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# Metallurgical and Inspection Requirements for Cast Galvanic Anodes for Offshore Applications



## ABSTRACT

*Reaffirmed 2019. Defines minimum chemical quality and inspection standards for cast sacrificial anodes for offshore applications. The objectives of the standard are (1) to standardize an industry-wide practice that can be used by consultants, manufacturers, and users to define the physical requirements of anodes and (2) to be specific enough to assist the inspection authority in its task of confirming that anodes comply with the physical requirements.*

## KEYWORDS

*Cracking, defects. fabrication, identification marking, inserts, inspection, sacrificial anodes, welding, TG 454.*



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# Foreword

The purpose of this standard practice is to set minimum physical quality and inspection standards for cast galvanic anodes for offshore applications. The objectives of this standard are to standardize an industry-wide practice that can be used by consultants, manufacturers, and users to define the physical requirements of cast galvanic anodes, and to be specific enough to assist the inspection authority in its task of confirming that cast galvanic anodes comply with the physical requirements.

This standard is complementary to NACE SP0176,[1] DNVGL[(1)]-RP-B401[2] and EN[(2)] 12495.[3]

This standard was originally prepared in 1987 by NACE Task Group T-7L-5, a component of Unit Committee T-7L on Cathodic Protection, in association with a working group of the Corrosion Control Engineering Joint Venture (CCEJV), sponsored by NACE International and the Institute of Corrosion Science and Technology (ICorr).[(3)] It was reaffirmed in 1990, revised in 1999, and reaffirmed in 2006 by Specific Technology Group (STG) 30, "Oil and Gas Production—Cathodic Protection." It was revised in 2014 and reaffirmed (with editorial changes) in 2019 by Task Group (TG) 454, "Metallurgical and Inspection Requirements for Cast Galvanic Anodes for Offshore Applications," which is administered by STG 30, "Oil and Gas Production—Cathodic Protection." This standard is issued by NACE under the auspices of STG 30.

In NACE standards, the terms ***shall, must, should,*** and ***may*** are used in accordance with the definitions of these terms in the NACE Publications Style Manual. The terms ***shall*** and ***must*** are used to state a requirement, and are considered mandatory. The term ***should*** is used to state something good and is recommended, but is not considered mandatory. The term ***may*** is used to state something considered optional.

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[(2)] European Committee for Standardization (CEN), rue de Stassart 36, B-1050 Brussels, Belgium.
[(3)] Institute of Corrosion Science and Technology (ICorr), P.O. Box 253, Leighton Buzzard, Bedfordshire LU7 IFG United Kingdom.

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