

1. INSULATION ACC. TO FWI JOB SPEC. BD0314A-82A1.
2. EXTERNAL PAINTING ACC. TO SPEC. NO. MN-PG-1030.
3. MARKING ACC. TO USER'S DIRECTIONS.
4. ALL DIMENSIONS SIGN "mm" FIT BY ASSEMBLY.
5. FOR NDT SEE ALSO FWI PIPING MATERIAL JOB SPEC. BD0314A-50A10 TABLE AT PAGE 7.

Nuketta j
lapa Nr.10

(3)

2015.10 UAB "TPSC" REKONSTRUKCIJOS VIETA
Žr. 12-13 sch lapus

INSPECTION OF PIPELINE CIRCUMFERENTIAL WELD



810 DISTANCE BETWEEN WELDS



- Rekonstrukcija 2007.11.21 (naftoremont)
- Rekonstrukcija 2000.10.12 (iremas)
- Rekonstrukcija 2000.10.11 (TSK)

10	100	114.3	PD-005	300	800	2	1
9	100	114.3	PD-005	340		1	1
8	100	114.3	PD-005	340		1	1
7	100	114.3	PD-005	340		1	1
6	80	80.9	IS-040	A		1	1
5	80	80.9	PD-005	1140		1	1
4	80	80.9	PD-005	700		1	1
3	100	114.3	PD-002	100	300	7	1
2	100	114.3	PD-002	100	300	4	1
1	100	114.3	PD-002	100	300	1	1

BILL OF SUPPORTS

OPER. MEDIUM				DIESEL				TEST MEDIUM				WATER			
PARAMETERS				OPER.		DESIGN		TEST		QUALITY LEVEL		VT		RT/UT	
PRES. barg				11		16		24		B		100		5	
TEMP. °C				100		100		10-40		PWHT					
80		3.2		-		-		-		DN		100		80	
100		3.5		-		-		-		TYPE		FP		FP	
DN		M.A.W.T.		DN		M.A.W.T.		DN		M.A.W.T.		THK.		40	
												40		-	

MINIMUM ALLOWABLE WALL THK. INSULATION

HEATING	WT	MATERIAL	CS	CLASS
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CODES	PED, ASME B31.3
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PIPING LAYOUT DWG. NO.	10
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P&I DIAGRAM NO.	GP2-S001/1-20
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BILL OF MATERIAL NO.	BD0314A-57-0208/0209/0210/0216/0219/0220-615/5
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INSPECTION BY	PT	CLASS ACC. TO PED	1-1
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0	AS BUILT, FOR PASSPORT DOC. ONLY
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REV.	REVISION DESCRIPTION
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0	T. Nawrocki	R. Tokarczyk	K. Radomski
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REV.	PREPARED BY	SIGN	CHECKED BY	SIGN	APPROVED BY
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INVESTOR:	AB MAZEKU NAFTA
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PLANT:	VACUUM UNIT
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PROJECT TITLE:	VACUUM UNIT REBUILDING
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LINE NO.:	615/5
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SIZE	ISO. NO.	SHEET	SHEE
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AS	BD0314A-57-0208/0209/0210/0216/0219/0220-615/5	01	13
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NAFTOREMONT	ISO. NO.	SHEET	SHEE
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AS	BD0314A-57-0208/0209/0210/0216/0219/0220-615/5	01	13
----	--	----	----

NAFTOREMONT	ISO. NO.	SHEET	SHEE
-------------	----------	-------	------

AS	BD0314A-57-0208/0209/0210/0216/0219/0220-615/5	01	13
----	--	----	----

NAFTOREMONT	ISO. NO.	SHEET	SHEE
-------------	----------	-------	------

AS	BD0314A-57-0208/0209/0210/0216/0219/0220-615/5	01	13
----	--	----	----

NAFTOREMONT	ISO. NO.	SHEET	SHEE
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AS	BD0314A-57-0208/0209/0210/0216/0219/0220-615/5	01	13
----	--	----	----

NAFTOREMONT	ISO. NO.	SHEET	SHEE
-------------	----------	-------	------

AS	BD0314A-57-0208/0209/0210/0216/0219/0220-615/5	01	13
----	--	----	----

NAFTOREMONT	ISO. NO.	SHEET	SHEE
-------------	----------	-------	------

AS	BD0314A-57-0208/0209/0210/0216/0219/0220-615/5	01	13
----	--	----	----

NAFTOREMONT	ISO. NO.	SHEET	SHEE
-------------	----------	-------	------

AS	BD0314A-57-0208/0209/0210/0216/0219/0220-615/5	01	13
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NAFTOREMONT	ISO. NO.	SHEET	SHEE
-------------	----------	-------	------

