

## Assignment

Kraatz was contracted by the Rossing Uranium, a RioTinto company, to construct a new sulphuric acid storage tank. This was an addition to 2 similar existing tanks. Construction has to take place during normal operations and also included the tie-in of pipework to the existing pipework. The tank’s dimensions were 24m in diameter, 18 m high and included a staircase for access to the roof of the tank. The client places a very high priority on safety and this needed to be kept in mind all the time. The applicable standard for construction and quality management was API 650. Quality of welding is of utmost importance due to the API requirements and the relative thickness of some sections of the shell plate, up to 25mm.

## Getting the job done

Due to the client’s high priority on safety, Kraatz adopted a first for Namibia approach, by constructing the tank in a “top down” manner. The key benefit of this approach is that working at heights is restricted to a minimum.

The “top down” approach entails that the floor section of the tank being built first, then the top strake of the tank, then the roof section and then the remaining strakes. The completed tank section is then jacked up so that the next strake could be added at the bottom. The following pictures are an illustration of this method.

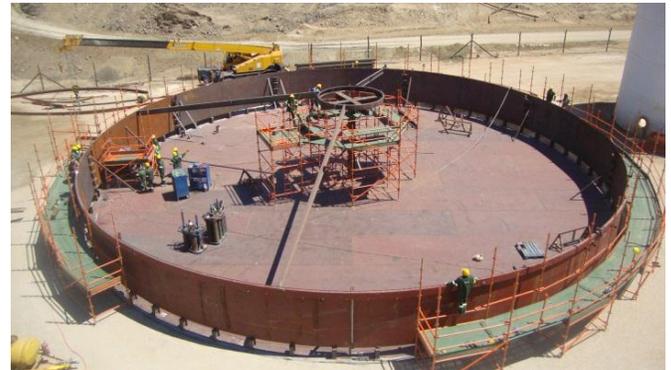


Figure 2 - Top strake assembled



Figure 3 - Roof section assembly in progress



Figure 1 - Floor section



Figure 4 - First strake and roof "jacked up"

# “10kt above ground acid storage tank”



Figure 5 - Second strake in progress

## Key learnings

The project was completed successfully and a total of 57,000 hours was spent without a reportable incident. Quality standards were high and achieved throughout the project.



Figure 6 - Project completed