

COCHRAN LTD

Newbie Works, Annan, Dumfries & Galloway, Scotland, UK DG12 5QU
 Telephone: +44 (0) 1461 202111 Fax: +44 (0) 1461 200255
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**CERTIFICATE OF COMPLIANCE**

Description	Steam Boiler	Manufacturer	Cochran Ltd
Type	ST23		
Approximate Overall Dimensions	1520 I/Dia x 2440 LOTP	Serial Number	23/7749
Approved Drawing Number(s)	V131063 Rev B	Year of Manufacture	2020
Working Pressure	0.6 N/mm ²	Design Organisation	Cochran Ltd
Applicable Standard	BSEN12953:2002, BSEN12953-4:2002, BSEN12953-5:2002	Purchaser	Kerry Foods Ltd.
	Joint Factor 0.85		
Inspection Authority	British Engineering Services Limited	Purchaser's Number	

Design	Design Conditions of Principal Components	Design Pressure N/mm ²	Design Temperature °C	Corrosion Allowance mm
	Shell Plate	1.1	188.0	0.75
	Shell Tubeplates	1.1	238.0	0.75
	Furnace	1.1	263.0	0.75

Other factors affecting design (e.g. weight, nature of contents, environment): None

Pressure Test		Post Weld Heat Treatment	
Location	Newbie Works, Annan	Component	PWHT Not Required
Test Pressure	1.774 N/mm ²	Temperature	N/A
Test Medium	Water	Holding Time	N/A
Date	23/10/2020	Date	

Design

We certify that the design of this vessel complies with the stated standard.

For Manufacturer

[Signature]

Position: Chief Engineer

Date: 29/10/2020

We confirm that we have checked the design of the above vessel and that it complies with the stated standard.

For Inspection Authority

[Signature]
 D. L. CHEMUNSON
 British Engineering Services Engineering

Position: Senior Engineer

Date: 12 NOV 2020

Construction and Testing

We confirm that this vessel has been constructed and tested in compliance with the stated standard.

For Manufacturer

[Signature]

Position: Quality Manager

Date: 29/10/2020

We confirm that the construction and testing of the above vessel has been carried out under our surveillance and that to the best of our knowledge and belief all aspects comply with the requirements of the stated standard.

For Inspection Authority

[Signature]
 British Engineering Services Engineering

Position: Surveyor

Date: 12 NOV 2020

NOTIFIED BODY CERTIFICATE OF CONFORMITY

In accordance with module G (Unit Verification) of the Pressure Equipment Directive	Certificate Number BESL/ CAT000519412- 23/7749 Rev. 0
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Manufacturers's Name	Cochran Group Limited
Address	Newbie Works Annan Dumries & Galloway DG12 5QU

Description	Boiler
Identification No	23/7749
Drawing No	V131063 Rev B V95225 Rev K
Design Code	BS EN 12953:2002
Year of Manufacture	2020
Chamber	Shellside
Design Pressure	11 bar (g)
Design Temperature	188°C
Volume	3080 Litres
Contents	Steam
Hydraulic Test Pressure	17.74 bar(g)
Test Date	23/10/2020
Safety Valves	ARI ARMATUREN ARI-SAFE 12901 DN32/50
Capacity	2407 kg/h
Set Pressure	7.7 bar(g)
Manufacturing and other arrangements	
For details of the Inspection/Test plans, Welding Procedures, Welding Personnel, NDT Procedures, NDT Personnel and Particular Material Appraisal results please see the Technical File.	

Notified Body	
Name	British Engineering Services Limited
Address	5 New York Street, Manchester, M1 4JB
Identification Number	0040

The undersigned declares that the design, manufacture and inspection of this equipment conforms with the relevant requirements of Pressure Equipment Directive 2014/68/EU.

