

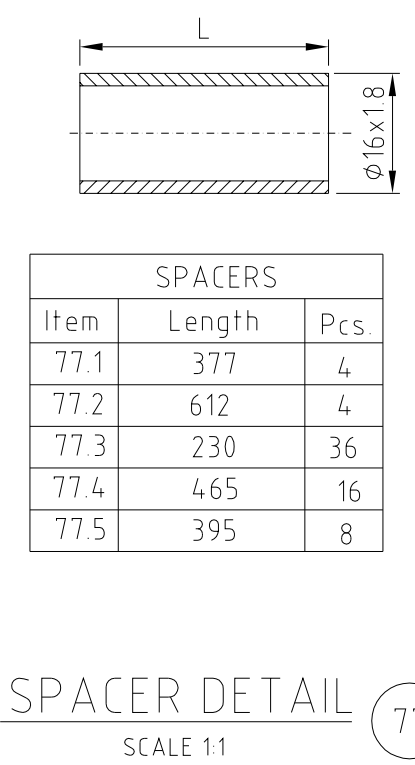
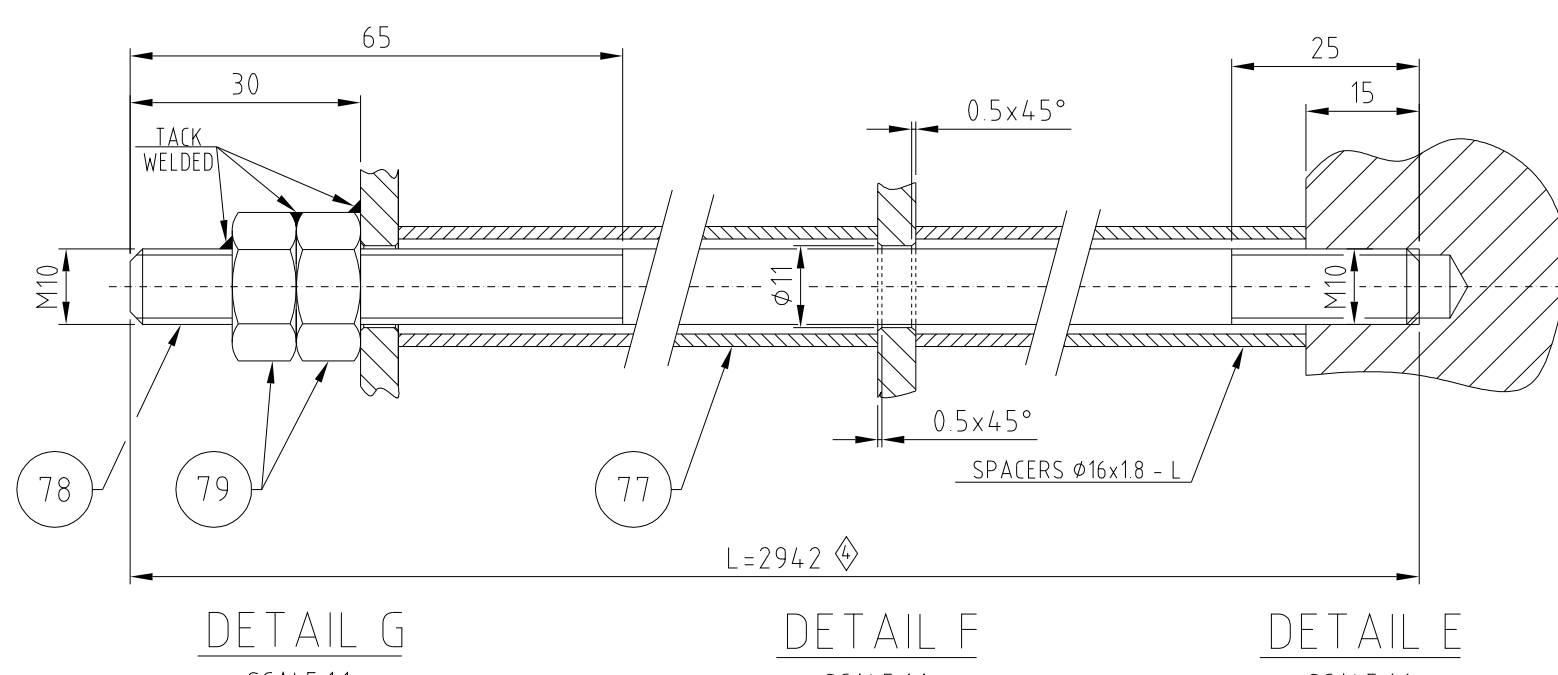
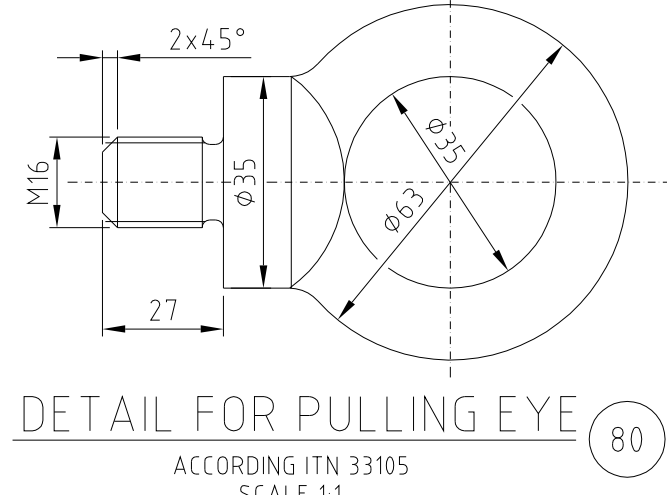
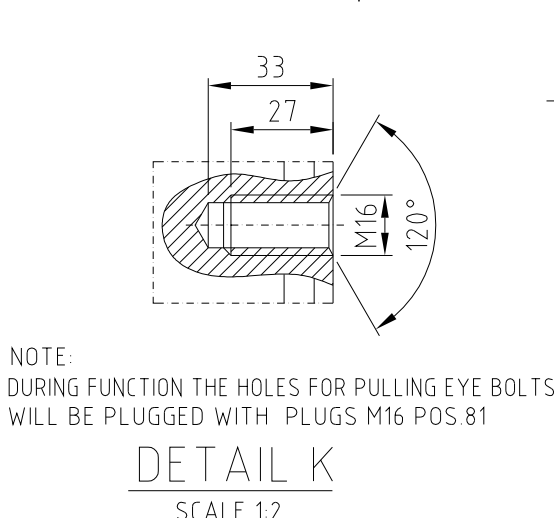
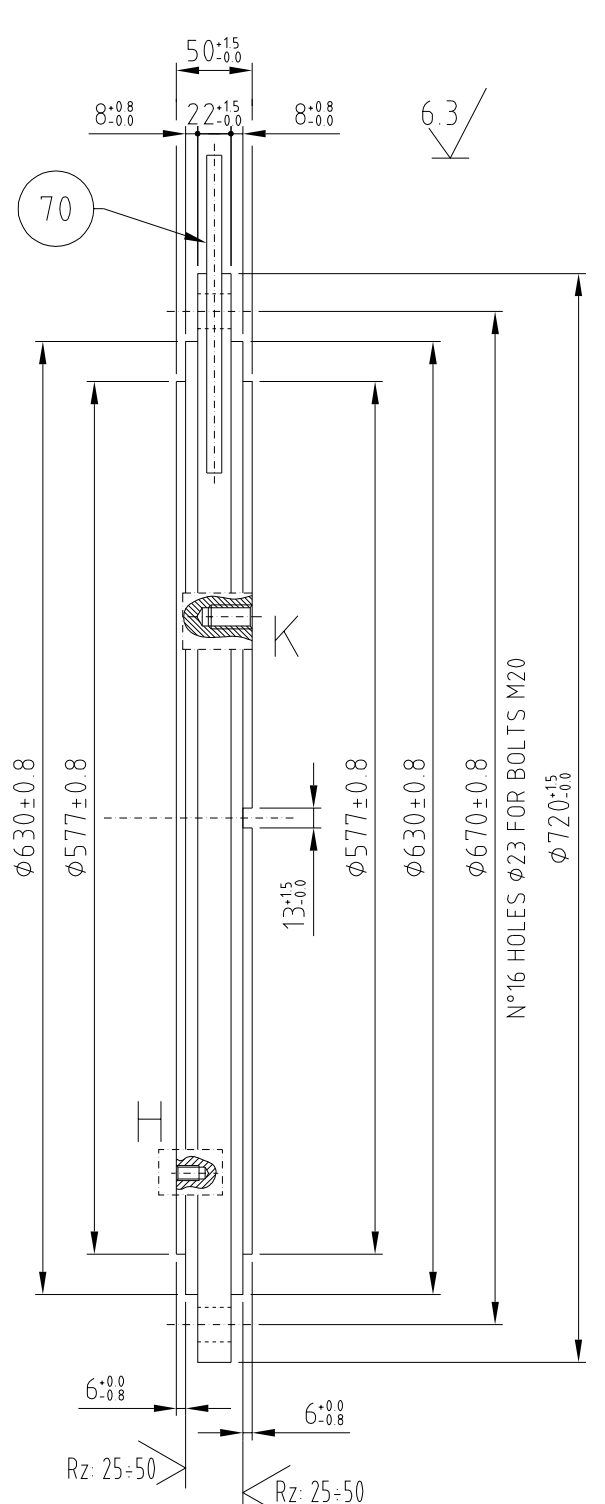
