate Coat: Final Coat:
NDT Performed: Visual: DFT: Average DFT: 8 5
Rework Required: U/A
Repair Acceptable: Olan Zulul Date Accepted: 4-17-98



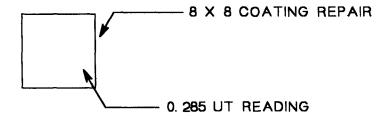
TYPE 10 REPAIR

MID ATLANTIC ENVIRONMENTAL		
EMERGENCY REPAIRS FOR RED HILL TANKS		
Tank #7 RECOMMENDED REPAIR DRAWING		
Repair No. : 056 File:7R056		
CYLINDER	Quadrant: A	
Course: 28	Plate: 2	
Drawn by: Tom Kitchen Date: 5/4/98		

Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

Tank No.: 7	Repair No.:_056	Type:	Location: B2-28
411	- 1'5' -1 		Pinhole indication in fillet weld - Grind out defect, weld repair, and perform P.T.
	R-w1		9 PT
	Sketch	of Repair Ar	rea

Weld Repair
WPS No.: SM 1.1-1
Welder ID: John Walsh
NDT Performed: Visual Vacuum Box Dye Penetrant
Rework Required: ν/Λ
Rework Required: N/A Repair Acceptable: Date Accepted: 4-15-98
Coating Repair
Coating Type: POXY
Surface Preparation: Primer Coat: Intermediate Coat: Final Coat:
NDT Performed: Visual: DFT: Average DFT: 8-15 mils
Rework Required: ν/\hbar
Repair Acceptable: Date Accepted: 4.17.78

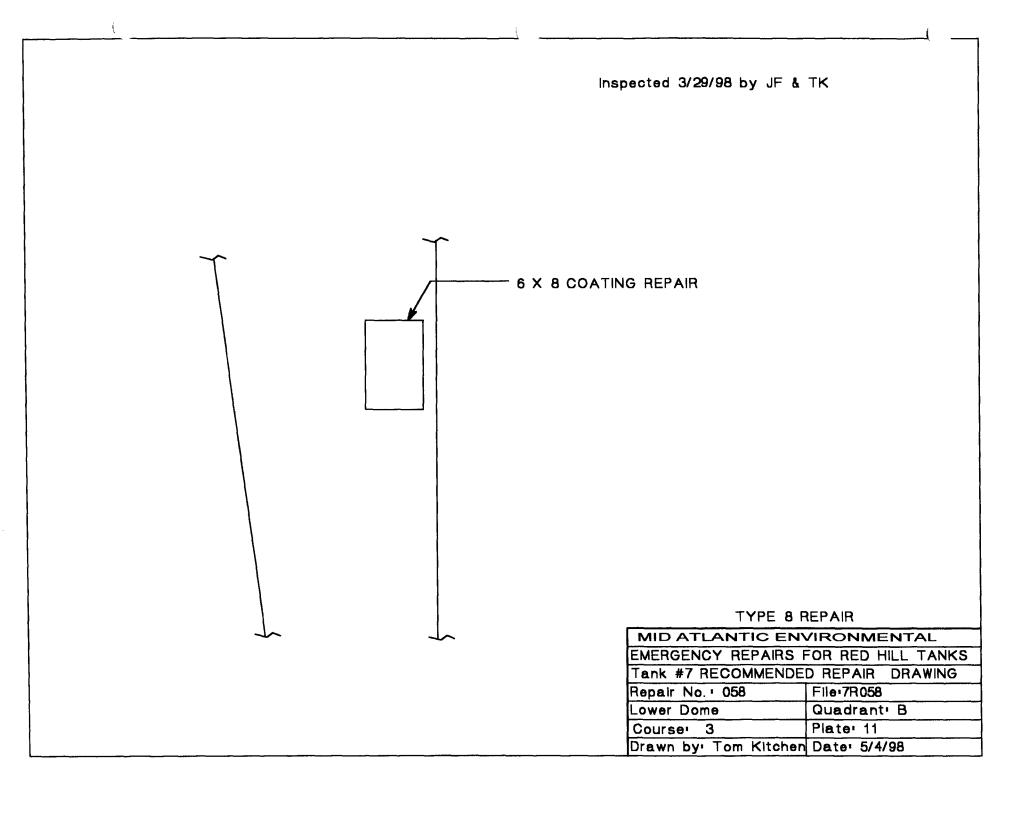


TYPE 8 REPAIR

MID ATLANTIC ENVIRONMENTAL		
EMERGENCY REPAIRS FOR RED HILL TANKS		
Tank #7 RECOMMENDED REPAIR DRAWING		
Repair No.: 057	File:7R057	
LOWER DOME	Quadrant: B	
Course: 3	Plate: 11	
Drawn by: Tom Kitchen	Date: 5/4/98	

