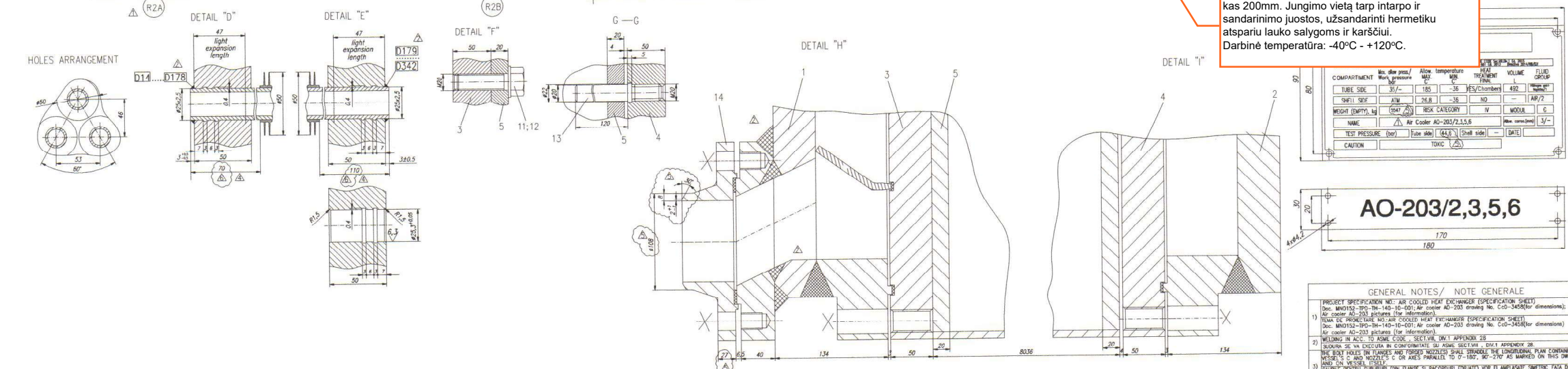
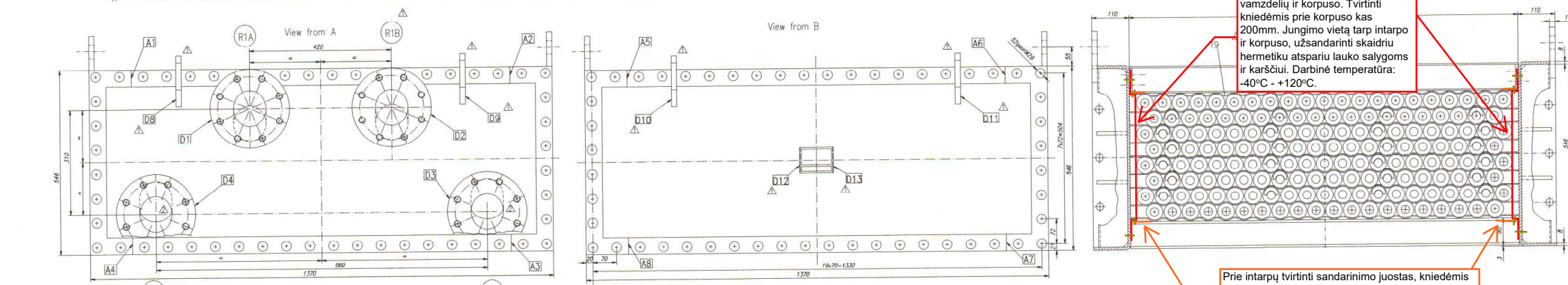
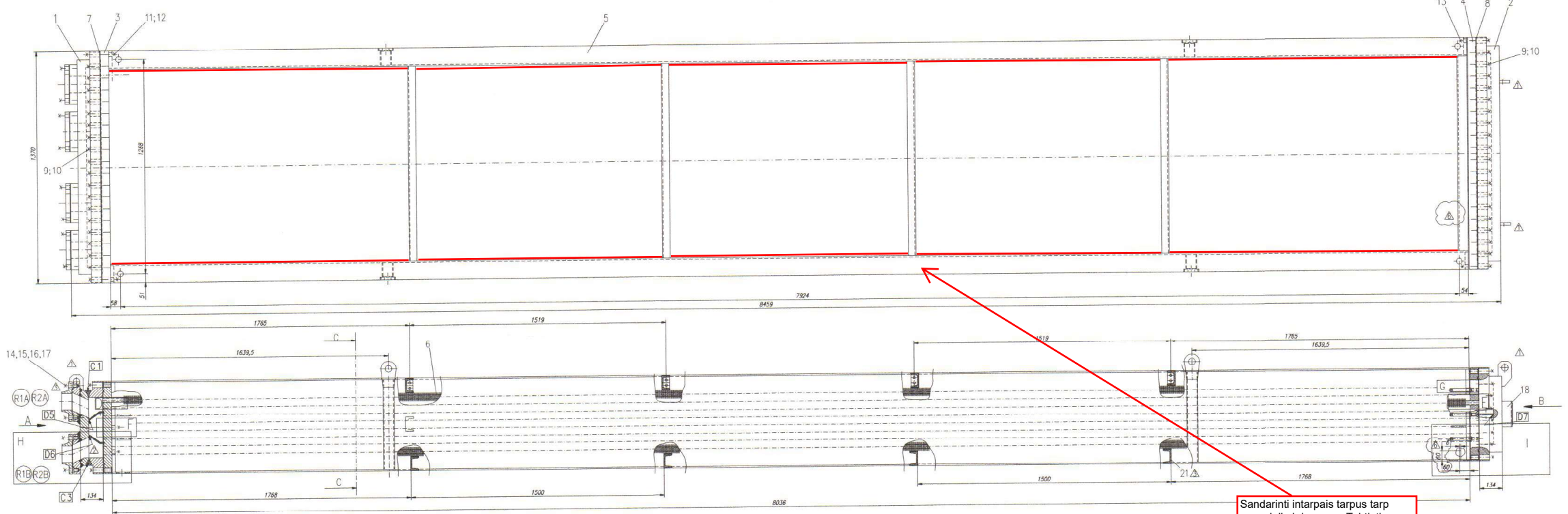