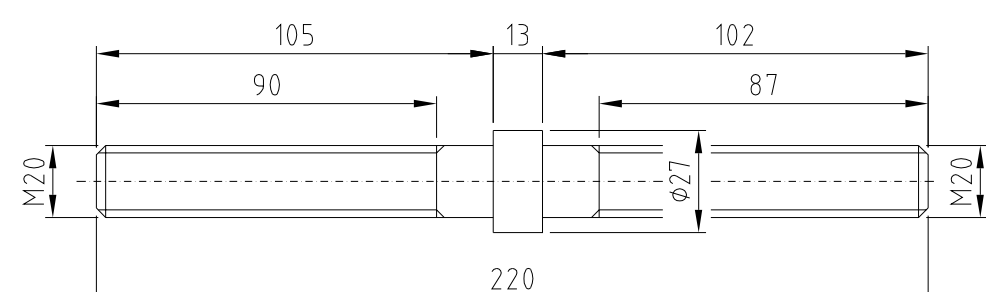
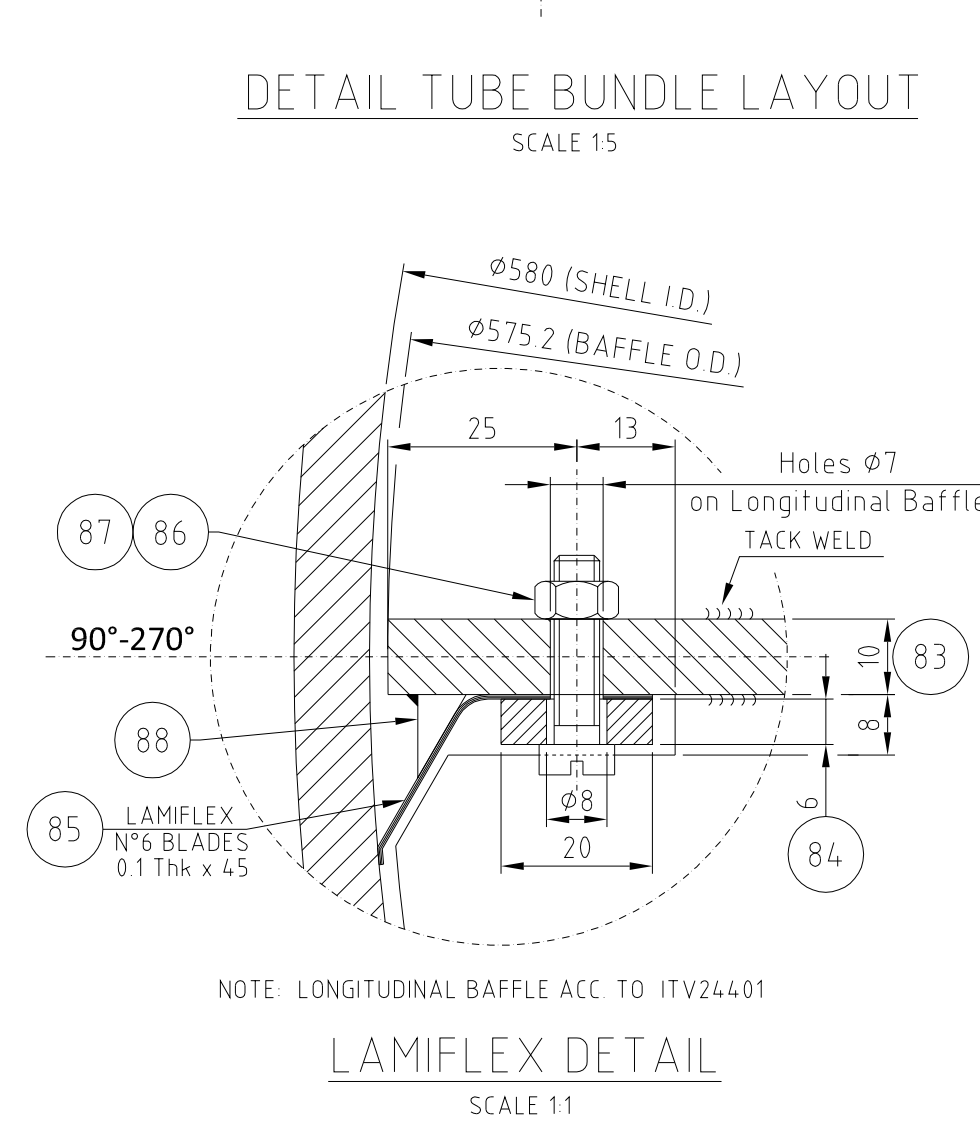
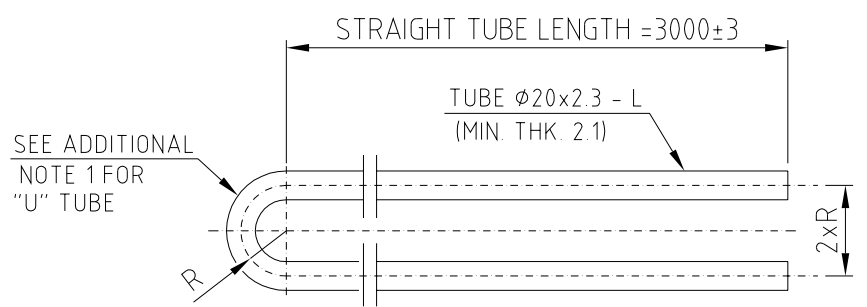
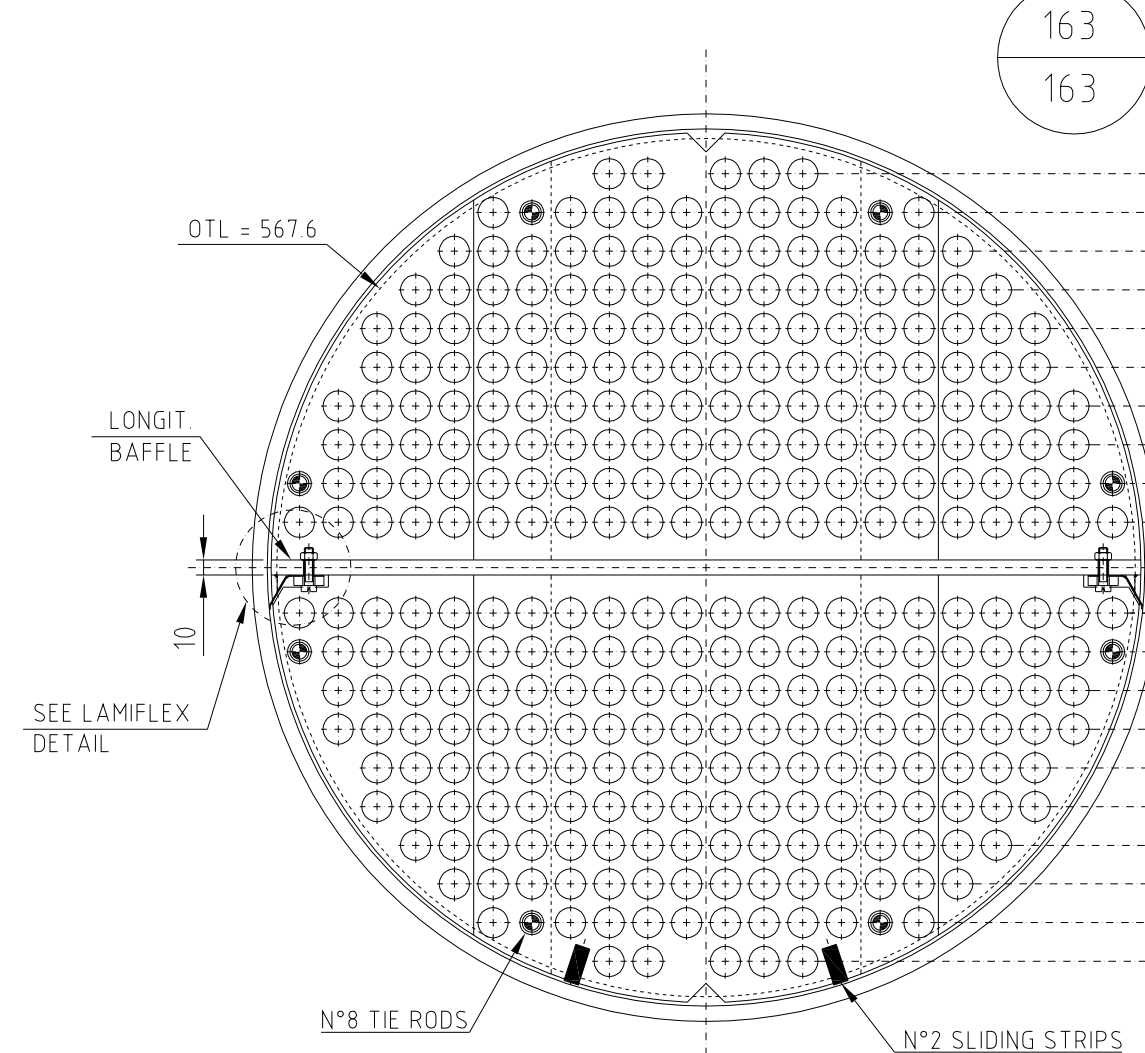




