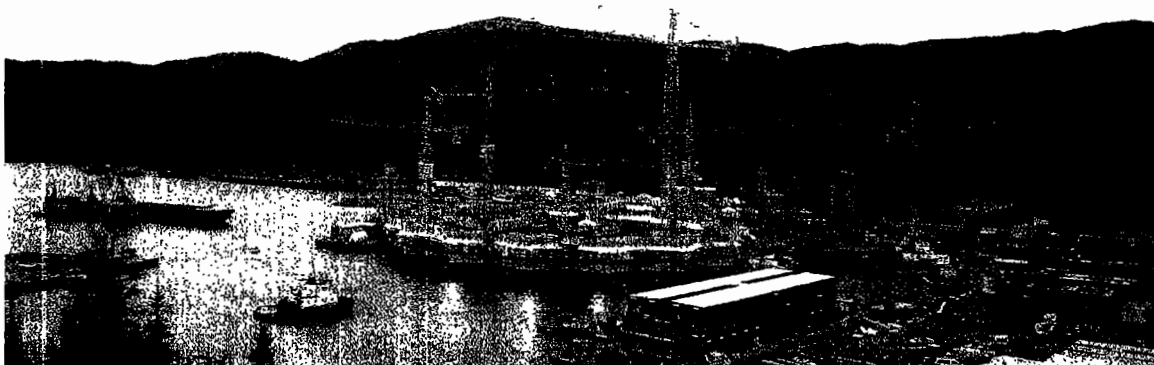


# Hibernia Floating Out 1,400,000 Tons

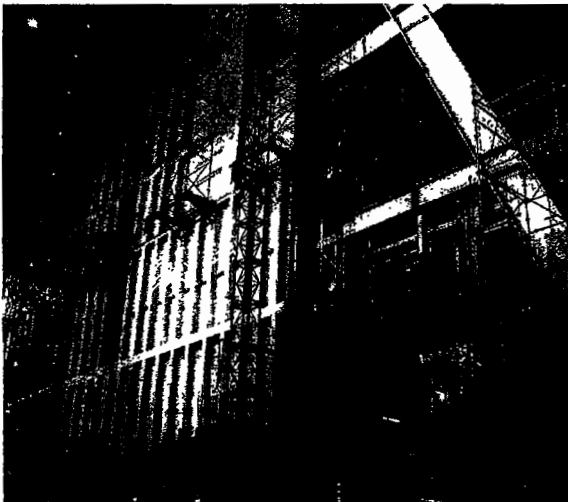


*The Hibernia Project dominates Mosquito Cove in Bull Arm Bay, Newfoundland.*

It's as big around as a stadium, high as a 74-story building, weighs about 1.4 million tons, and will be floated 200 miles out to sea. The massive Hibernia offshore oil drilling platform is unique in design and concept. Its concrete base will rest on the ocean floor. The platform will drill down to two sandstone deposits holding two billion barrels of oil.

The base, with 16 "teeth" in its exterior wall to fend off ice bergs, is under construction at Mosquito Cove and Bull Arm Bay, Newfoundland. Up to 1.3 million gallons of crude oil can be stored in the base for fast loading into double-hulled tankers. The lowest section of the base was built in a drydock, the drydock flooded, and the section towed and moored to a deepwater site for completion to its full height of about 36 stories. On this huge "pedestal" will rest the topsides assembly of drilling and production equipment.