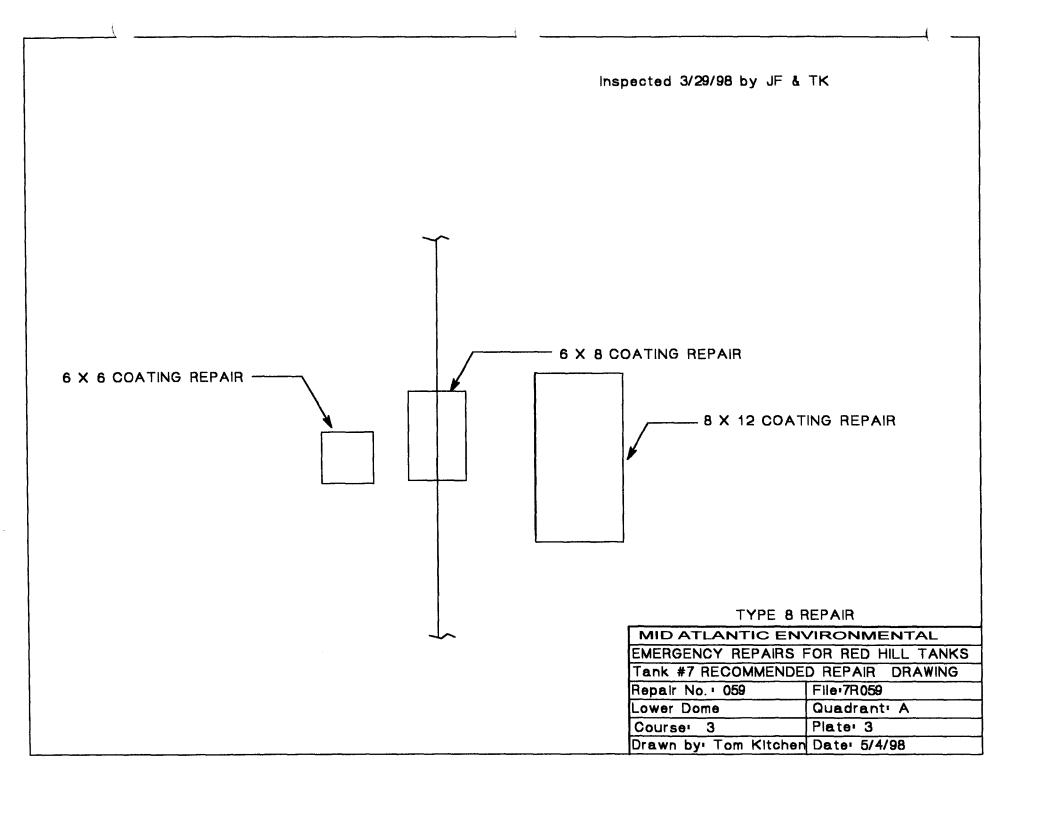
Dames & Moore
Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center
Contract No. N62742-96-C-1356

Tank No.: 7 Repair No.: 057 Type: 8 Location: 811-3
8"x 8" CORROSION BLISTERS
Sketch of Repair Area
Weld Repair W/A
WPS No.:
Welder ID:
NDT Performed: Visual Vacuum Box Dye Penetrant
Rework Required:
Repair Acceptable: Date Accepted:
Coating Repair
Coating Type: EPOXY
Surface Preparation: Primer Coat: Intermediate Coat: Final Coat:
NDT Performed: Visual: DFT: Average DFT: B
Rework Required: NA
Repair Acceptable: John Backell Date Accepted: 4-17-9



Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

Tank No.: 7 Repair No.: 05% Type: 8 Location: B11-3
6 x 8 CORROSION BLISTER
Sketch of Repair Area
Weld Repair N/A
WPS No.:
Welder ID:
NDT Performed: Visual Vacuum Box Dye Penetrant
Rework Required:
Repair Acceptable: Date Accepted:
Coating Repair Coating Type: EPOXY
Surface Preparation: Primer Coat: Intermediate Coat: Final Coat:
NDT Performed: Visual: V DFT: Average DFT: 8-15 m.1
Rework Required: U/A
Repair Acceptable: John Sulull Date Accepted: 4-17-98

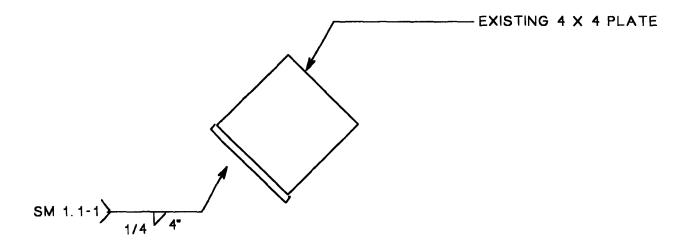


Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

Repair Record

Tank No.:	7 Repair No.:_	059 Type:	8	Location:	A3-3
	F. 6"	8"	k 8">	12"	
		1	CORR	osion F	BUSTELS
		Sketch of Repair	r Area		
Weld Repair	N/A				

WPS No.: Welder ID: Visual _____ Vacuum Box _____ Dye Penetrant ____ NDT Performed: Rework Required: Repair Acceptable: Date Accepted: Coating Repair EPOXY Coating Type: Surface Preparation: _____ Primer Coat: _____ Final Coat: _____ Final Coat: _____ Visual: _____ DFT: ____ Average DFT: ______ 8-15 miles NDT Performed: Rework Required: _\(\mu/\beta\) Date Accepted: 4.17.98 Repair Acceptable:



TYPE 10 REPAIR

MID ATLANTIC ENVIRONMENTAL			
EMERGENCY REPAIRS FOR RED HILL TANKS			
Tank #7 RECOMMENDED REPAIR DRAWING			
	File:7R060		
CYLINDER	Quadrant: A		
Course: 17	Plate: 1		
Drawn by: Tom Kitchen	Date: 5/4/98		

Emergency Repairs For Red Hill Tanks at the Fleet Industrial & Supply Center Contract No. N62742-96-C-1356

Tank No.: 7 Repair No.: 060 Type: 10 Location: A1-17
Pinhole indication in fillet weld - Grind out defect, weld repair, and perform P.T.
Sketch of Repair Area
Weld Repair
WPS No.: <u>SM1.1-1</u>
Welder ID: John Walsh
NDT Performed: Visual
Rework Required: U/A
Repair Acceptable: Date Accepted: 4-15-98
Coating Repair
Coating Type: Epoxy
Surface Preparation: Primer Coat; Intermediate Coat: Final Coat:
NDT Performed: Visual: DFT: Average DFT: _8-15 m. \square
Rework Required:
Repair Acceptable: Date Accepted: 4-17-98