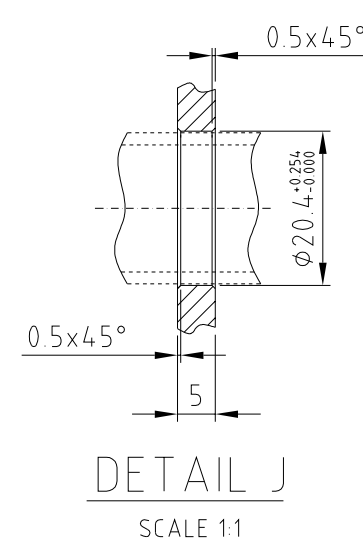
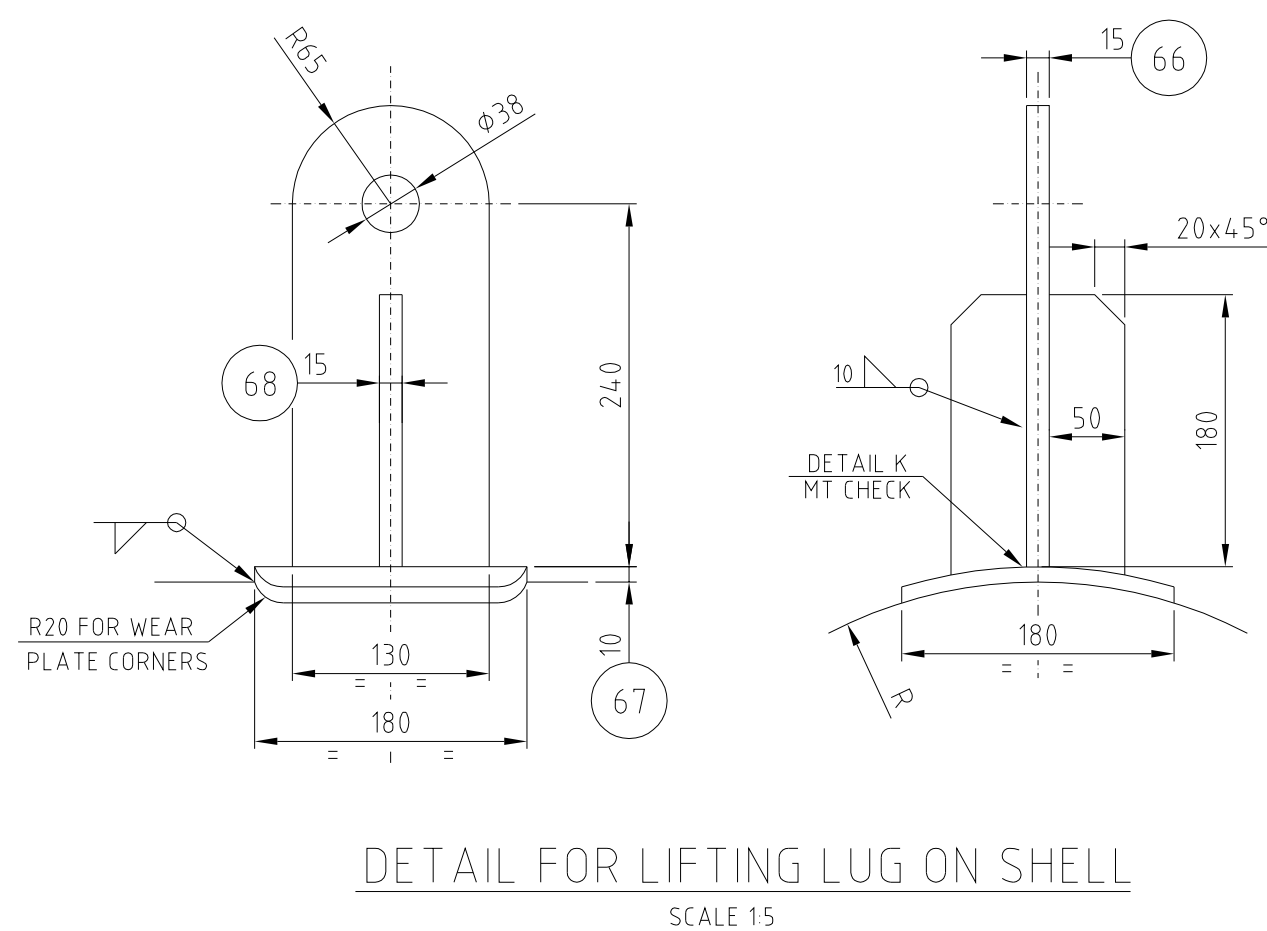
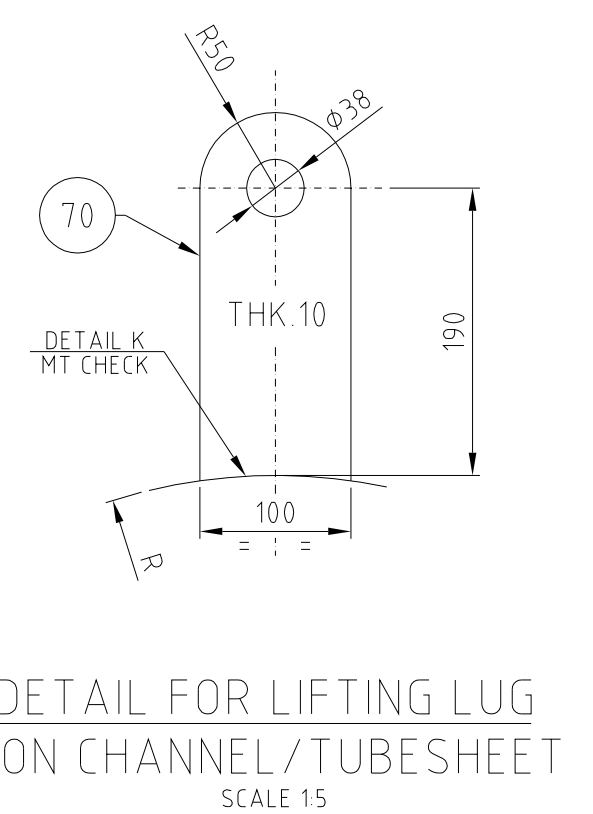
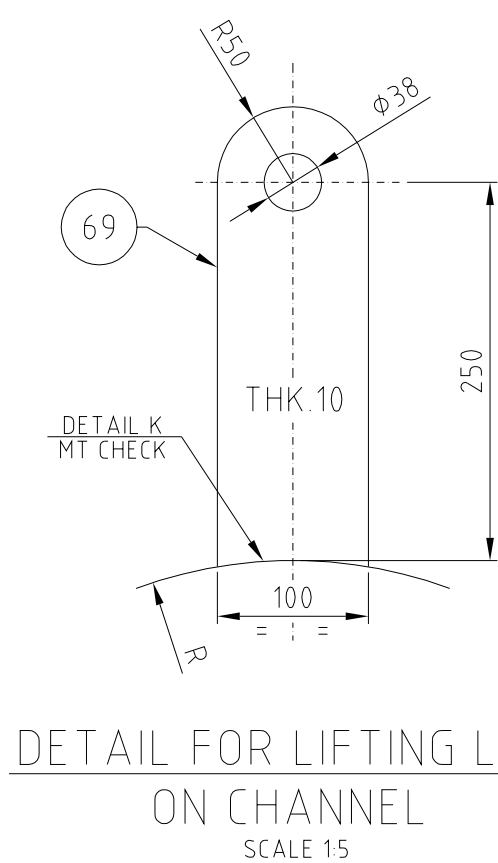
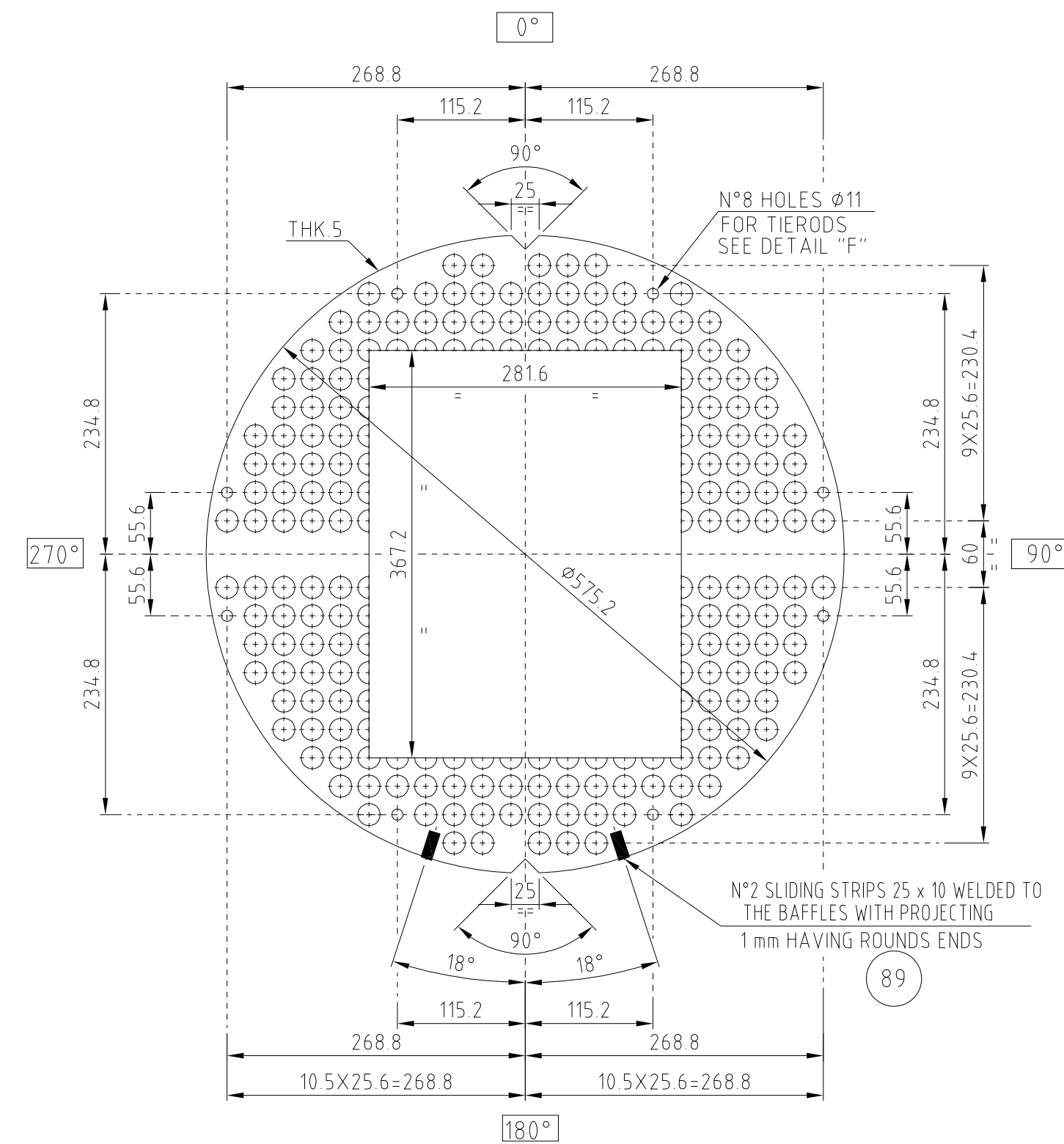
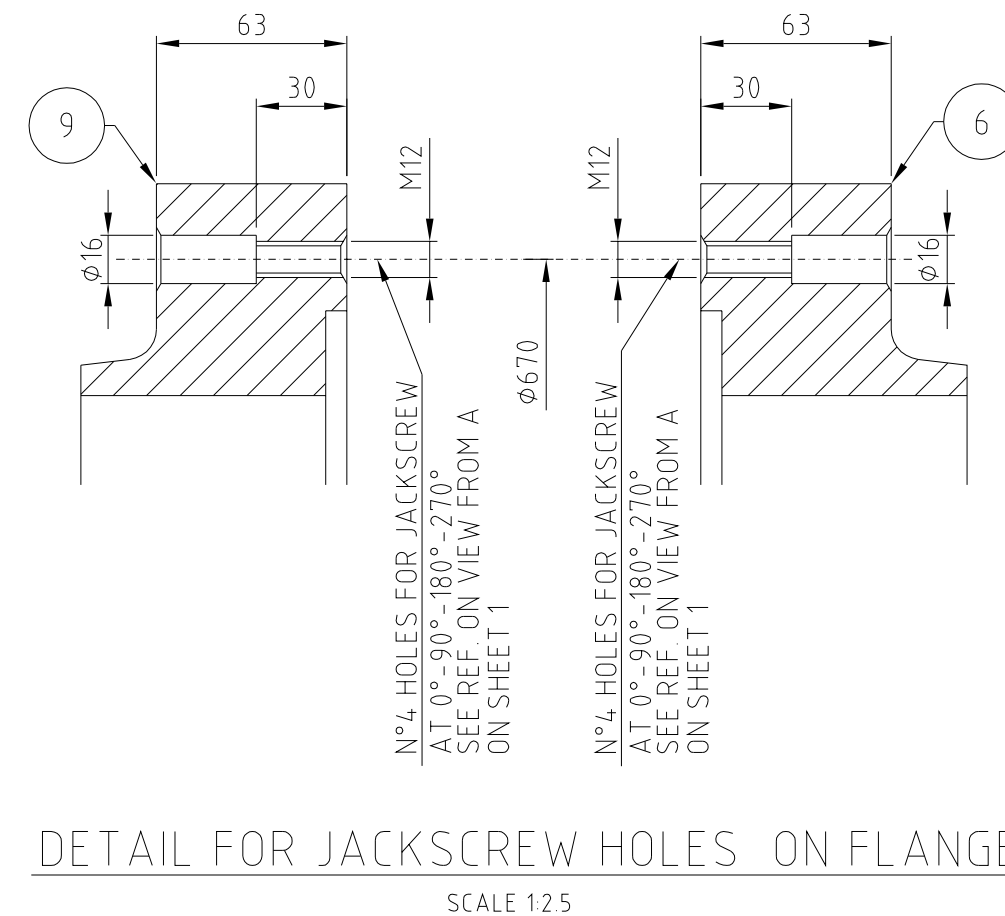
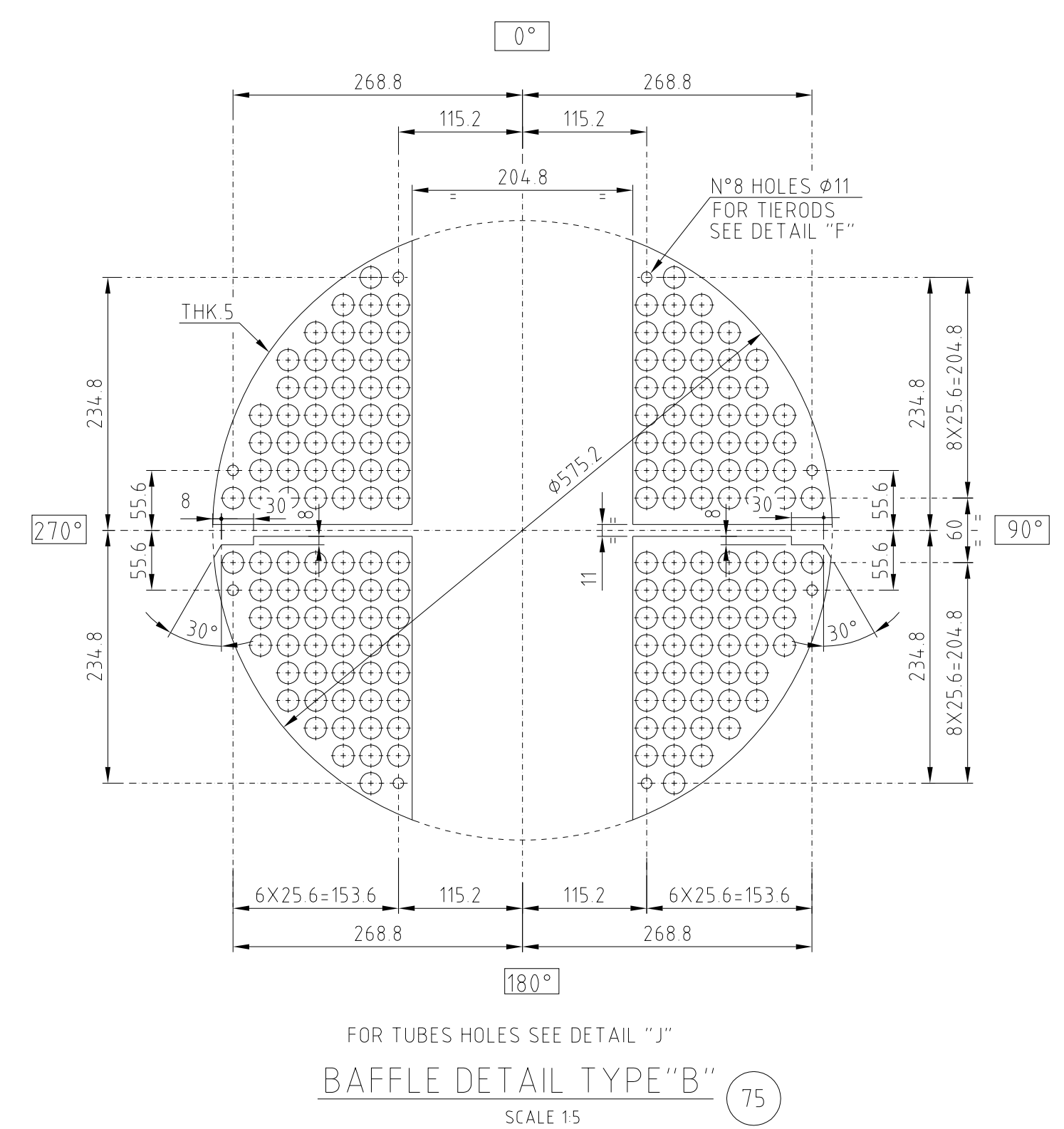
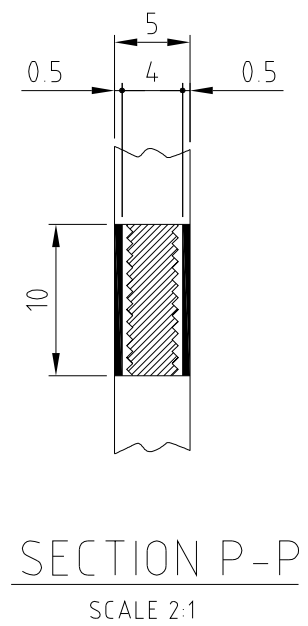
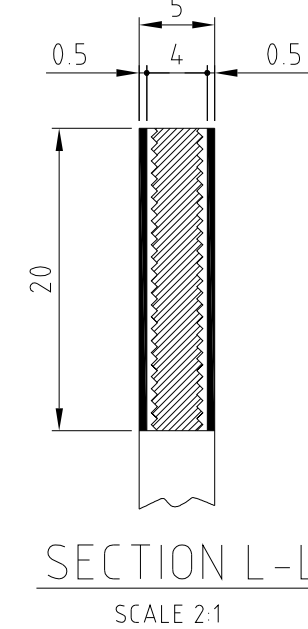
PROJECT NAME: Propane Propylene Fraction (PPF) Splitter		SUBSUPPLIER INFORMATION:		CLIENT PROJECT NO.: OLP01011	
CLIENT NAME: ORLEN Lietuva		LOCATION: Juodeikiai, Lithuania		GE INTERNAL PROJECT NO.: ICP-000037	
REPLACES		SUPPLIER/CONTRACTOR IDENT NO:		CLIENT PROJECT DOC. NO.: OLP-01011-DP-M-GA900	
		TITLE: REGENERATION GAS FEE EFFLUENT HEAT EXCHANGER TK-441 CONSTRUCTION DRAWING		DOCUMENT CODE: SG 8080084	
REVISION DESCRIPTION ISSUED AS BUILT		REVISION DATE 12-Nov-18		APPROVED Electronically Stored CHECKED Electronically Stored DRAWN P.E.S.	
		SCALE 1/10		REPLACES/DERIVED BY N/A	
		1st EXECUTION 16-Feb-18		ORIGINAL JOB 6400216	
				SIZE 1	
				LANGUAGE A	