Five large modules—process, wellhead, mud, utility, and service/quarters—and smaller structures including drilling derricks, flare boom, helipad, pipe rack, and lifeboat sta-



*Wellhead Module rises fifteen stories.*

tions will make up the assembly. The 15-story wellhead module (the smallest at 4710 metric tons) and some smaller structures are being constructed on site. The four other modules, being fabricated in Korea and Italy, will be towed to Mosquito Cove. After assembly, the topsides structure



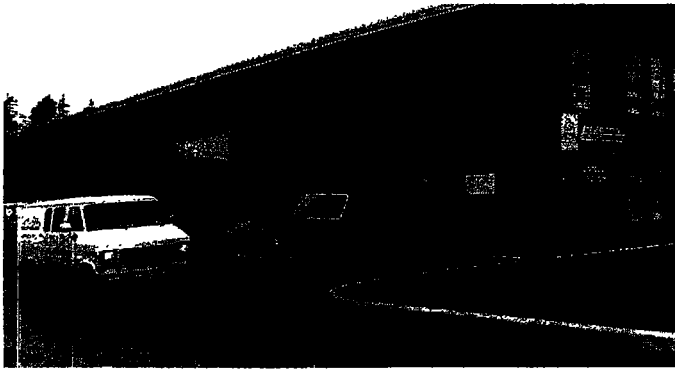
*Helping to make it happen (left to right): Bernie Wall, General Foreman Welding; Don Tucker, PASSB Electrical Supervisor; Berge Husa, Materials Supervisor; Steve Griffiths and Keith Pike of Electro Mechanical Services; and Mark Burke, Lincoln Electric Technical Sales Representative.*

will be towed out and attached to the base. The complete platform will then be tugged about 200 miles east of St. John's, NF, and positioned for drilling.

## Wellhead Module

The wellhead module being fabricated at the site is 90% complete and on schedule, as are the lifeboat stations, flare boom, and helipad assemblies. Weld quality standards are, of course, strict. Specifications call for 100% perfect welds. Weld repair rate has been held to a remarkable 0.4%. There were 155 welding procedure qualification tests developed by PASSB for structural steel and 35 for piping. Pre-site and on-site training and qualification required a major initial effort and a continuing program.

In the wellhead module building, about 60 welders per shift lay down 25 lbs. of wire per day each. A total of 150 welders are available, most trained in SMAW, FCAW, and



Electro Mechanical Services, Mount Pearl, NF, a Lincoln Distributor and Field Service Shop, providing both service and creative input.



Welders take a 15-story-high break on top of the wellhead module.

SAW. Most wire is Lincoln's 81K2H. High technology Invertec™ V300's were in use throughout the building along with DC-400's, -600's, -1000's, and LN-25's. Over 300 Lincoln power sources virtually covered the topsides area. "Lincoln provides good quality equipment," said Bernie Wall, Welding Foreman. "The skill of the welders, training, PASSB maintenance Dept., and equipment account for the exceptional quality of our welding." Added Berge Husa, Materials Supervisor, "Our people chose Lincoln also because of their proven track record on offshore projects in Norway." Richard Arnt welding specialist for the utility shaft added, "We chose Lincoln because of their excellent performance in South Texas on the Green Canyon Project."

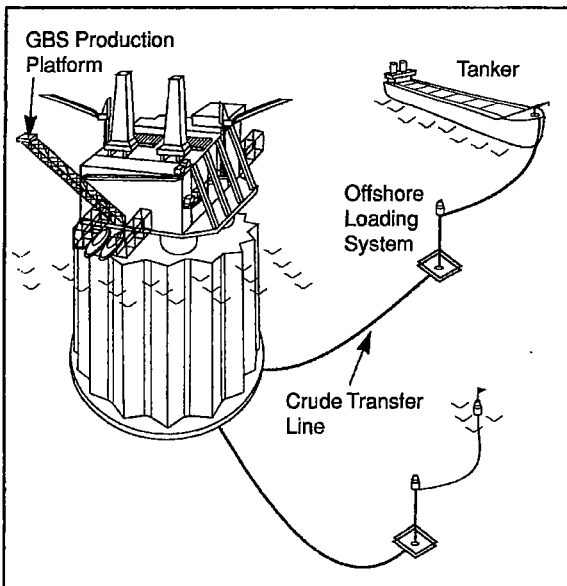
**Distributor Excellence**

Service from Electro Mechanical Services, Mount Pearl, NF, a Lincoln Distributor and Field Service Shop, has been exceptional, providing both service and creative input. The

