

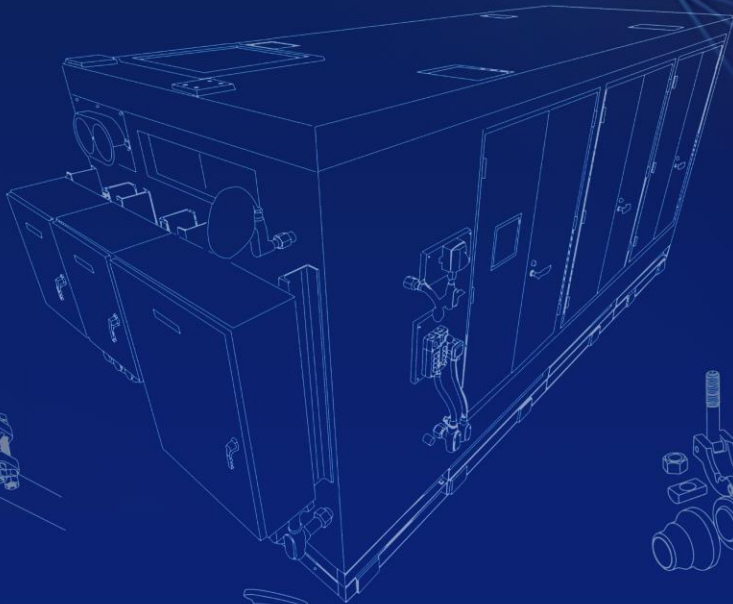


**cimtas** | NINGBO  
MODULAR SKIDS  
PIPE SPOOLS

# 2022

COMPANY  
OVERVIEW

公司简介







# CONTENT

01 ENKA

02 CIMTAS GROUP

03 CIMTAS NINGBO

- ✓ Prefabricated Pipe Spools
- ✓ Modularization
- ✓ Energy Services Business





01

ENKA





# ENKA OVERVIEW



64

Years of Engineering and  
Construction Experience  
Worldwide



64

Subsidiaries



Over  
500

Projects



46

Countries



5

Billion  
USD Market Cap



Over  
16,500  
Employees



CIMTAS STEEL



CIMTAS PIPE & FITTING & SPOOLS



CIMTAS PRECISION MACHINING



CIMTAS NINGBO MODULAR SKIDS  
PIPE SPOOLS



CIMTAS MODULE & SHIPYARD

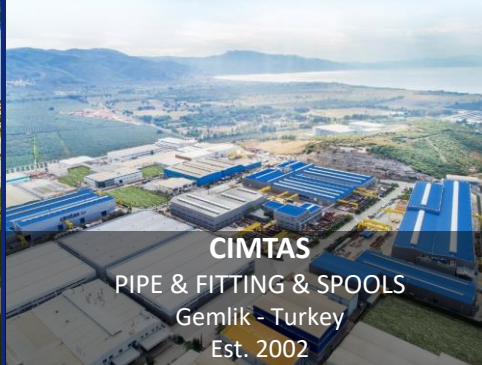




# CIMTAS GROUP



**CIMTAS**  
STEEL  
Gemlik - Turkey  
Est. 1973



**CIMTAS**  
PIPE & FITTING & SPOOLS  
Gemlik - Turkey  
Est. 2002



**CIMTAS**  
NINGBO MODULAR SKIDS PIPE SPOOLS  
Ningbo - China  
Est. 2002



**CIMTAS**  
MODULE & SHIPYARD  
Golcuk - Turkey  
Est. 2010



**CIMTAS**  
PRECISION MACHINING  
Gemlik - Turkey  
Est. 2012

- Structural Steel
- Pressurized Equipment
- Steel Wind Towers
- Installation and Modularization

Fenced Area : 160,000 sqm  
Covered Area : 60,000 sqm  
Annual Fabr. Capacity : 50,000 ton

[www.cimtas.com](http://www.cimtas.com)

- LSAW Pipes
- Fittings
- Pipe Spools
- Skids and Modules

Fenced Area : 120,000 sqm  
Covered Area : 60,000 sqm  
Annual Fabr. Capacity : 42,000 ton  
Annual Manf. Capacity : 160,000 ton

[www.cimtaspipe.com](http://www.cimtaspipe.com)

- Pipe Spools
- Skids and Modules
- Energy Services Products

Fenced Area : 55,250 sqm  
Covered Area : 31,680 sqm  
Annual Fabr. Capacity : 20,000 ton

[www.cimtasnbo.com](http://www.cimtasnbo.com)

- Structural Steel
- Shipbuilding
- Power Ship
- Modules
- Offshore

Fenced Area : 212,000 sqm  
Covered Area : 42,500 sqm  
Annual Fabr. Capacity : 35,000 ton

[www.cimtasshipyard.com](http://www.cimtasshipyard.com)

- Gas Turbine Components :
- Combustion Casing
- End Cover
- Welded Turbulated Liner
- Transition Pieces

Fenced Area : 12,000 sqm  
Covered Area : 8,000 sqm  
Annual Fabr. Capacity : 7,000 pcs

[www.cimtas machining.com](http://www.cimtas machining.com)

**Cimtas Ningbo** is a Chinese company fully owned by the Cimtas Group.

A subsidiary of **ENKA**



# CIMTAS GROUP REFERENCES







03

CIMTAS NINGBO  
MODULAR SKIDS  
PIPE SPOOLS



# HSE POLICY



## our mission

To **deliver** high **quality** engineering, procurement, welded fabrication, assembly and installation services, **safely, on time** and at the **least total cost** of each customer.

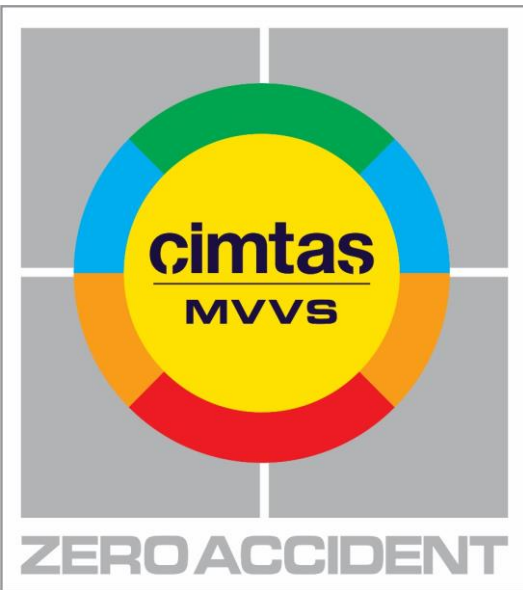
## our vision

To be the **best-in class** and **preferred** partner for the engineered and **integrated** solutions of the demanding construction projects.