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4	12.11.2018	P.E.S.	A. Schiavello	G. Arena	ISSUED AS BUILD
3	19.04.2018	P.E.S.	A. Schiavello	G. Arena	REVISED CLIENT PROJECT DOC. NO.
2	11.04.2018	P.E.S.	A. Schiavello	G. Arena	SHEET NOT REVISED
1	12.03.2018	P.E.S.	A. Schiavello	G. Arena	ISSUED FOR APPROVAL
0	16.02.2018	P.E.S.	A. Schiavello	G. Arena	ISSUE FOR 3D MODEL DESIGN
REV.	DATE	CREATED BY	CHECKED BY	APPROVED BY	DESCRIPTION
PROPRIETARY AND CONFIDENTIAL					
PROJECT NAME Propane Propylene Fraction (PPF) Splitter			SUBSUPPLIER INFORMATION		
CLIENT NAME ORLEN Lietuva		LOCATION Juodeikiai, Lithuania	CLIENT PROJECT NO. OLP01011		
			GE INTERNAL PROJECT NO. ICP-000037		
REPLACES		SUPPLIER/CONTRACTOR IDENT NO.		CLIENT PROJECT DOC. NO. OLP-01011-DP-M-GA900	
		TITLE REGENERATION GAS FEEF EFFLUENT HEAT EXCHANGER TK-441 CONSTRUCTION DRAWING			DOCUMENT CODE SG 8080084
REVISION DESCRIPTION ISSUED AS BUILD					REVISION 4
					PAGE MARKER N/A
					ORIGINAL JOB 6400216
					SHEET 1
					SECURITY CODE N/A
					LANGUAGE A
					SHEET 2 of 4
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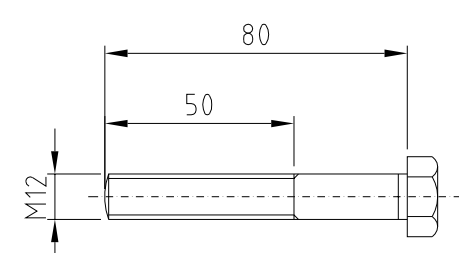