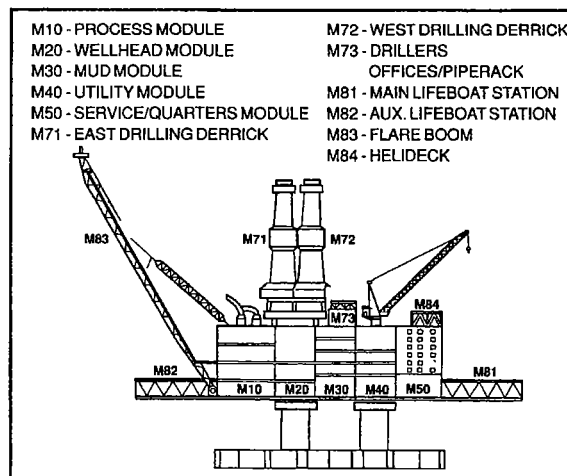
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Training to meet exacting weld standards on an Invertec V300-PRO.



Hibernia Production System Components



Topsides Assembly

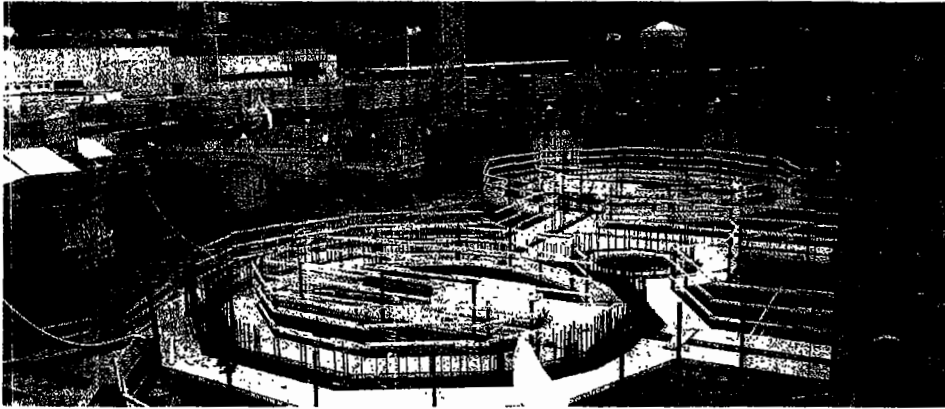
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*Hibernia continued:* expertise of EMS president and owner Dave Griffiths, his son Steve, and Salesman Keith Pike, is always readily available. They are backed up by Mark Burke, Lincoln Electric Technical Sales Representative.

Controlled by The Hibernia Management and Development Company Ltd., this incredible undertaking, with many design concepts and structures never used before, is on schedule. Upwards of 3500 workers on site, and thousands elsewhere, are molding concrete and steel into a unique, safe, and environmentally responsible offshore platform. The first drum of crude should flow in September, 1997—on schedule.



*Invertec V300-PRO produces quality welds at PKS, vital for an offshore rig.*



*Stadium-sized Gravity Base Structure under construction.*

## WHAT'S NEW AT LINCOLN ELECTRIC

### New! TIG, Stick Power Source Invertec® V250-S

It's compact and 36-pounds light. It welds both stick and TIG. The new Invertec V250-S is an inverter-based, constant current power source designed for welding versatility. Most DC stick and TIG welding applications from 1-250 amps are easily handled.

Controls on the V250-S are simple to operate. A three-position mode switch allows the V250-S to produce both a soft stick welding arc or a touch start TIG arc without high frequency starting techniques.

You can produce a gentle start for thin gauge material or open gap weldments. Or select a more powerful start for positive penetration on critical weldments or dirty/rusty steel. The energy-efficient Invertec V250-S is ideal for machine shop, field, and maintenance operations where an extremely smooth TIG welding arc is needed. Great for welder training schools. It's versatile, compact, lightweight, easy-to-operate. The new Invertec V250-S!