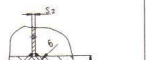
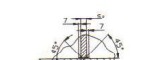


AO-203/2 AO-203/3 remonto schema - sandarinimas



WELDING JOINT ELEMENTS/ ELEMENTELE IMBINARII SUDATE																				
<p>Cat. C (conf. UW-3) Tip 7 (conf. UW-12)</p> <p>A1...A8</p> 			<p>Cat. A (conf. UW-3) Tip 1 (conf. UW-12)</p> <p>D1...D4</p> 			<p>Cat. D (conf. UW-3) Tip 1 (conf. UW-12)</p> <p>D5...D6</p> 			<p>Cat. D (conf. UW-3) Tip 7 (conf. UW-12)</p> <p>D7</p> 			<p>Cat. D (conf. UW-3) Tip 7 (conf. UW-12)</p> <p>D8...D9</p> 			<p>Cat. D (conf. UW-3) Tip 7 (conf. UW-12)</p> <p>D10...D13</p> 			<p>Cat. D (conf. UW-3) Tip 7 (conf. UW-12)</p> <p>D14...D34</p> <p>Cat. D (conf. UW-3) Tip 7 (conf. UW-12)</p> 		
<p>Symbol s_1 s_2 PQR WPS</p> <p>A1...A8 89</p> <p>Non destructive test: FUL UT</p> <p>Test nedistructiv: FUL UT</p>			<p>Symbol s_1 s_2 PQR WPS</p> <p>D1...D4 50 45</p> <p>Non destructive test: FUL PT</p> <p>Test nedistructiv: FUL PT</p>			<p>Symbol s_1 s_2 PQR WPS</p> <p>D5...D6 50 B</p> <p>Non destructive test: FUL PT/MT</p> <p>Test nedistructiv: FUL PT/MT</p>			<p>Symbol s_1 s_2 PQR WPS</p> <p>D7 50 B</p> <p>Non destructive test: FUL PT/MT</p> <p>Test nedistructiv: FUL PT/MT</p>			<p>Symbol s_1 s_2 PQR WPS</p> <p>D8...D9 50 16</p> <p>Non destructive test: FUL PT/MT</p> <p>Test nedistructiv: FUL PT/MT</p>			<p>Symbol s_1 s_2 PQR WPS</p> <p>D10...D13 50 4</p> <p>Non destructive test: FUL PT/MT</p> <p>Test nedistructiv: FUL PT/MT</p>			<p>Symbol s_1 s_2 PQR WPS</p> <p>D14...D34 50 2,5</p> <p>Non destructive test: FUL PT</p> <p>Test nedistructiv: FUL PT</p>		