FOR TUBES HOLES SEE DETAIL "J"

BAFFLE DETAIL TYPE "C"

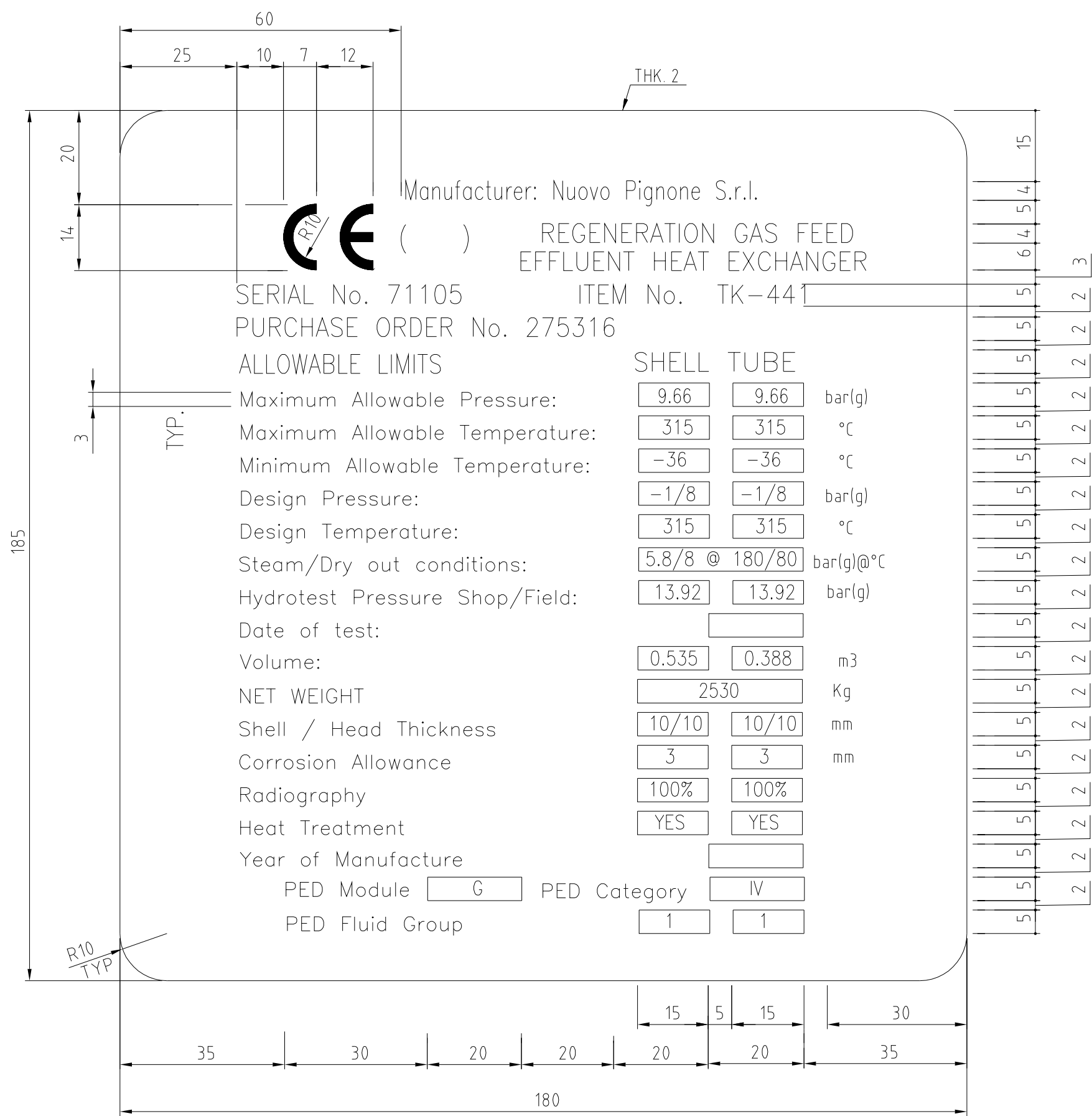
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76



4	12.11.2018	P.E.S.	A. Schiavello	G. Arena	ISSUED AS BUILT
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2	11.04.2018	P.E.S.	A. Schiavello	G. Arena	SHEET NOT REVISED
1	12.03.2018	P.E.S.	A. Schiavello	G. Arena	ISSUED FOR APPROVAL
0	16.02.2018	P.E.S.	A. Schiavello	G. Arena	ISSUE FOR 3D MODEL DESIGN
REV.	DATE	CREATED BY	CHECKED BY	APPROVED BY	DESCRIPTION
<div>PROPRIETARY AND CONFIDENTIAL</div> <div><div></div></div>					
PROJECT NAME Propane Propylene Fraction (PPF) Splitter			SUBSUPPLIER INFORMATION		CLIENT PROJECT NO: OLP01011
CLIENT NAME ORLEN Lietuva		LOCATION Juodeikiai, Lithuania			GE INTERNAL PROJECT NO: ICP-000037
REPLACES			SUPPLIER/CONTRACTOR IDENT NO:		CLIENT PROJECT DOC NO: OLP-01011-DP-M-GA900
<div><div><div>BAKER HUGHES</div><div>GE company</div></div><div></div></div>		TITLE: REGENERATION GAS FEED EFFLUENT HEAT EXCHANGER TK-4-L1		DOCUMENT CODE SG 80080084	REVISION 4
REVISION DESCRIPTION ISSUED AS BUILT		<div><div>PAGE MARKER N/A</div><div>ORIGINAL JOB 6400216</div><div>SIZE 1</div><div>LANGUAGE A</div></div>			
<div><div>© 2018 Novus Petrochem Technology S.r.l., a Baker Hughes, a GE Company, Ltd. ("BHEC") company. The information contained in this document is company confidential and proprietary property of BHEC or its affiliates. It is to be used only for the benefits of BHEC and may not be distributed, transacted, reproduced, altered or used for any purpose without the express written consent of BHEC.</div></div>					
					SHEET 3 OF 4