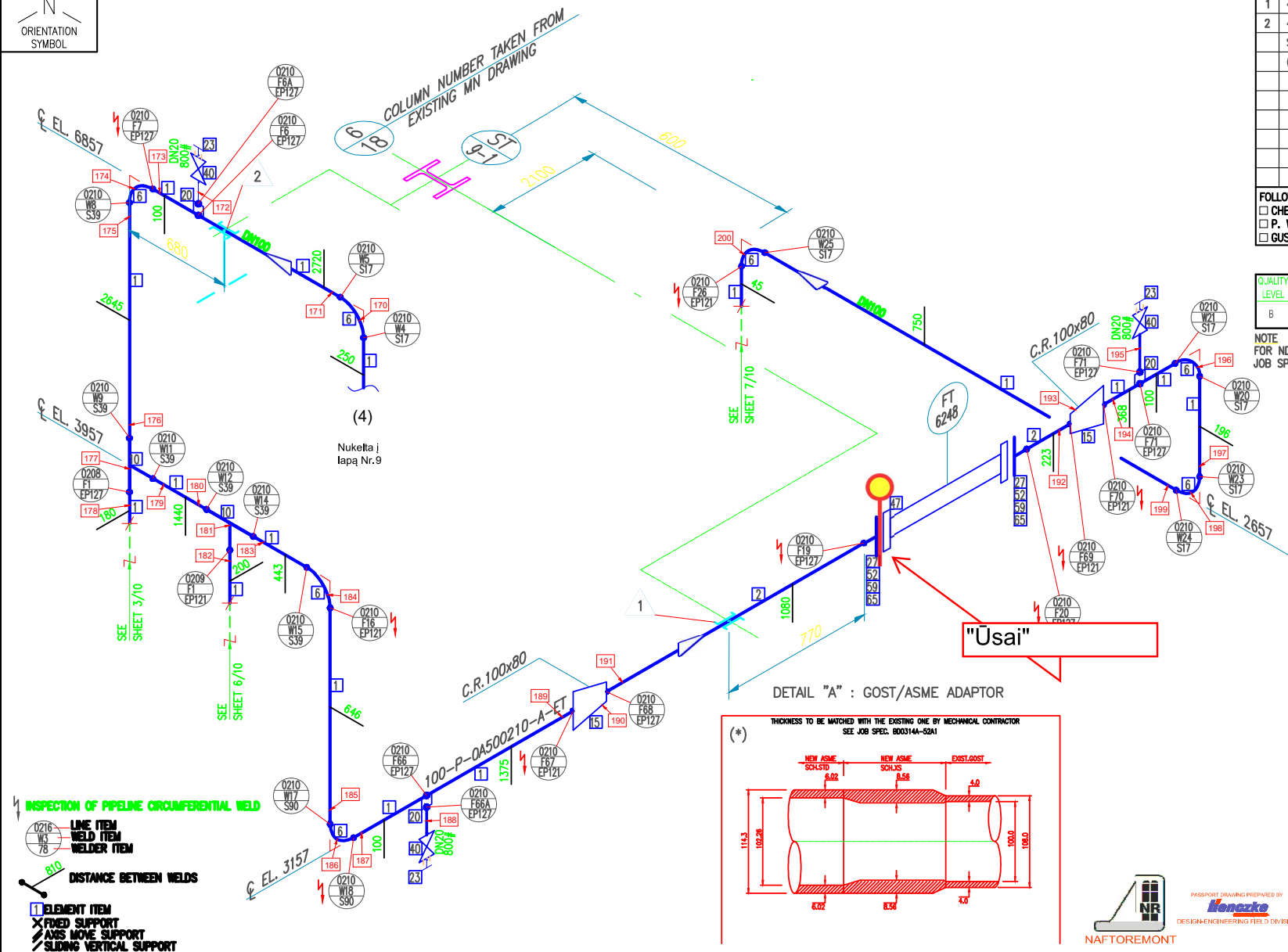
AS	BD0314A-57-0208/0209/0210/0216/0219/0220-615/5	01	13
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NAFTOREMONT	ISO. NO.	SHEET	SHEE
-------------	----------	-------	------

AS	BD0314A-57-0208/0209/0210/0216/0219/0220-615/5	01	13
----	--	----	----

NAFTOREMONT	ISO. NO.	SHEET	SHEE
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AS	BD0314A-57-0208/0209/0210/0216/0219/0220-615/5	01	13
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TAG	PIPE SUPPORT CODE NUMBER	QTY
1	4"-B.SG-100-300-#	1
2	4"-B.SG-100-300-#	1
	S.S13-A1-H100-600-300	1
	(S.S71-3-H160-6000)	-

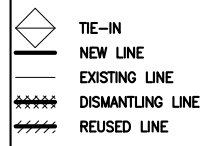
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<input type="checkbox"/> P. W. H. T.	<input type="checkbox"/> SAFETY SHIELD
<input type="checkbox"/> GUSSETING	<input type="checkbox"/> WET H ₂ S