NOZZLE TABLE / TABELUL RACORDURILOR									
MARK	PCS	SERVICE	SIZE	RATING	PIPE / TRAI	FLANGE / FLANSA	FLANGE / FLANSA	REIN. PAD	REMARKS
NO.	OUT.	DESTINATIE	IN	PN	OD x THK SCH	OR NORM	OR FLANS	OD x THK SCH	NOTES
RITA R1B	2	INLET NOZZLE	100	40	DN 100 x 5	DN 100	MF	△	Flange & gasket stud both the no
R2A R2B	2	OUTLET NOZZLE	100	40	DN 100 x 5	DN 100	MF	△	Flange & gasket stud both the no

RF, Raised Face concentric or spiral seated
 Radius of cutting face 1.6mm, Pitch 0.6, 0.8mm; Row=3, 12.5mm

TECHNICAL CHARACTERISTICS/CAPACIT. TECHNICAL SPECIFICATIONS			
NAME		Mass unit	TEMP. USE
NOMINUM		kg	°C
P	Pres. pressure (atm./at)		
	Pres. pressure (atm./at)	bar g	34,3
T	Temperatura (°C/°F)		
	Temperatura (°C/°F)	°C	-36/85
Q	Operating pressure		
	Pressione di lavoro	bar g	-36/85
Q	Operating temperature		
	temperatura di lavoro (°C/°F)	°C	153/45
G	Gas		
	Gas		Heligon gas
F	Fluid Group		
	Gruppo fluidi		1 2
D	Density	kg/m ³	756,2
	Densità		7,1700C
C	Corrosion allowance	mm	3
	Corrosione media		3
C	Capacity	L	492
	Capacità		
N	Number of hoses		4
	Numero di tubi		
S	Sec. surface	m ²	1780
	Area di trasfer.		
N	Number of tubes		164
	Numero di tubi		
P	Pressure of tube (1000 t/h x L) pich	mm	Ø252,51-Ø186
	Pressione di tubo		
L	Tube layout & pitch	mm	P-353
	Layout & pitch		Ø186-Ø186
L	Tube to tubsheet joint		FR-550
	Joint tuba a tubsheet		FR-550
L	Empty tube bundle weight (see item 1)	kg	594
	Weight of empty tube bundle		
P	Proton exchange weight	kg	6039
	Proton exchange weight		

TECHNICAL REQUIREMENTS/ CONDTITI TECHNIQUE				
CALCULATION AND DESIGN		AS 6100 Code Sect 4.6.1.1 La 2005 AS 6100 Code Sect 4.6.1.2 La 2005 AS 1754 (2003) (2005) (2008) AS 1010 La 2005 Appendix 2 (AS 1010)		CE
FABRICATION, EXAMINATION, TESTING AND INSPECTION				
SIDE			TURE SIDE	
Joint eff.			1	
Type of welds	Butt welds	Groove welds	Fillet welds	
Nondestructive test	FULL UT	FULL UT	FALL UT	FALL UT
Hydrostatic test pressure			44.6	5
Test temperature	°C	15	30	
Duration of hydrostat. test	min	30	Δ	
Design wind calculation			—	
Seismic design calculation			—	
Post weld heat treatment			YES—CHAMBER	
Impact Test required			YES	

	MATERIALS/MATERIALE	Additional requirements Cerinte suplimentare
USE CASE / CAZ DE UTILIZARE	Poly board Corc. comp.	Normalized, C ≤ 0.23% wt., CE ≤ 0.43%, 100% UT examination for discontinuity flows of steel plate
	Steel flanges flange receburit	
	S16-816 G70	
	Tubesheet foaie tubulara	
	S16-816 G70	
	Flange flansa	Seamless, without longitudinal and circumferential weld joints
	S16-17H N	Maximum Carbon content ≤ 0.23%
	Concentric concentrice	C ≤ 0.43%
	Counter Flanges flansa de contra	For GOST flanges ASME B16.5/ For GOST flanges DIN EN 934(matrix)
	Pressure nuts capacane - stal	
Capacane - Shell Flanges flansa - coaja		
	CAPACANE	

*-Cu exceptia tevilor cu ar

- - Sandarinimo tarpai 60vnt (Užsakovo)
- - Sandarinimo juostos 120vnt (užsakovo)
- - Kniedžių montavimo vieta.