Manufacturer: Nuovo Pignone S.r.l.  
REGENERATION GAS FEED  
EFFLUENT HEAT EXCHANGER  
SERIAL No. 71105 ITEM No. TK-44  
PURCHASE ORDER No. 275316

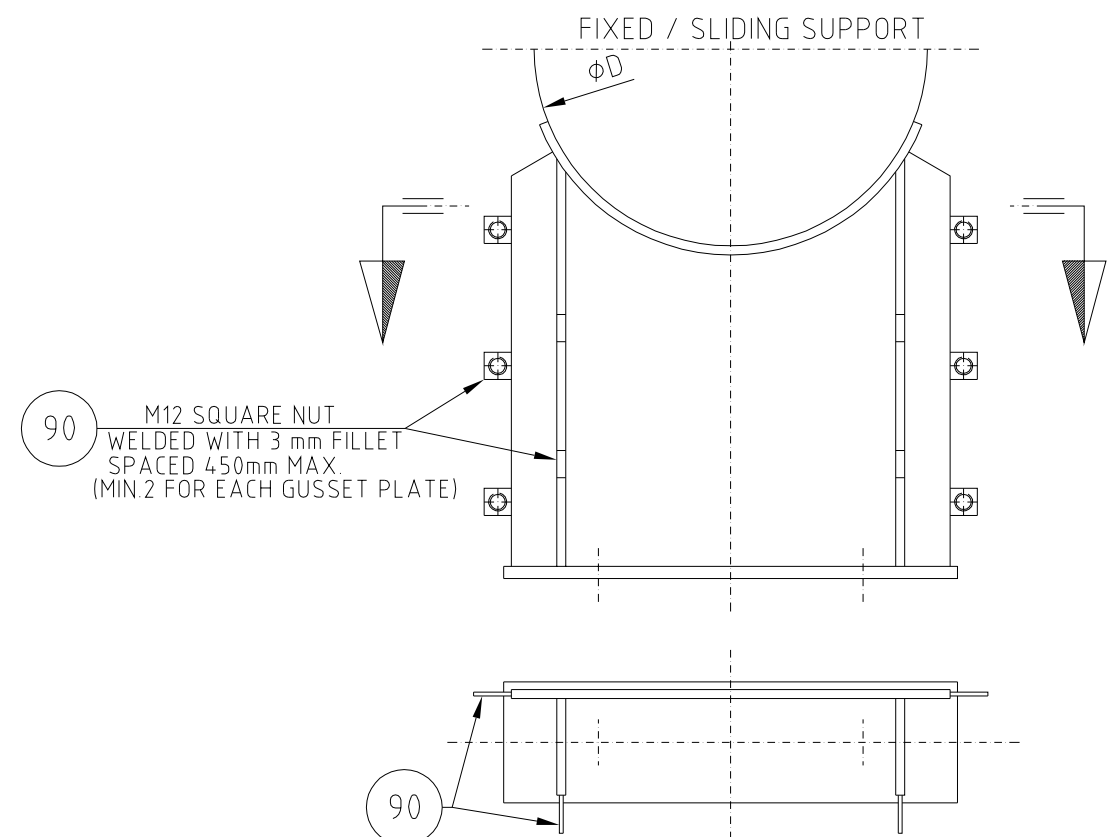
ALLOWABLE LIMITS		SHELL TUBE		
Maximum Allowable Pressure:	9.66	9.66	bar(g)	
Maximum Allowable Temperature:	315	315	°C	
Minimum Allowable Temperature:	-36	-36	°C	
Design Pressure:	-1/8	-1/8	bar(g)	
Design Temperature:	315	315	°C	
Steam/Dry out conditions:	5.8/8 @ 180/80		bar(g)/°C	
Hydrotest Pressure Shop/Field:	13.92	13.92	bar(g)	
Date of test:				
Volume:	0.535	0.388	m <sup>3</sup>	
NET WEIGHT		2530	Kg	
Shell / Head Thickness	10/10	10/10	mm	
Corrosion Allowance	3	3	mm	
Radiography	100%	100%		
Heat Treatment	YES	YES		
Year of Manufacture				
PED Module	G	PED Category	IV	
PED Fluid Group	1	1		

PED NAMEPLATE DETAIL  
SCALE 1:1



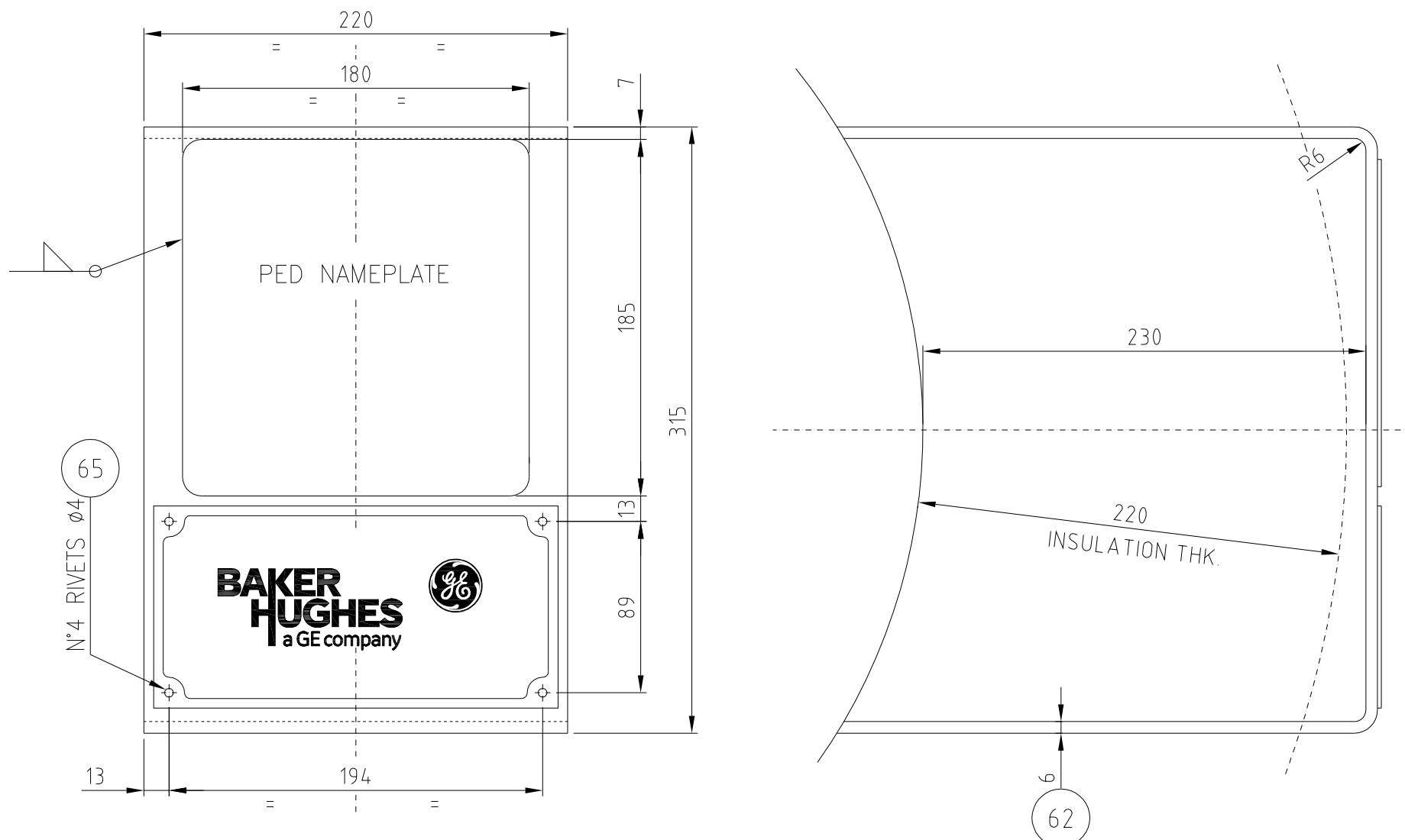
SEE ITN0000010/1  
- "Version BF" for colors of text, plate and frame of nameplate.