## our values

Safety, competency, development and leadership of our **employees**  
Satisfaction of our **customers** through operational excellence and flexibility  
Effective use of advanced **technology** and **information**  
Identification and roll-out of **best practices** and **lessons learned**  
Being **innovative** in everything we do and willingness to **change**  
Being ethically, environmentally and socially **responsible**

Corporate HSE program with Zero Accident as top priority





# OVERVIEW



- ✓ Established in July 2002 at the Ningbo Free Trade Zone, China
- ✓ Fully-owned subsidiary of Cimtas, Turkey
- ✓ Fabrication of OEM, Power and Process piping
- ✓ Assembly of Process Skids and Modules
- ✓ ~ 500 employees
- ✓ Fenced area : 55,250 sqm
- ✓ Covered area : 31,680 sqm
- ✓ Annual fabrication capacity
  - 1.5 Million Dia"
  - 20,000 ton

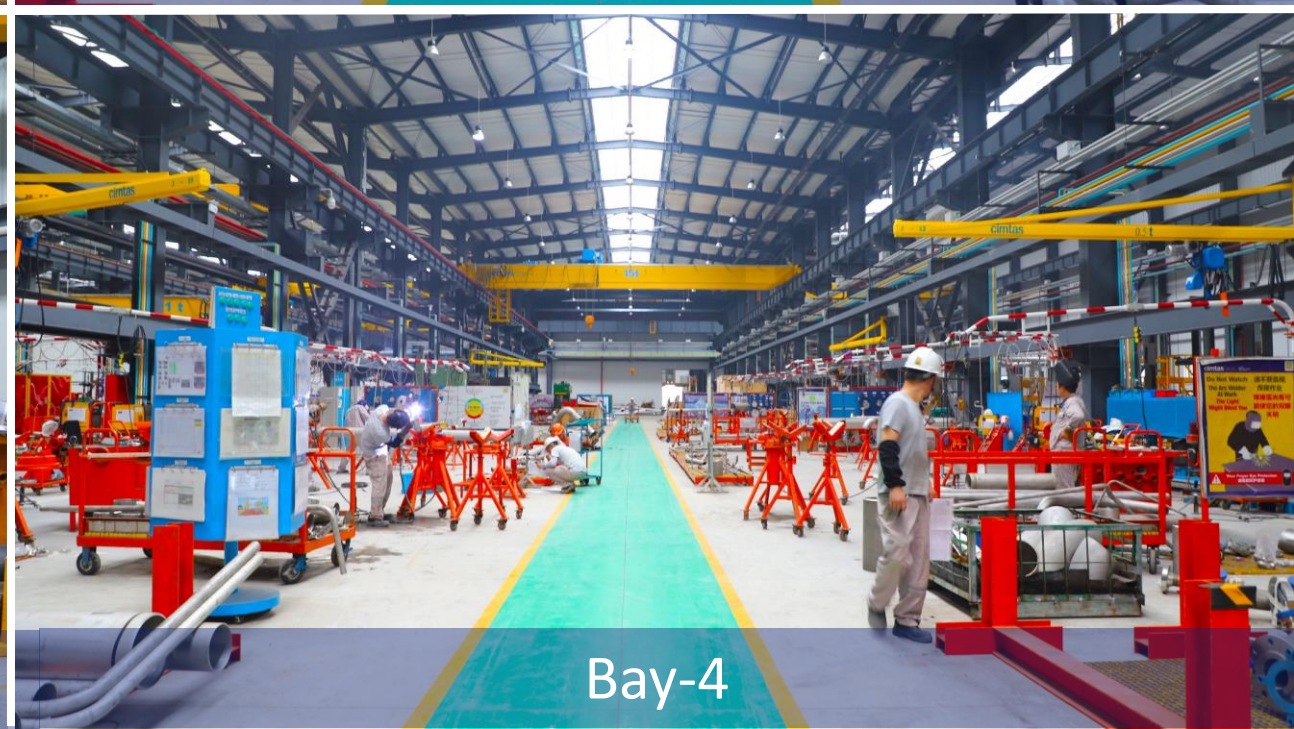
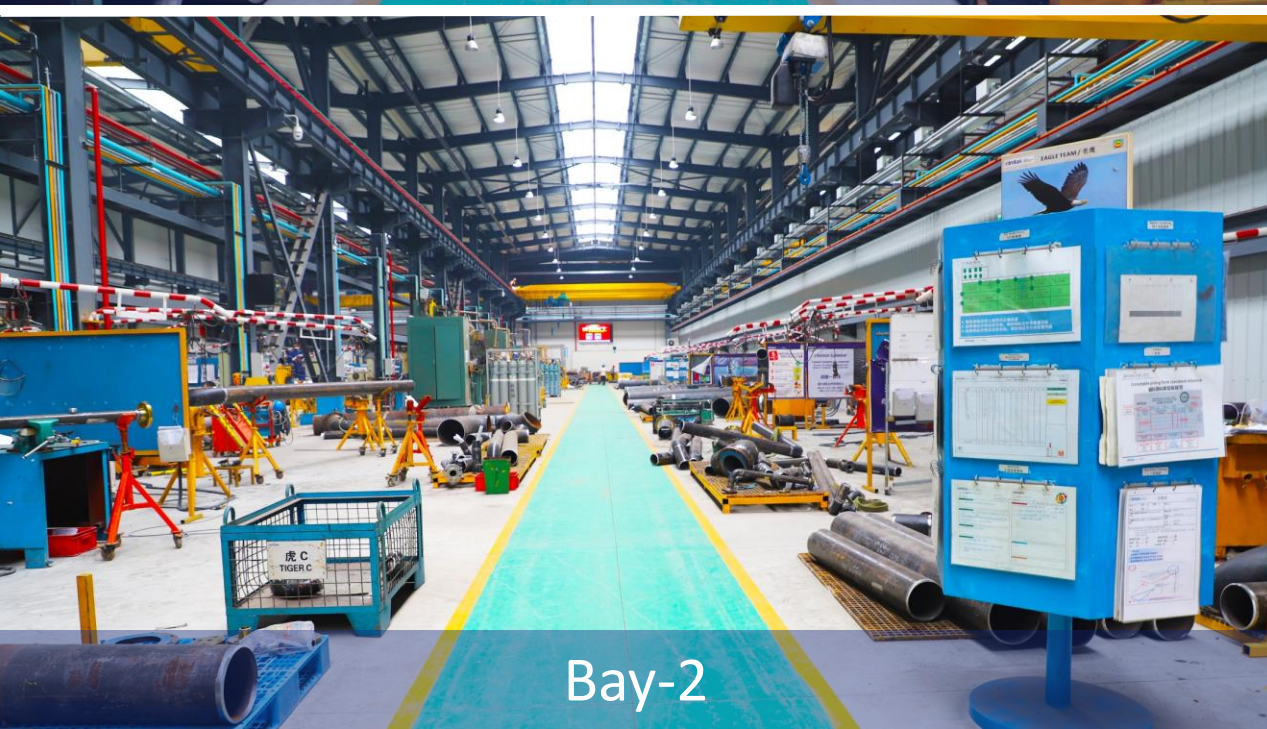
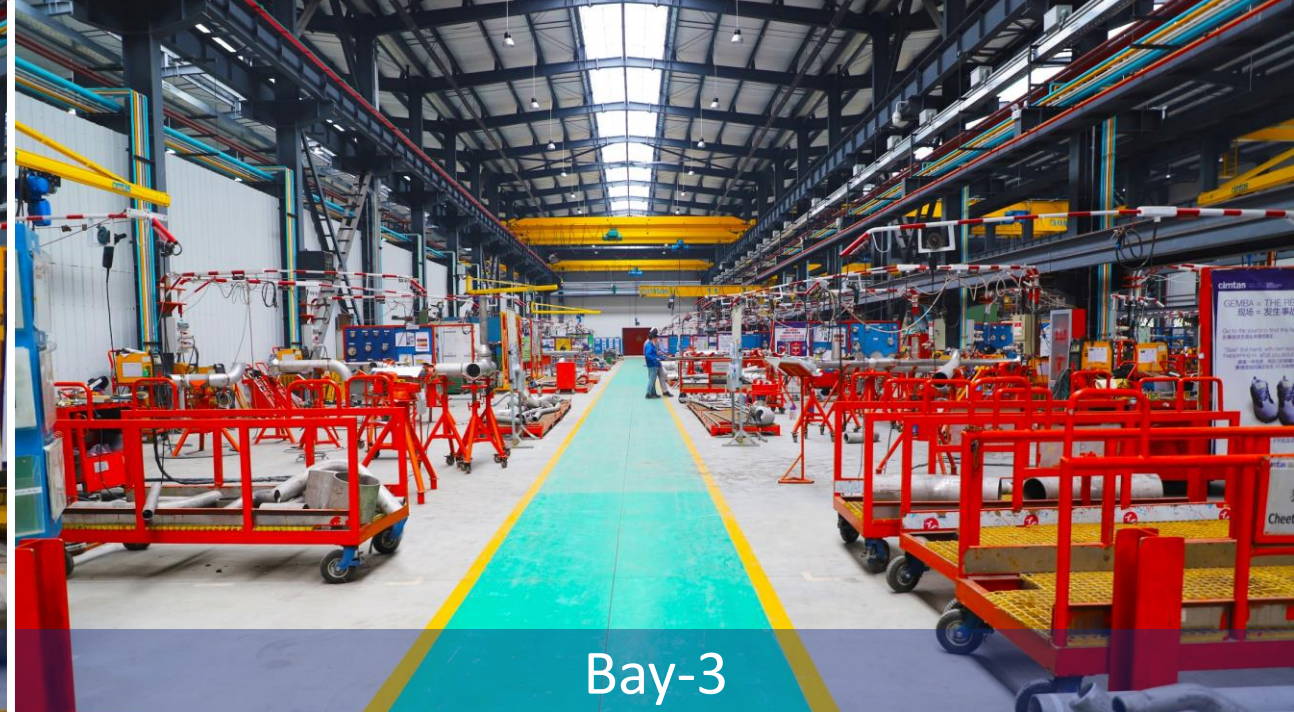