Date
18/12/2020

Name
Mr L Cleminson

Position
Consulting Engineer




Signed on behalf of British Engineering Services
Limited



**TECHNICAL SERVICES DEPARTMENT
REPORT OF EXAMINATION**

For: **Cochran Group Limited**

At: **S4807
Newbie Works
Annan
Dumries & Galloway
DG12 5QU**

Contract details: **Examination of Boiler Ref. No. 23/7749 during manufacture in accordance with BS EN12953-3:2002, BS EN12953-4:2002, BS EN12953-5:2002
CE Marked
PED Module G
Cochran Ltd client : Kerry food Ltd.**

Examination(s) and/or tests: **Drawing No. V131063 Rev. B
The boiler was examined during fabrication.
The examinations included the following :-
Examination of materials ,checks on material traceability.
Review of weld procedures & welder qualifications.
Examination of weld fit ups prior to welding on :- Shell, Furnace tube, Tubeplates, Pads & standpipes & Stay bars/tubes.**

**Witness Hydraulic pressure test 23/10/2020
Test pressure 17.74 barg.
Tested with water & held for 30 minutes. Gauge No. 01150784 was used.
Final visual examination & sample dimensional check.
Name plate details confirmed against drawing.**

**The boiler data book review included the following :-
Review of material test certificates
Review of NDT reports covering Radiography, UT, MPI.**

Observations and/or results: **The above detailed inspections during manufacture were satisfactory.
NDT Operator Quals confirmed PCN Level 2 and in date.
Pressure gauge confirmed calibrated and traceable to National Standards.
Hydraulic Test certificate signed off.
Nameplate reviewed and stamped BES.**

Unless otherwise stated, this inspection has been completed in accordance with Procedure 05-20-P01.

NOTE: This document is issued subject to a disclaimer of any liability on the part of the Group or its servants or sub-contractors for loss of profits or loss of use, however caused, and irrespective of the nature or effect of any defect which may have caused or contributed to such loss.

Date of Examination **16/09/2020**

Report Date **17/11/2020**

Signature: Mr W Prudham
07920 507314



SS3B

vers E.21

ID: 37058135

Qualification - Engineer Surveyor to
British Engineering Services
5 New York Street, Manchester M1 4JB
Telephone: 0345 712 5842 Web: britishengineeringservices.co.uk



COCHRAN

Cochran Ltd
Newbie Works, Annan
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Scotland, UK DG12 5QU

Tel: +44 (0)1461 202111
Email: info@cochran.co.uk

EU Declaration of Conformity

Manufacturer's Declaration of Conformity for Design, Manufacture and Inspection

Description:	Serial No.	Module	Notified Body	EC Cert. Ref.	Mfr Std
Boiler	23/7749	G	British Engineering Services Manchester, UK 0040 British Engineering Services Manchester, UK 0040	BESL/CAT000519412-G1-23/7749 Rev. 0 CE/0040/PED/G/COC/060/20/GBR	BS EN12953

This declaration of conformity is issued under the sole responsibility of the manufacturer and the undersigned declares for and on behalf of the manufacturer that the design, manufacture, and inspection of the boiler plant equipment listed above and their associated valves, fittings, instrumentation and controls conform to the requirements of the:

Pressure Equipment Directive 2014/68/EU
Machinery Directive 2006/42/EC
The Low Voltage Directive 2006/95/EC
The Electromagnetic Compatibility Directive 2004/108/EC

Name: A. Shaw

Position: Quality Manager

Signature: *A Shaw*

Date: 26 October, 2020

Contract Number: 23/7749

Date: 26/10/2020

LETTER OF CONFORMITY

This is to certify that the materials used in the manufacture of the above unit, which are not covered by individual certification, conforms to the required specification.



Quality Manager
Cochran Ltd

PRESSURE TEST RECORD

OM 88252/7

Contract Reference:		23/7749	
Client:		KERRY FOODS LTD.	
Inspection Authority:		BRITISH ENGINEERING SERVICES LTD	
Test Pressure	(Required)	17.74	Bar (g)
"	(Achieved)	17.74	Bar (g)
Hold Period		30	minutes
Vessel Checked		Yes	
Pipework Checked		n/a	
Indents Checked		Yes	
Gauge Calibration Ref.		01150784	
Test Procedure		QCP570	
Remarks			
Date Tested:		23-10-20	
Quality Control		Inspection Authority	Client
Signed: <i>A. Leithner</i>		British Engineering Services Witness <input checked="" type="checkbox"/> Review <input checked="" type="checkbox"/> Sig: <i>C. Bellon</i>	