BHGGE-LOGO NAMEPLATE DETAIL  
SCALE 1:2



NOTE: FIREPROOFING IS NOT IN BHGE SCOPE OF SUPPLY

DETAIL FOR INSULATED VESSEL FIREPROOFING  
SCALE 1:10

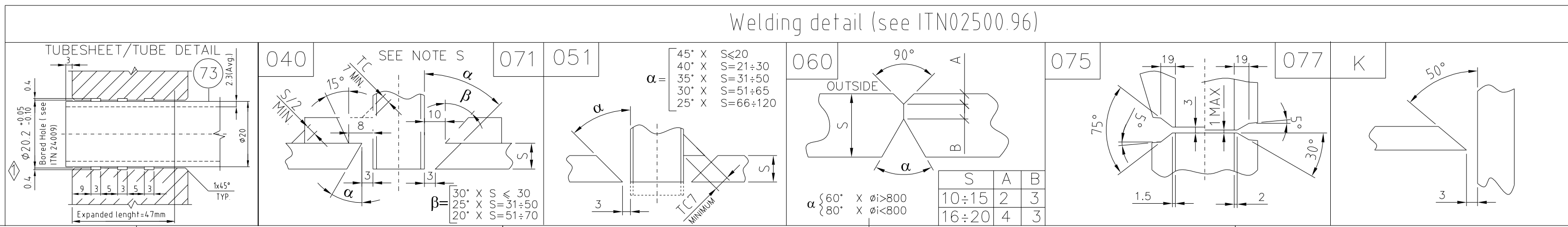


NAMEPLATE SUPPORT DETAIL  
SCALE 1:3

EARTH LUG DETAIL  
SCALE 1:2

	94				
	93	INSULATION SUPPORT ON CHANNEL	2	PL THK = 6 L= 310 x 220	P275NH/NL2 EN10028-3
	92	INSULATION SUPPORT	8	PL THK = 6 L= 220 x 220	P275NH/NL2 EN10028-3
	91	INSULATION SUPPORT ON SHELL	2	PL THK = 6 L= 2990 x 220	P275NH/NL2 EN10028-3
	90	M12 SQUARE NUT	24	SEE DETAIL SHT 4/4	CS
	89	SLIDING STRIPS	2	PL THK = 10 L= 25 x 2922	P275NH/NL2 EN10028-3
	88	GUIDE PLATE	2	ACC. TO ITV24401	P275NH/NL2 EN10028-3
	87	NUTS	32	M6 ITN34050/3	AISI 304
	86	SCREWS	32	M6 L=25 ITN32101	AISI 304
	85	LAMIFLEX	2	45x2530 - 0.6 mm	SS 18/8
	84	FLAT BAR	2	PL THK = 6 L= 20 x 2470	P275NH/NL2 EN10028-3
	83	LONGITUDINAL BAFFLE	1	PL THK = 10 L= 2530 x 590	P275NH/NL2 EN10028-3
REV	POS	DENOMINATION	No	DIMENSIONS	MATERIAL

Welding detail (see ITN02500.96)



ADDITIONAL NOTES	
M02) HEADS POS 6 & 7 SHALL BE COLD FORMED AND NORMALIZED	
1) M.A.W.P. - SHELL SIDE - IS LIMITED BY FLANGE RATING	
M.A.W.P. - TUBE SIDE - IS LIMITED BY FLANGE RATING	
2) MATERIALS SHALL RESPECT THE ADDITIONAL REQUESTS OF PED	
3) THE MANUFACTURER SHALL PROVIDE ALL NECESSARY DOCUMENTATION FOR PED CERTIFICATION, INCLUDING BUT NOT LIMITED TO THE FOLLOWING (IF APPLICABLE):	
DOCUMENTS	
PED Category	Quality Control Plan
Pressure vessel general description	Material list
Risk analysis	PMA (Particular Material Appraisal)
Check list ESR (Essential Safety Requirement)	Welding specifications (WPS and WPQR)
Design drawings	Welding map
Nameplate drawing	User manual
Applicable Codes list	Integrity procedure (for modifications only)
Design calculation and assumptions	
4) NOZZLE 10" AND SMALLER SHALL BE SEAMLESS PIPE	
5) REINFORCING AND WEAR PLATE PROVIDED WITH ONE TEST HOLE TAPPED M10. THE WELD OF EACH PAD SHALL BE TESTED AT 0.34 BARG WITH AIR AND SOAP SOLUTION BEFORE POST WELD HEAT TREATMENT AND IN THE PRESENCE OF THE "OL" INSPECTOR AFTER THE TEST. THE HOLE WILL BE FILLED WITH CORROSION INHIBITING GREASE.	
6) IF THE PAD IS FABRICATED IN TWO PARTS THE WELD WILL BE ORIENTATED IN CIRCUMFERENTIAL DIRECTION	
7) EACH PLATE OR FORGING SHALL BE LEGIBLY STAMPED OR STENCILED SHOWING GRADE NO. AND PLATE OR FORGING NO. WHEN METAL STAMPING IS DONE IT SHALL BE PREFERABLY BE ON THE LONG EDGE OF EACH COMPONENT AS IT LEAVES THE MILL. METAL STAMPING ON ROLLED SURFACES SHALL BE DONE WITH A "LOW STRESS" STAMP	
8) MATERIAL SUBJECT TO PWHT SHALL BE PURCHASE WITH MILL TEST REPORTS INDICATING HEAT TREATING TIME SUFFICIENT TO ALLOW AT LEAST ONE FULL PWHT CYCLE IN ADDITION TO ALL PLANNED PWHT	
9) ALL WELDS FOR NOZZLE AND MAINWAYS ATTACHING TO SHELL AND HEADS WILL BE FULL PENETRATION THROUGH THE VESSEL WALL	
10) A TEMPERATURE OF VESSEL AND TESTING MEDIUM DURING HYDROSTATIC TESTS SHALL BE IN ACC. TO EN13445/PED	
11) THE TEST PRESSURE SHALL BE MAINTAINED FOR A PERIOD OF AT LEAST ONE HALF HOUR PER 25MM OF THICKNESS, BUT NOT LESS THEN ONE HOUR. THE THICKNESS OF THE HEAD OR SHELL, WHICHEVER IS GREATER, SHALL BE USED TO DETERMINE THE LENGTH OF TEST PERIOD	
12) ALL WELDS OF PRESSURIZED PARTS OF VESSEL FOR FLUID GROUP 1 ACC. TO PED SHALL BE TESTED VOLUMETRIC METHODS (RADIOGRAPHIC OR ULTRASONIC TESTING)	
13) THE LEVEL OF WELDING JOINT QUALITY ASSESSMENT SHALL BE NOT LESS THAN B GRADE ACC. TO EN587	
14) THE EXTERNAL SURFACE OF THE EQUIPMENT SHALL BE PRIMER PAINTED IN GREY ("RAL7035") ITEM SURFACE SHALL BE CLEANED AND PAINTED IN ACCORDANCE WITH THE PAINT SPECIFICATION AND OL-TR-CR-011 REQUIREMENTS	
15) DURING THE TRANSPORTATION, THE ITEM SHALL BE PROPERLY PROTECTED AGAINST CORROSION IN ACC. WITH OL SPECIFICATION OL-TR-MVR-001	
17) TUBESHEET, FLANGES ARE SUBJECT TO 100% ULTRASONIC EXAMINATION FOR DISCONTINUITY FLAWS	
21) THE REQUIREMENTS OF ISO 15156 APPLY TO VESSELS WHICH INTENDED FOR USE IN H2S CONTAINING ENVIRONMENT	
22) STEEL PLATES IN WET H2S SERVICE ARE SUBJECT TO 100% ULTRASONIC TESTING FOR DISCONTINUITY FLAWS AS PER REQUIREMENT OF EN10160 CLASSES S1 & E1	
23) IN WET H2S SERVICE MATERIALS SHALL BE SUPPLIED IN NORMALIZED CONDITION	
24) FOR SOUR OR WET HYDROGEN SULFIDE SERVICE, THE MINIMUM POST WELD HEAT TREATMENT REQUIREMENTS FOR CARBON STEEL CONSTRUCTION SHALL BE IN ACC. TO NACE SP0472 THE MINIMUM HOLD TIME SHALL BE IN ACCORDANCE WITH THE PRESSURE DESIGN CODE, OR 1 HOUR, WHICHEVER IS GREATER	
25) PRESSURE PARTS AND TEST IN ACCORDANCE WITH THE REQUIREMENTS OF NACE MR0175/ISO 15156-2 ANNEX A-2	
26) COMPOSITION RESTRICTIONS FOR MATERIALS ASTM A 350 LF2 CL1 C: 0.23 %; P: 0.035 %; S: 0.025 %	
27) BHGE DOCUMENTS ARE NOT IN CONFLICT WITH "CLIENT APPLICABLE SPECIFICATIONS"	
28) PAINTING ACCORDING TO SG 8194.005 EQUAL TO OL-TR-CR-011 SURFACE PREPARATION SSPC SP-10 25-40 µm PRIMER PAINTING SYSTEM 1B THICKNESS 75-60 µm IN ONE COAT FINISH N.A. (APPLIED IN FIELD)	