# LAY-OUT



Area	Covered	Uncovered	Total
Bay 1-2-3-4	7,458 m <sup>2</sup>	-	7,458 m <sup>2</sup>
Bay 5 (Skid & Jig Assembly Bay)	2,260 m <sup>2</sup>	-	2,260 m <sup>2</sup>
Bay 6-7 (STP Areas)	6,700 m <sup>2</sup>	-	6,700 m <sup>2</sup>
Bay 8-9 (Packing + High Module Assembly Bay)	5,896 m <sup>2</sup>	-	5,896 m <sup>2</sup>
Storage Areas	2,310 m <sup>2</sup>	4,851 m <sup>2</sup>	7,161 m <sup>2</sup>
Offices	4,418 m <sup>2</sup>	-	4,418 m <sup>2</sup>
Open Areas	-	23,566 m <sup>2</sup>	23,566 m <sup>2</sup>
<b>Grand Total</b>	<b>29,042 m<sup>2</sup></b>	<b>28,417 m<sup>2</sup></b>	<b>55,250 m<sup>2</sup></b>









Bay-5 (Skid & Jig Assembly Bay)



Warehouse (Indoor)



Bay-9 (High Module Assembly Bay)



Warehouse (Outdoor)





Grit Blasting

Dimensions : 14.0x5.0x4.5m

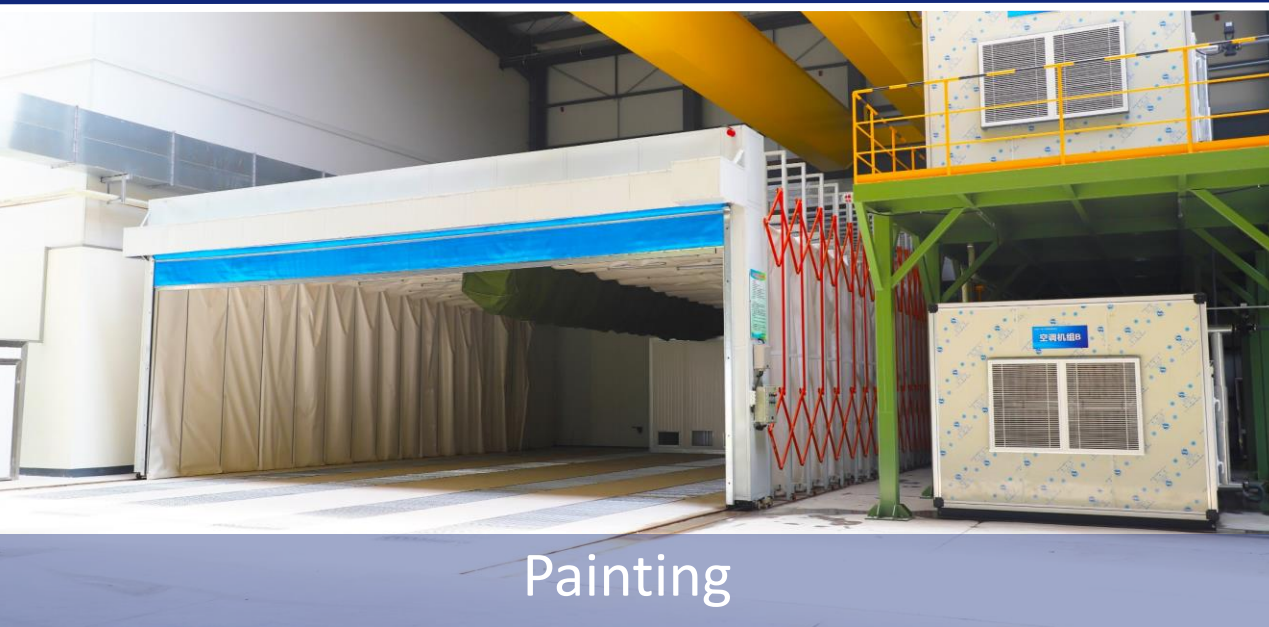
Quantity : 3 units



Heat Treatment

Unit 1 : Dimensions : 14.0x6.9x3.5.0m

Unit 2 : Dimensions : 8.0x4.0x3.0m



Painting

Dimensions : 20.0x12.0x5.0m

Quantity : 2 units



NDT

Unit 1 : Dimensions : 14.0x5.5x4.0m

Unit 2 : Dimensions : 14.0x5.5x3.5m



# Auxiliary Equipment



Pickling Pool



Phosphate Pool



Stainless Steel Pre-treatment Area



Carbon Steel Pre-treatment Area

Dimensions : 6.8\*2.3\*2.0m

Dimensions : 6.8\*2.3\*2.0m



# Environmental Protection



## The Catalytic Combustion System

Capacity : 30 ton/ shift



## Waste Water Treatment System

Capacity : 2 ton/ hour



## Acid Mist Purification System

Capacity : 40,000 m<sup>3</sup>/ hour



## Chemical Storage Area

Capacity : 40 ton



# COLD BENDING AND CUTTING

- Cold bending capacity:
  - 1x 6" – 8"
  - 1x 2" – 6"
  - 1x 1/8" – 2.5" (CNC)
  - 2x 1/8" – 2"
  - 1x 1/2" – 1½"
- Round bending capacity:
  - 1x 1" – 8"
- HGG plasma cutting machine:
  - 1x 2" – 24"
- Cutting & Beveling machine:
  - 1x 2" – 16"



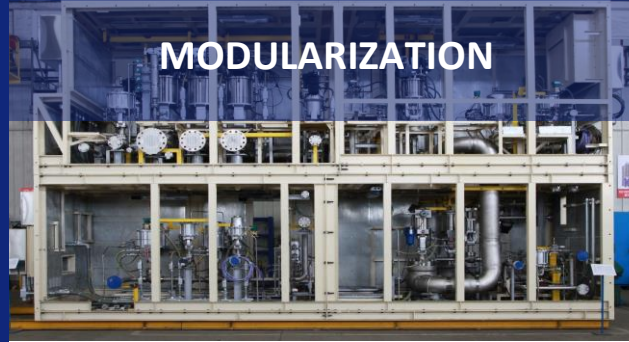


# BUSINESS LINES & CUSTOMERS

PIPE SPOOLS



MODULARIZATION



ENERGY SERVICES



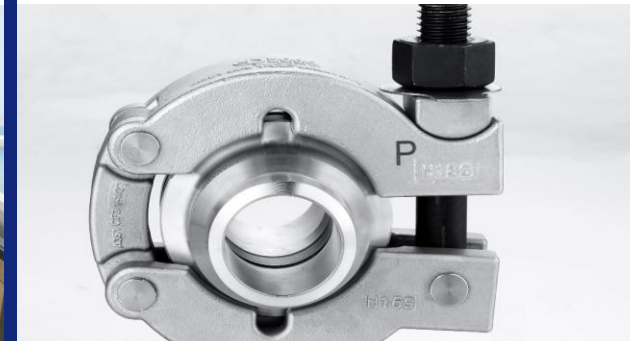
QUICK RELEASE FLANGES



哈电集团  
HARBIN ELECTRIC CORPORATION



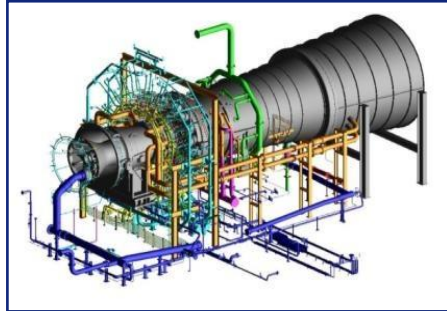
**TOSHIBA**





# PIPE SPOOLS

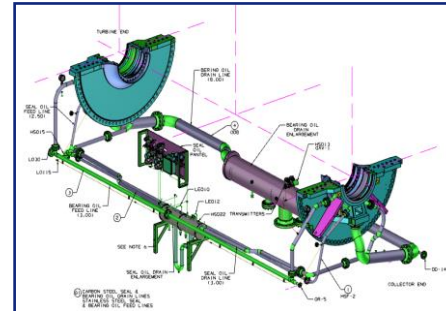
## GAS TURBINE PIPING



## MAIN STEAM PIPING



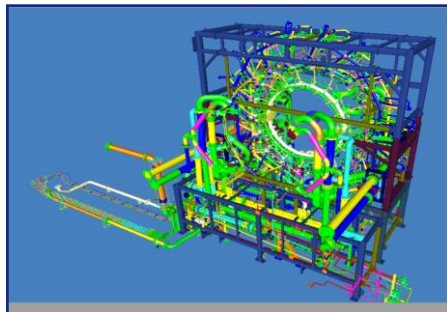
## GENERATOR PIPING



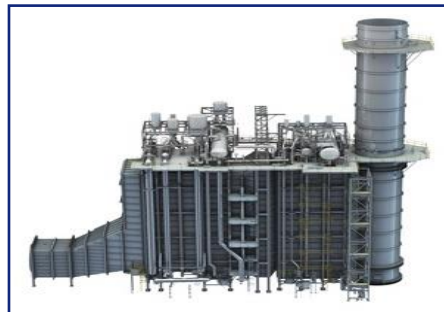
## SKID PIPING



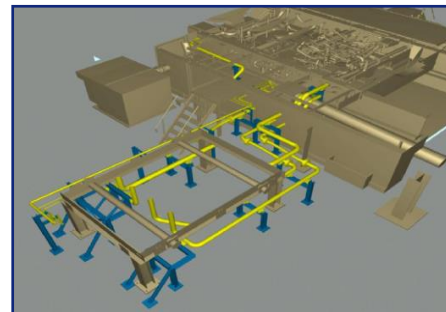
## MODULARIZED PIPING



## HRSG PIPING



## BOP PIPING



## LNG PIPING





# FABRICATION RANGE

**LARGE BORE  
UP TO 70"**



**SMALL &  
MIDDLE  
BORE**



**P91 & P92  
MATERIALS  
PIPE WALL  
THICKNESS UP  
TO 60 MM**





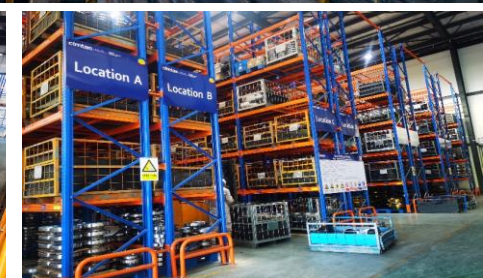
# MODULARIZATION

## Assembly & Supplementary Bays:

## Process skids & Modules



- **SCOPE:**
- Detail design and engineering
- Procurement and/or prefabrication of:
  - Structural steel and supports
  - Piping systems
  - Manual valves
  - Electrical and instrumentation
  - Insulation and heat tracing
- Assembly of:
  - Mechanical systems
  - E & I systems
  - Tubing
  - Insulation and heat tracing
- Complete unit testing:
  - Hydrostatic/pneumatic
  - Functional
  - Electrical
- Trial assembly
- Packaging and delivery





