



MATERIALS AND SPECIFICATION			
POS. QUANT.	DESCRIPTION	MATERIALS	NOTES
1	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
2	204 CAST STAIN REDUCER TO FIT TUBE 10-110	204-35N NB	WELDING MATERIAL
3	204 GRID PLATE (STAIN CAST) 00108	204-35N NB	WELDING MATERIAL
4	204 4" 600# BULLD 125-250 MSW (12)	ASTM A182 347H	SEE DTL "A"
5	204 4" 600# BULLD 125-250 MSW (12)	ASTM A182 347H	SEE DTL "A"
6	1632 GRID PLATE 7/8" L = 154	ASTM A182 347H	SEE DTL "A"
7	3264 HEX NUT 7/8"	ASTM A182 347H	SEE DTL "A"
8	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
9	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
10	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
11	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
12	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
13	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
14	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
15	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
16	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
17	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
18	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
19	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
20	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL
21	204 10-110-TK 12 MSW (6)	204-35N NB	WELDING MATERIAL

DESIGN DATA			
PART	INLET ZONE POS. 445/11	CAST TUBE POS. 8	OUTLET ZONE POS. 8
FLUID PHASE	HC-STEAM	HC-STEAM	HC-STEAM
FLUID GROUP/EQUIVA. CATEGORY	ACC-37/23/CE	ACC-37/23/CE	ACC-37/23/CE
MODULE	I/V	I/V	I/V
DESIGN-PRESSURE	37.5	37.5	37.5
DESIGN-TEMP.	545	545	545
CORROSION ALLOWANCE	mm	mm	mm
HYDRO-TEST PRESS. (SHOCK)	bar g	bar g	bar g
HYDRO-TEST PRESS. (FIELD)	bar g	bar g	bar g
EMPTY WEIGHT	kg	kg	kg
OPERATION WEIGHT	kg	kg	kg
WEIGHT FILL OF WATER	kg	kg	kg
VOLUME	m ³	m ³	m ³
POST WELD HEAT TREATMENT	N.A.	N.A.	N.A.
RADIUS SHOT WELD PERC.	100	100	100
RADIUS FIELD WELD PERC.	100	100	100
DRY PENETRANT	100	100	100
ULTRASONIC EXAMINATION	100	100	100
MAGNETIC EXAMINATION	100	100	100
DESIGN AS PER	97/23/CE(FED)/TR/KI	97/23/CE(FED)/TR/KI	97/23/CE(FED)/TR/KI
CONSTRUCTION AS PER	97/23/CE(FED)/TR/KI	97/23/CE(FED)/TR/KI	97/23/CE(FED)/TR/KI
INSPECTION BY	NOTIFY BODY/TR/KI/CLIENT	NOTIFY BODY/TR/KI/CLIENT	NOTIFY BODY/TR/KI/CLIENT

NOTES (FOR FABRICATION)			
1- ALL DIMENSIONS ARE IN MM UNLESS OTHERWISE SPECIFIED.			
2- DESIGN, CONSTRUCTION, INSPECTION, TESTING AND EXTENT OF SUPPLY SHALL COMPLY WITH MATERIAL SPECIFICATION Y. 30570-800-4P-0121-001.			
3- WELDING SHALL BE IN ACCORDANCE WITH THE WELDING PROCEDURE SPECIFICATION (WPS) AND THE WELDING QUALIFICATION RECORD (WQR).			
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10- TO BE TESTED IN FIELD TOGETHER WITH INLET SYSTEM AND OUTLET SYSTEM.			
11- EACH CAST SECTION OF TUBES SHALL BE X-RAY PRESSURE TESTED ACCORDING TO EN 10204 TYPE 3.1, ANYWAY ACC. TO PED.			
12- FLANGE DIMENSIONS AND THICKNESS SHALL BE AS PER PRESSURE TESTED ACCORDING TO EN 10204 TYPE 3.1, ANYWAY ACC. TO PED.			
13- BASED ON FLANGE FINISH WITH TUBE 10. AND 0.1.			
14- ALL ELEVATIONS ARE REFERRED TO THE HIGHEST PAVING POINT (HPP) +4.00 WHICH CORRESPOND TO ELEVATION 64.75 m ABOVE SEA LEVEL.			
15- ACTUAL WELD NUMBER AND WELD DETAIL BY VENDOR.			
16- WELD DETAIL SIZE = (TUBE TUBE O.D.) X 1" SCH. 40.			
17- CATALYST TUBE ASSEMBLY TO BE SUPPLIED COMPLETELY SHOP FABRICATED AND TESTED.			
18- DETAIL TO BE SUPPLIED COMPLETELY SHOP FABRICATED AND TESTED.			
19- DETAIL TO BE SUPPLIED COMPLETELY SHOP FABRICATED AND TESTED.			
20- THE INDICATED GRID SHALL BE WELDED INTO CATALYST TUBE BEFORE WELDING THE REDUCER TUBE.			
21- MECHANICAL DIMENSION DESIGN IS A FULL SUPPLIER'S RESPONSIBILITY AND SHALL BE DEVELOPED BY TAKING INTO ACCOUNT THE TOLERANCE WORKING & PREPARATION TOLERANCE AS PER 30570-800-4P-0121-001.			
22- TOLERANCE WORKING & PREPARATION TOLERANCE AS PER 30570-800-4P-0121-001.			
23- ALL BUTT WELDS SHALL BE 100% RADIOGRAPHED.			
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25- WPS FOR WELDING SHALL BE IN ACCORDANCE WITH ASME IX LAST EDITION.			
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