**MEASUREMENT OF IRREGULARITIES
IN BOILER SHELL PROFILE**

CONTRACT No: 23/7749	
SHELL: OUTSIDE DIAMETER 1540 mm PLATE THICKNESS 10 mm	MAX. ACCEPTABLE IRREGULARITY GENERAL, POSITIVE (A) 3.00 mm POSITIVE, NOT EXCEEDING 1M (B) 3.75 mm NEGATIVE <5 mm
GAUGE CONFORMITY CHECK <i>A. Lethbridge</i>	

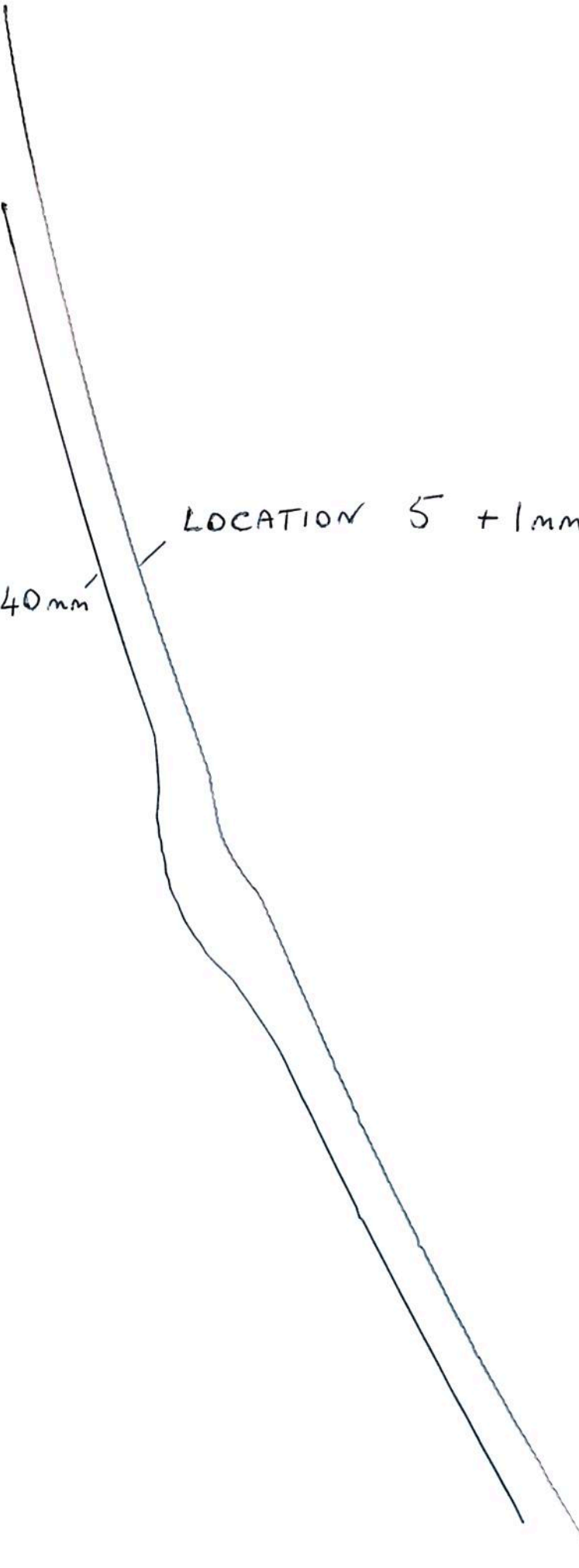
LOCATION*	IRREGULARITY mm	LOCATION*	IRREGULARITY mm
	AFTER ALL WELDING		AFTER ALL WELDING
1	-1	19	
2	0	20	
3	0	21	
4	0	22	
5	+1	23	
6	+1	24	
7	+1	25	
8	0	26	
9	0	27	
10	0	28	
11	0	29	
12		30	
13		31	
14		32	
15		33	
16		34	
17		35	
18		36	

MEASURED BY: *A. Lethbridge* DATE: 23-10-20

* LOCATIONS NUMBERED AT 250mm INTERVALS ALONG THE SHELL FROM FRONT TUBEPLATE. ACTUAL GREATEST DISCONTINUITY REPRESENTED ON THE REVERSE SIDE.

IMPORTANT NOTE TO END USERS

Please retain this report for review by your statutory inspector. Ref:SAFed SBG2



GAUGE

1540mm

LOCATION 5 + 1mm