# SKID/MODULE PROJECTS



GE A160 SKID



MPW M701F5 FUEL GAS MODULE



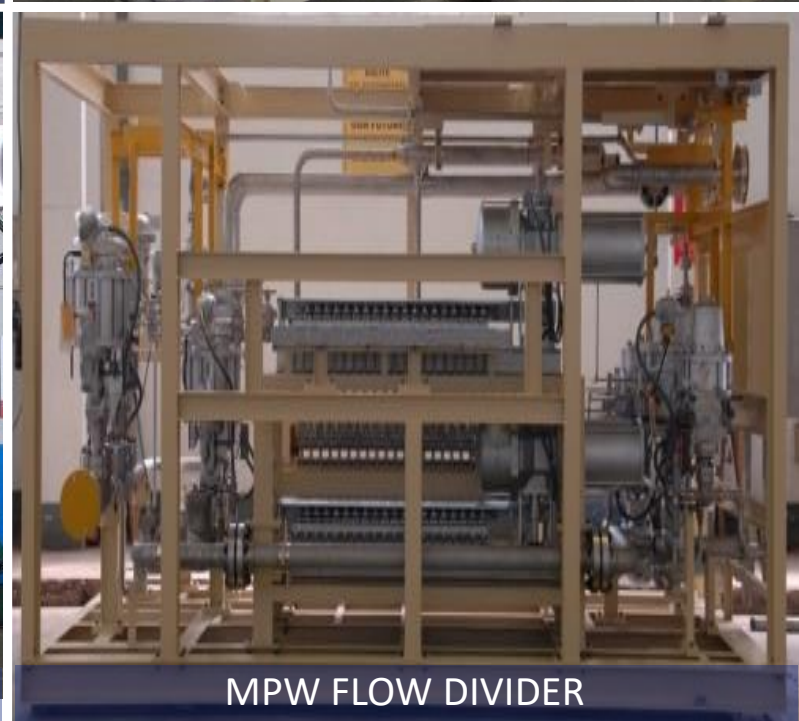
MPW FUEL GAS SKIDS



MPW PURGE AIR SKID



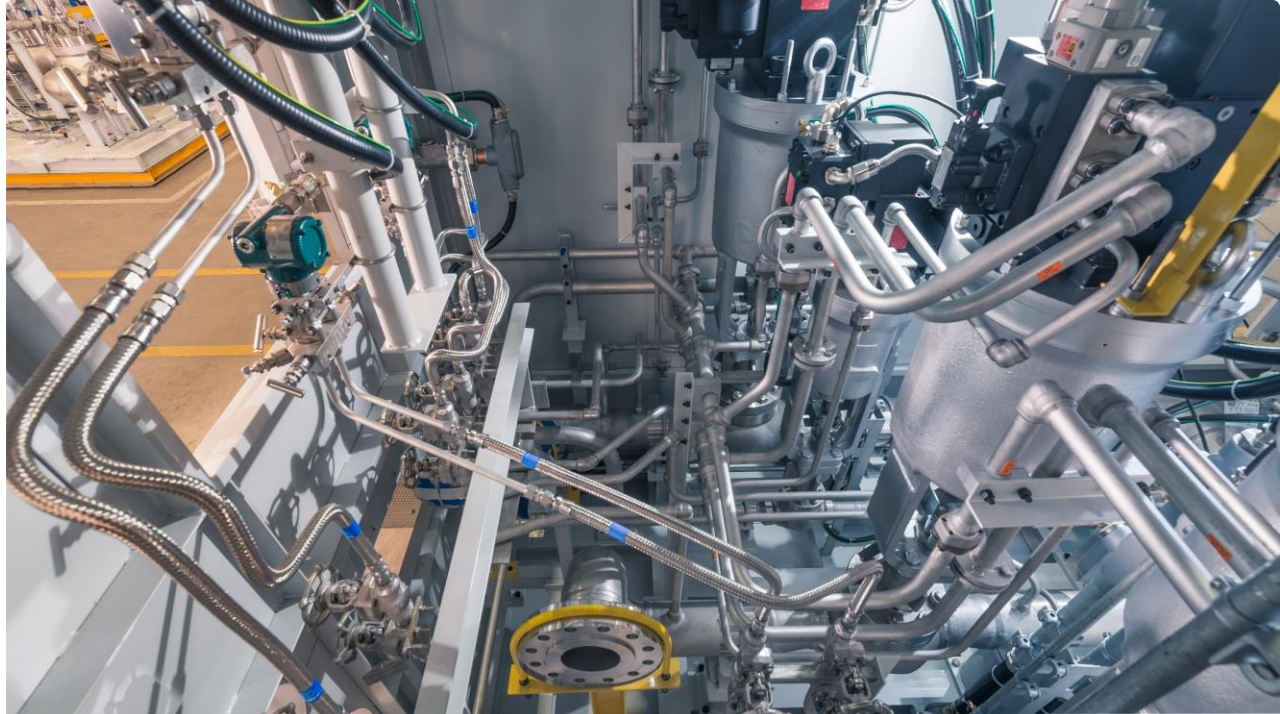
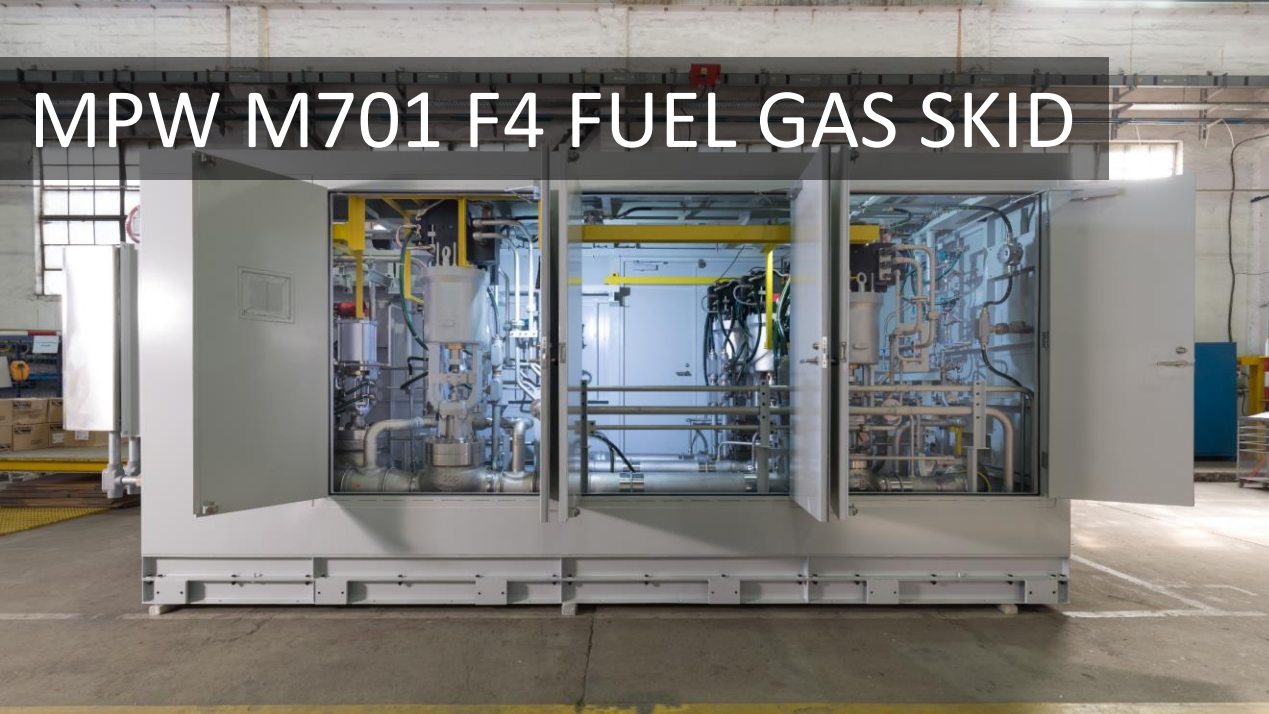
MPW 501J FUEL GAS & PURGE AIR ASSEMBLIES