82	JACKSCREW	8	M12 L= 80 ITN32211	42CrMo4 EN10269	
81	PLUGS	2	M16 L= 30 ITN32500	ASTM A 193 B8	
80	PULLING EYE BOLT	2	M16 ITN33105	C15 UNI 8550	
79	NUTS	16	M10 UNI 374.0	42CrMo4 EN10269	
78	TIERODS	8	ø10 L = 294.2	ASTM A 36	
77	SPACERS	68	øe= 16 THK 18 L = SEE TABLE	ASTM/ASME A/SA 334 Gr 6	
76	BAFFLE TYPE "C"	1	PL THK = 5 L= 590 x 590 -SEE SHT 3/4	P275NH/NL2 EN10028-3	
75	BAFFLE TYPE "B"	5	PL THK = 5 L= 590 x 590 -SEE SHT 3/4	P275NH/NL2 EN10028-3	
74	BAFFLE TYPE "A"	5	PL THK = 5 L= 590 x 590 -SEE SHT 2/4	P275NH/NL2 EN10028-3	
73	TUBES	1630	øe= 20 THK 2.3 Avg thk L = SEE TABLE	ASTM/ASME A/SA 334 Gr 6	C
72	TUBESHEET	1	øe= 720 THK = 50	P285DH EN10222-4	C
71	PASS PARTITION	1	PL THK = 10 L= 590x 680	P275NH/NL2 EN10028-3	C
70	LIFTING LUGS CHANNEL/TUBESHEET	3	PL THK = 10 L= 250 x 110	P275NH/NL2 EN10028-3	C
69	LIFTING LUGS CHANNEL	1	PL THK = 10 L= 310 x 110	P275NH/NL2 EN10028-3	C
68	RIBS FOR LIFTING LUGS	4	PL THK = 15 L= 60 x 200	P275NH/NL2 EN10028-3	
67	WEAR PLATE	2	PL THK = 10 L= 200 x 200	P275NH/NL2 EN10028-3	C
66	LIFTING LUGS ON SHELL	2	PL THK = 15 L= 320 x 140	P275NH/NL2 EN10028-3	
65	RIVETS	4	ø4 x 20 UNI 136	AISI 304	
64	PED NAMEPLATE	1	SEE DETAIL SHEET 4	AISI 304	
63	BHGE LOGO NAMEPLATE	1	SEE DETAIL SHEET 4	ANODIZED ALUMINIUM	
62	NAMEPLATE SUPPORT	1	SEE DETAIL SHEET 4	P275NH/NL2 EN10028-3	
61	EARTHING LUG	2	PL THK = 10 L= 90 x 90	AISI 304	
60	BASE PLATE	2	PL THK = 16 L= 170 x 610	P275NH/NL2 EN10028-3	
59	WEAR PLATE	2	PL THK = 12 L= 200 x 750	P275NH/NL2 EN10028-3	C
58	GUSSET PLATE	4	PL THK = 12 L= 140 x 680	P275NH/NL2 EN10028-3	
57	WEB PLATE	2	PL THK = 12 L= 710 x 590	P275NH/NL2 EN10028-3	
56					
55					
54					
53					
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51					
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49					
48					
47					
46	REINFORCING PAD N4	1	PL THK = 10 L= 300 x 300	P275NH/NL2 EN10028-3	C
45	NOZZLE N4	1	ø= 6" SCH80-XS L= 410	P275NL2 EN10216-3	C
44	FLANGE N4	1	ø= 6" WN 150HRF-R9 SCH80-XS	ASTM A 350 LF2 CL1	
43	REINFORCING PAD N3	1	PL THK = 10 L= 300 x 300	P275NH/NL2 EN10028-3	C
42	NOZZLE N3	1	ø= 6" SCH80-XS L= 410	P275NL2 EN10216-3	C
41	FLANGE N3	1	ø= 6" WN 150HRF-R9 SCH80-XS	ASTM A 350 LF2 CL1	C
40					
39					
38					
37					
36					
35					
34					
33					
32					
31					
30	RIBS V1	2	PL THK = 6 L= 40 x 310	P275NH/NL2 EN10028-3	
29	GASKET V1	1+2	ø= 1" 300# ITN84617 SPIRAL WOUND	GRAPHITE-AISI 316L	
28	NUTS V1	8+2	M16 m=D ITN34050/3	ASTM A 194 Gr 4.53	C
27	BOLTS V1	4+1	M16 L= 90 ITN33202-TYPE A	ASTM A 320 L7	C
26	BLIND FLANGE V1	1	ø= 1" B 300HRF-R9	ASTM A 350 LF2 CL1	C
25	FLANGE V1	1	ø= 1" LWN 300HRF-R9 L=320	ASTM A 350 LF2 CL1	C
24	RIBS D1	2	PL THK = 6 L= 40 x 310	P275NH/NL2 EN10028-3	
23	GASKET D1	1+2	ø= 1" 300# ITN84617 SPIRAL WOUND	GRAPHITE-AISI 316L	
22	NUTS D1	8+2	M16 m=D ITN34050/3	ASTM A 194 Gr 4.53	C
21	BOLTS D1	4+1	M16 L= 90 ITN33202-TYPE A	ASTM A 320 L7	C
20	BLIND FLANGE D1	1	ø= 1" B 300HRF-R9	ASTM A 350 LF2 CL1	C
19	FLANGE D1	1	ø= 1" LWN 300HRF-R9 L=320	ASTM A 350 LF2 CL1	C
18	REINFORCING PAD N2	1	PL THK = 10 L= 300 x 300	P275NH/NL2 EN10028-3	
17	NOZZLE N2	1	ø= 6" SCH80-XS L= 410	P275NL2 EN10216-3	C
16	FLANGE N2	1	ø= 6" WN 150HRF-R9 SCH80-XS	ASTM A 350 LF2 CL1	C
15	REINFORCING PAD N1	1	PL THK = 10 L= 300 x 300	P275NH/NL2 EN10028-3	
14	NOZZLE N1	1	ø= 6" SCH80-XS L= 410	P275NL2 EN10216-3	C
13	FLANGE N1	1	ø= 6" WN 150HRF-R9 SCH80-XS	ASTM A 350 LF2 CL1	C
12	NUTS	32+4	M20 m=D ITN34050/3	42CrMo4 EN10269	C
11	COLLAR STUD BOLTS	4+1	M20 L= 220 SEE DETAIL SHT. 2/4	42CrMo4 EN10269	C
10	BOLTS	12+1	M20 L= 220 ITN33202-TYPE A	42CrMo4 EN10269	C
9	FRONT SHELL FLANGE	1	øe= 720/ øi= 580 h= 88	P285DH EN10222-4	C
8	GASKET FRONT SHELL	1+2	ø630 / ø590 THK 5 - SEE DETAIL SHT. 3/4	KAMMPROFILE SS 316L + GRAPHITE	
7	GASKET FRONT CHANNEL	1+2	ø630 / ø590 THK 5 - SEE DETAIL SHT. 3/4	KAMMPROFILE SS 316L + GRAPHITE	
6	FRONT CHANNEL FLANGE	1	øe= 720/ øi= 580 h= 88	P285DH EN10222-4	C
5	ELL HEAD øi= 580 x 10 (min.thk)	1	PL THK = 12 L= 820 x 820	P275NH/NL2 EN10028-3	C
4	ELL HEAD øi= 580 x 10 (min.thk)	1	PL THK = 12 L= 820 x 820	P275NH/NL2 EN10028-3	C
3	SHELL	1	PL THK = 10 L= 1910 x 1600	P275NH/NL2 EN10028-3	C
2	SHELL	1	PL THK = 10 L= 1910 x 1530	P275NH/NL2 EN10028-3	C
1	FRONT CHANNEL	1	PL THK = 10 L= 1910 x 430	P275NH/NL2 EN10028-3	C
REV	POS	DENOMINATION	No	DIMENSIONS	MATERIAL

C= MATERIALS CERTIFICATE ACC. TO EN 10204 ed 2004 - 3.1 (EQUIVALENT TO EN 10204 ed 1991 - 3.1B)

C= MATERIALS CERTIFICATE ACC. TO EN 10204 ed 2004 - 3.1 (EQUIVALENT TO EN 10204 ed 1991 - 3.1B)

## LIST OF RAW MATERIALS

4	12.11.2018	P.E.S.	A Schiavello	G Arena	ISSUED AS BUILT
3	19.04.2018	P.E.S.	A Schiavello	G Arena	REVISED CLIENT PROJECT DOC. NO.
2	11.04.2018	P.E.S.	A Schiavello	G Arena	REVISED WHERE INDICATED
1	12.03.2018	P.E.S.	A Schiavello	G Arena	ISSUED FOR APPROVAL
0	16.02.2018	P.E.S.	A Schiavello	G Arena	ISSUE FOR 3D MODEL DESIGN
REV.	DATE	CREATED BY	CHECKED BY	APPROVED BY	DESCRIPTION

PROPRIETARY AND CONFIDENTIAL				ORLEN Lietuva	
PROJECT NAME Propane Propylene Fraction (PPF) Splitter		SUBSUPPLIER INFORMATION		CLIENT PROJECT NO. OLP01011	
CLIENT NAME ORLEN Lietuva		LOCATION Juodeikiai, Lithuania		GE INTERNAL PROJECT NO. ICP-000037	
REPLACES		SUPPLIER/CONTRACTOR IDENT NO.		CLIENT PROJECT DOC. NO. OLP-01011-DP-M-GA900	
BAKER HUGHES		TITLE REGENERATION GAS FEED EFFLUENT HEAT EXCHANGER TK-44.1		DOCUMENT CODE SG 8080084	
REVISION DESCRIPTION ISSUED AS BUILT		PAGE MARKER N/A		REVISION 4	
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		SIZE 1		LANGUAGE A	
				SHEET 4 of 4	

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