Naudoti nerūdijančio plieno kniedes.
Skyles gręžti atitinkamai pagal
kniedės diametrą.

Pastaba: demontuoti AO-203/2; AO-203/3 sparnuočių apsaugas patekimui prie aušintuvo vamzdelių iš apatinės pusės.

21	CLEMA CLAMP	UC132-403.21	32	A199	0,03
20	FIXING CLAMP	UC132-403.20	28	A199	0,06
20	FIXING ELEMENT	UC132-403.19	36	A199	0,00
17	BANDA ONDULADA	UC132-403.18.00	1		2,25
17	WAVE BAND	UC132-403.18.00	1		0,15
17	PLACA DE TIMBURO CU SUPPORT NAME PLATE WITH SUPPORT	UC132-403.15	32	SA 194 2H M	0,10
17	PLACA M24 A30	UC132-403.16	32	SA 193 B7 M	0,15
17	HEX NUT M24	STAS 8121/3	4	SA 105/SA 350	8,6
17	PREZON 1A M24x90	UC132-403.15	4	SA 193 B7	0,02
17	STUD BOLT 1A M24x90	UC132-403.15	4	SA 193 B7	0,16
17	CAMPROFLE CAMPROFLE B7A	UC132-403.15	1		0,16
17	CAMPROFLE GASKET B7A	UC132-403.14	1		8,6
17	FLANGIA	UC132-403.14	1		0,02
17	FLANGES	UC132-403.13	6	SA 193 B7	0,17
17	BOLT CHORDARE	STAS 5200/2	6	Gr.10/9	0,16
17	GUIDE STUD BOLT	UC132-403.13	104	SA 193 B7 M	0,62
17	SABGA A20	STAS 5200/2	1		1,3
17	WASHER	SR ISO 4017	164		90,2
17	SURFUD M20x70	UC132-403.09	104	SA 193 B7 M	1,3
17	SCREW	UC132-403.08.00	1		19,2
17	PILGITA M27	UC132-403.07.00	1		247
17	HEX NUT M27	UC132-403.06.00	1		394
17	PREZON 1A M27x145	UC132-403.05.00	1		247
17	STUD BOLT 1A M27x145	UC132-403.04.00	1		247
17	CAMPROFLE CAMPROFLE CI	UC132-403.03.00	1		247
17	CAMPROFLE GASKET CI	UC132-403.02.00	1		247
17	GAMTRITUA CAMPROFLE CD	UC132-403.01.00	1		247
17	CAMPROFLE GASKET CD	UC132-403.00.00	1		247
17	TEAVA CU ARDIDARE	UC132-403.00.00	1		247
17	FINNED TUBE	UC132-403.00.00	1		247
17	RAMA SECTIE	UC132-403.00.00	1		247
17	BASE FRAME	UC132-403.00.00	1		247
17	PLACA TUBULARA MOBILA	UC132-403.00.00	1		247
17	MOBILE TUBE SHEET	UC132-403.00.00	1		247
17	PLACA TUBULARA FIXA	UC132-403.00.00	1		247
17	STATIONARY TUBE SHEET	UC132-403.00.00	1		247
17	CAMERA DE INTARCARE	UC132-403.00.00	1		247
17	RETURN CHAMBER	UC132-403.00.00	1		247
17	CAMERA DE DISTRIBUTIE	UC132-403.00.00	1		247
17	DISTRIBUTION CHAMBER	UC132-403.00.00	1		247

AO-203/2,3,5,6

[illegible]

Produs	Ing. Popa Alexe	Masa	16.01.2017	Secție tubulară AO-203/2,3,5,6
S.C. COMES S.A.				ΔAIR COOLER AO-203/2,3,5,6
http://www.comes.ro/				
Savinesti - Neamt				
Romania				AO (1188x840)