MPW FLOW DIVIDER



# MPW M701 F4 FUEL GAS SKID





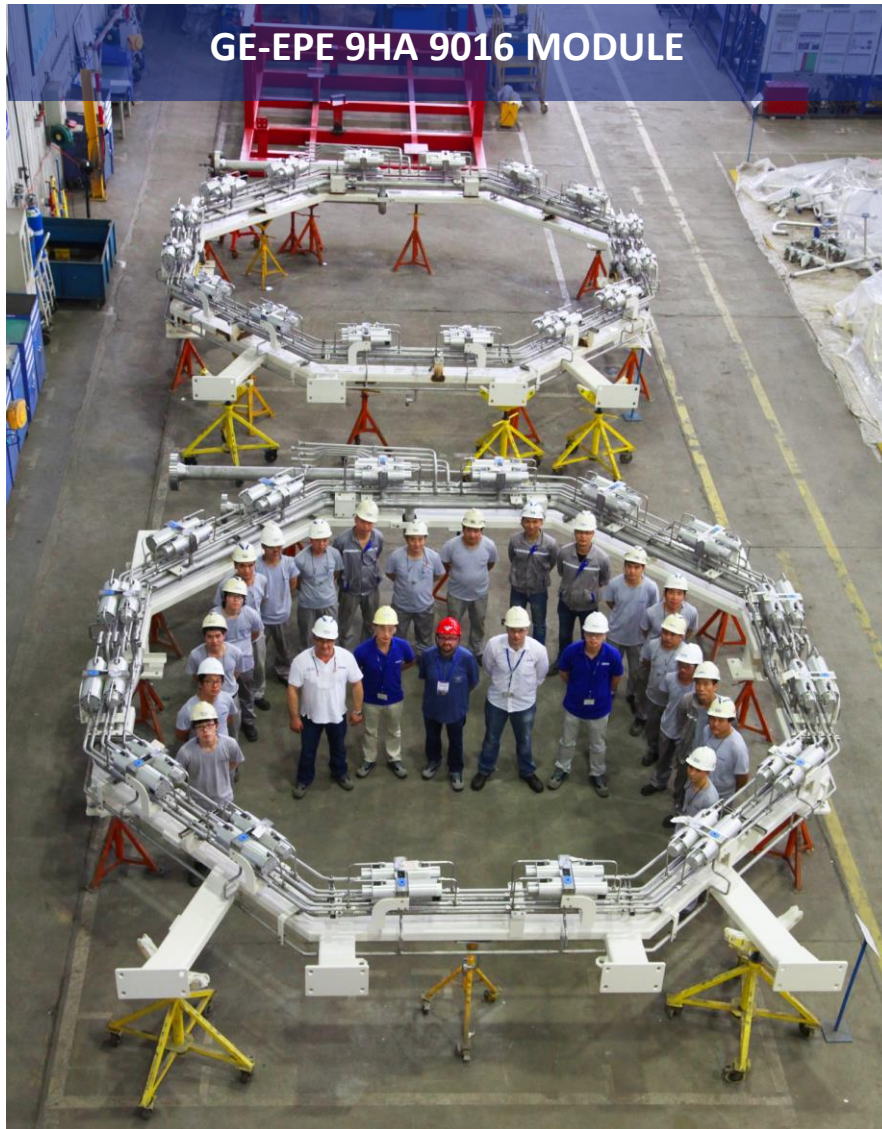
# PHARMACEUTICAL SKIDS





# MODULES

GE-EPE 9HA 9016 MODULE



GE 9FA MSD PIPING MODULES



Weight: 35 ton

Dimension: 9.2 x 4.8 x 8.1 m

30.1 x 15.7 x 26.5 ft



# SELECTED JIG PROJECTS



Mitsubishi Power- America M501J JIG

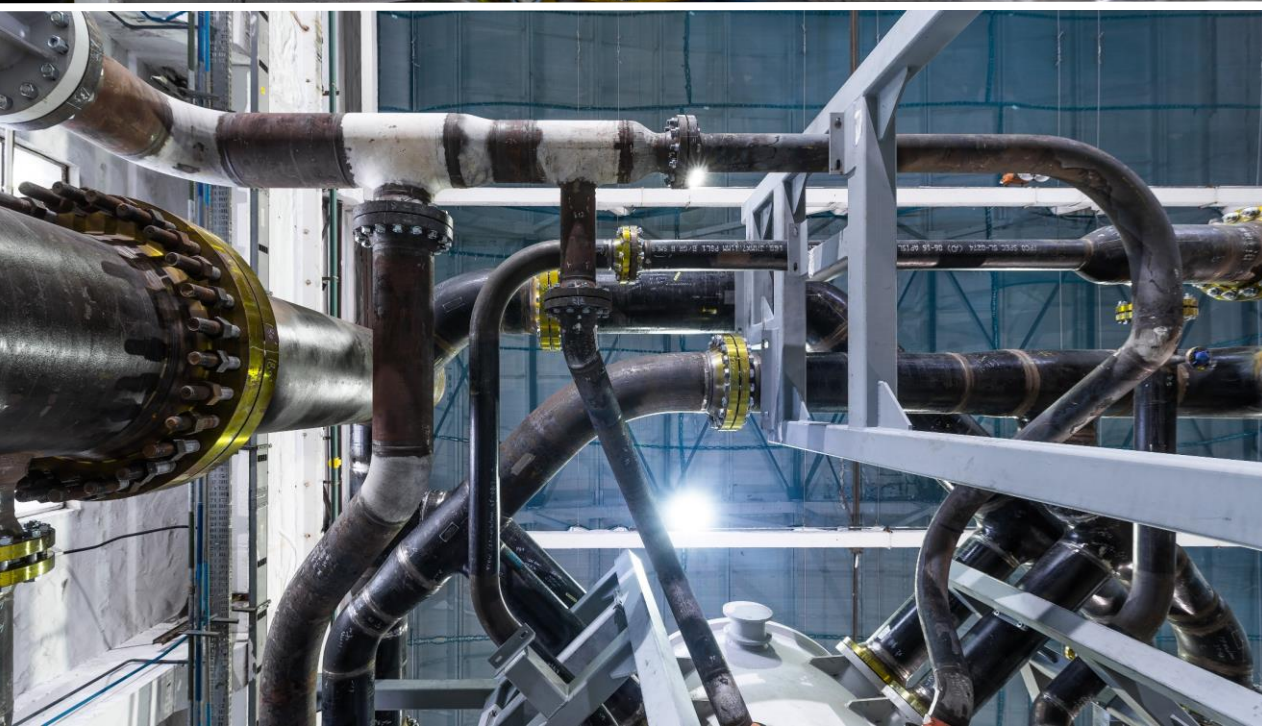


Mitsubishi Power M701F4 JIG





# BLEED AIR JIG





# ENERGY SERVICES



- Supply of piping and auxiliary components for maintenance, repair & overhaul operations
- Short cycle times; expedited solutions
- Agility, flexibility, adaptability at project coordination, procurement and production planning





# QRF PRODUCT

## Over view

- **4 different components**
  - ✓ 4 - bolted clamps
  - ✓ Single bolted clamps
  - ✓ Hubs
  - ✓ Seals
- **8 different sizes**
- **214 different part numbers**
- **9 customers**

## YLOCK quick release flange family offers various advantages versus conventional flanges:

- Quick installation
- Significant torque decreases by 93% in single-bolted and 75% in 4-bolted versions, compared to conventional flanges
- Mechanical sealing
- High pressure and temperature strength
- Various working conditions
- Low maintenance
- Less accessory requirement
- Lighter design

## Standards:

- ASME B31.1 & ASME B31.3
- European Pressure Equipment Directive (2014/68/EU)
- National Association of Corrosion Engineers (NACE Mr0175)

## Size:

- One Bolted Clamp:  $\frac{3}{4}$ " – 3" (DN20 - DN80)
- Four Bolted Clamp:  $2\frac{1}{2}$ " – 4" (DN65 - DN100)



# MATERIALS

CS & LTCS	FINE GRAIN STEEL	L.A. STEELS	ALLOY STEELS	STAINLESS STEELS	NICKEL ALLOYS	SPECIAL ALLOYS
A234 WPB	16Mo3	SA335 P11	SA335 P5	A790 UNS31803 (duplex ss)	INCOLOY® Alloy 825	SB 862 UNS
A420 WPL 6	15Mo3	SA335 P22	SA335 P9	SA312 S31254	INCONEL® Nickel-	R50400
SA105		SA335 P23	SA335 P91	SA312 TP304 / 304L	Chromium Alloy 625	(Titanium)
A672 GrC70		13CrMo4-5	SA335 P92	SA312 TP304H	ALLOY 20 UNS	Aluminum
API 5L B		10CrMo9-10	X10CrMoVNb9-1	SA312 TP316 / 316L	N08020	
API 5L X65		15NiCuMoNb 5-6-4	X10CrWMoVNb9-2	SA312 TP316H	INCOLOY® Alloy	
P235GH			WB36	TP316Ti	800HT®	
P250GH				SA312 TP317 / 317L	MONEL® Nickel-	
P265GH				SA312 TP321	Copper Alloy 400	
P355 NH				SA312 TP321H	INCONEL Alloy C-276	
SA 350 LF1&LF2				SA312 TP347 / 347H		
SA106 GrB&GrC				6Mo Super Austenitic		
SA333 Gr6				CVN down to @ -196C		
SA516 Gr60&Gr70				X5CrNi18-10,		
SA671 CC60				X5CrNiMoTi19-11-2		
CVN down to @ -58 C				X6CrNiMoTi17-12-2		
				X6CrNiTi18-10		



# WELDING

Automated and manual welding CS, SS, LA

5,950 WPS and 2,350 PQR in library

SAW/UP, SMAW/E 111, GTAW/TIG 141, GMAW/MIG&MAG,

FCAW , GTAW/TIG Hotwire, GTAW/Automatic Feeder, STT ,

Hard facing





# ENGINEERING

**Cimtas Group** provides various engineering and design services including conceptual, basic and detail engineering for the industries including but not limited to power, oil and gas, chemical, offshore and refinery.



## SCOPE

- Plant Design Engineering
- Process Design
- Power and Process Piping
- OEM Piping
- Pressure Vessels & Storage Tanks
- Heat Exchanger
- Civil & Structural Design
- Gas Processing Equipment
- BOP Equipment
- Technical Procurement



## SOFTWARE

### 3D Design & Modeling

PDMS/Aveva  
MDS/Aveva  
PDMS LMI/Aveva  
Smart Plant 3D & PID  
PDS  
Leica CloudWorx  
Tekla Structures  
Solidworks / Catia v5  
Visual Vessel Design

### Stress & Structural Analysis

Rohr2  
Caesar II  
Compress  
Ansys  
PVElite  
Abaqus  
ETABS  
SAP 2000  
STAAD Pro

### Process & Flow Analysis

ChemCad  
Flow Consultant  
Sinetz  
Thermoflow

### Drafting

AutoCAD  
Spoolgen  
Isogen  
Microstation  
SmartsSketch

### I & C – Electrical

ETAP  
Dialux  
ePlan



# TRACEABILITY

# IT & S TOOLS

- 100% traceability, including raw material heat number transfer on each spool
- 100% data collection with Line Inspection Summary Lists (LISLs)

**NOTES:**

1. GENERAL MACHINING APPLIED PRACTICES ARE PER J4849000.
2. PIPELINE APPLIED PRACTICES ARE PER J5143700.
3. PIPELINE WELDING PER PER J4849000, FILLER METAL PER J5143700 AND WELD DOCUMENT.
4. CLEAN AND PAINT PER MAL ITEM 0108.
5. PROVIDE MATERIAL AND PROCESS TRACEABILITY PER J5846000 - GROUP 2 ONLY!

06/07/2017 - 10:42:47  
KZHO

**cintas**

LISL (LINE INSPECTION SUMMARY LIST)

Project: GE ES 2016 VOLUME PO 42301210-2		Report No:	
Customer's P.O. No: 42301210-2	Customer's Supplier Code: E58020-102	Assembly Dwg. No: 118789400002	Hydro Test
Project No: 18189-415	Lot No:	Reference No:	Hydro Test Pressure(bar):
M.L.#: 820	Rev.: 0	Spool Tag No: 118789400001	Spool Weight: 11.33
Code: PCD	Serial Number: E58020	Manifest No:	Spool Weight: 11.33
Category: SEP			

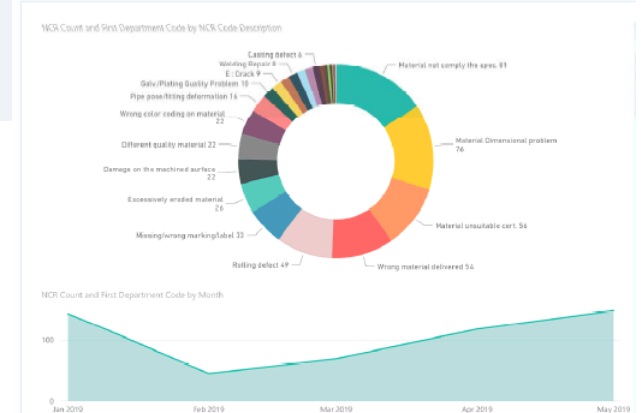
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NA	1.1	8088170	0	304L SS PIPE 1" OD X 1/2" THK X 10' L	201808080001	201808080001	19-008	0.00									
NA	1.2	8088170	0	304L SS PIPE 1" OD X 1/2" THK X 10' L	201808080002	201808080002	19-008	0.00									
NA	2	8088170	0	304L SS PIPE 1" OD X 1/2" THK X 10' L	201808080003	201808080003	19-008	0.00									

Mat	Point Code	Checked By / Date	Final Control And Shipment	Visual Inspection: Done Satisfactory
NA	201AW	1/2016-08-21	1/2016	1/2016
Checked by (Client)	Checked by (Client)	Checked by (Client)	Checked by (Client)	Checked by (Client)
Date: 2016-08-21	Date: 2016-08-21	Date: 2016-08-21	Date: 2016-08-21	Date: 2016-08-21
Sign: JAAKO	Sign: LAAKO	Sign: LAAKO	Sign: LAAKO	Sign: LAAKO

This LISL has been automatically generated by the Cintas ERP System

## CNBO Runs JDE Oracle for ERP

## Supplier Performance, NCR by Category



Power BI



# WELDING TRAINING CENTER

- Practical & theoretical trainings for the qualification & update of:
  - SAW, GTAW, SMAW, GMAW, FCAW, GTAW-Automatic Feeder, STT/RMD
- VT trainings for all welders
- 34 theoretical training



# QUALITY CONTROL

- On-line Documentation and Traceability
- In-house Level I, II, III NDT Personnel as per SNT-TC-1a , ASNT, PCN, ISO 9712, AQSIG, etc.
- Testing Capabilities : RT, UT, MPT, LPT Movable OES PMI / Handheld XRF PMI
- Pressure (Hydro / Pneumatic) Testing with Grip Tight Plugs
- Marking, Identification and Traceability Control
- Receiving Inspection
- In-process and Dimension Control
- Fit -up and Hardness Control
- Parent & Weld Material Verification
- Blasting & Painting Control
- Inside Cleanliness Control

# SELECTED CUSTOMER AWARDS



2003  
Excellence in Delivery  
General Electric



2015  
Excellence in Fulfillment  
General Electric



2016  
Excellence in Customer Centricity  
General Electric



2018  
Excellence in Performance  
Mitsubishi Power



2020  
Certificate of Appreciation  
Mitsubishi Power - Japan



2020  
Excellence in Performance  
Mitsubishi Power

2021  
Global Best Partner of Year  
Certificate of Appreciation  
Mitsubishi Power



# 3D MEASUREMENTS

Faro Vantage-E technology allows Cintas Ningbo's large welded products to achieve less than 0.1mm tolerance, deliver quick, simple and precise measuring solutions.





# CERTIFICATES



EN 9100: 2016 (AS9100D)  
(ISO 9001:2015)



EN ISO 1090-2

EN ISO 1090 - 2 (EXC 3)

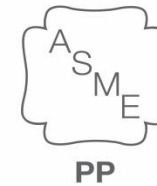


EN ISO 3834-2

EN ISO 3834 - 2



ASME 'S', 'PP' and 'U' stamps



National Board 'NB' and 'R'



PED 2014/68/EU Module H



TS (GC1)



CSA B51 (TSSA)



ISO 27001



# WORLDWIDE DELIVERIES



# PROCUREMENT

- Pipes
- Pipe supports
- Fittings
- Flanges
- Valves
- Instruments
- Equipment
- Process equipment
- Enclosures

**120 APPROVED SUPPLIERS**

**3,600 DIFFERENT TYPE OF MATERIALS**

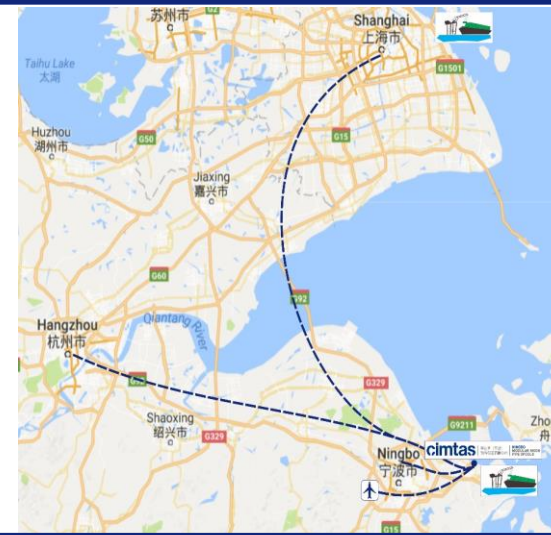
**95% CHINA (LOCAL) SOURCING**

# PACKING



# LOCATION

- Ocean Vessel Duration:
- USA West Coast: 3 weeks
  - USA East Coast: 5 weeks
  - Saudi Arabia: 5 weeks
  - Korea: 2 days
  - Japan: 2 days
  - Indonesia, Malaysia: 2 weeks
  - Singapore, Thailand: 1 week





- Asakai Meeting
- Team Organization
- Quality at Source
- Value Stream Map
- Kaizen
- KPI
- SMED
- 5S



## SAFETY

- Zero accident & Corporate HSE program
- Lesson learned
- 5S program
- Risk analysis
- Environmentally and social responsible

## RELIABILITY

- 19 years of manufacturing experience in China
- Excellent assembly and modularization track record
- Full know-how transfer & back-up from Cimtas Turkey
- 100+ active suppliers, with 19 years experience of supplier development in China
- Business ethics: Code of conduct

## WORLD CLASS QUALITY

- High quality welded fabrication, with 5,950 WPS
- Excellent assembly and modularization service
- Proven quality assurance system
- Skilled and dynamic personnel
- Multiple customer certificates

## EFFICIENCY

- New state of the art facility with high tech machinery
- Lean initiatives, Kaizen workshops
- Advanced information technology
- Worldwide, on-time delivery at short cycles with least total cost
- Multiple award winner with proven flexibility



**cimtas** | NINGBO  
MODULAR SKIDS  
PIPE SPOOLS



[www.cimtasnbo.com](http://www.cimtasnbo.com)

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