Q.QUALITY	VT	RTUT	MT/PT
LEVEL		%	
B	100	5	SEE NOTE

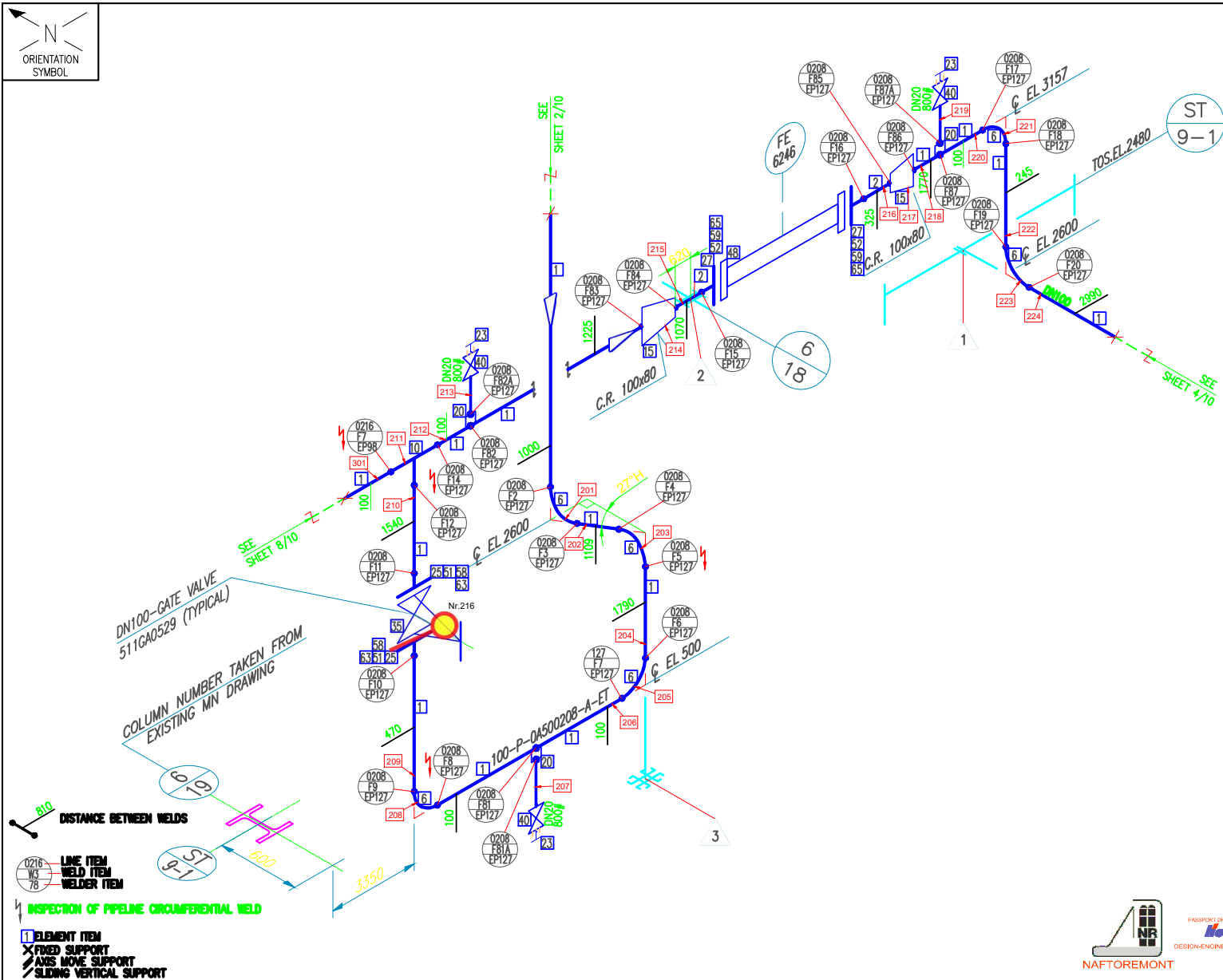
NOTE
FOR NDT SEE ALSO FWI PIPING MATERIAL
JOB SPEC. BD0314A-50A10 TABLE AT PAGE 7.

LEGEND








REVAMP VACUUM UNIT
MZK000A5

										0	01-2008	AS BUILT. FOR PASSPORT DOC. ONLY	T.N.	D.K.					R.M. APPROVED FOR CONSTRUCTION	FWI CONTRACT: 1-BD-0314A			
										S02	11-09-07	REVISED WHERE INDICATED	M.D.	I.C.	M.A.	C.E.	D.M.	B.C.		SUBPROJECT CODE: MZK000A5			
										S02	10-08-07	REVISED WHERE INDICATED	M.D.	I.C.	M.A.	E.C.	D.M.	B.G.		MATERIAL TYPE: C.S.			
										R01	05-07-07	ISSUED FOR CONSTRUCTION	M.D.	I.C.	M.A.	E.C.	D.M.	B.G.					
100	615/5	A	N/A	35	100	16.0	26	ET	40	A00	23-05-07	PRELIMINARY ISSUE	M.D.										KT MODERNIZATION PROGRAM
SIZE	LINE N°.	SPEC.	TURN. SYS.	OPER. TEMP.	DES. TEMP.	DES. PRES.	TEST PRES.	TYPE	THK	REV	DATE	REVISION DESCRIPTION	DRAW	CHK	SUPP	PIPING	STRESS	MTG					
								INSULATION															




NOTE
FOR NDT SEE ALSO FWI PIPING MATERIAL
JOB SPEC. BD0314A-50A10 TABLE AT PAGE 7.

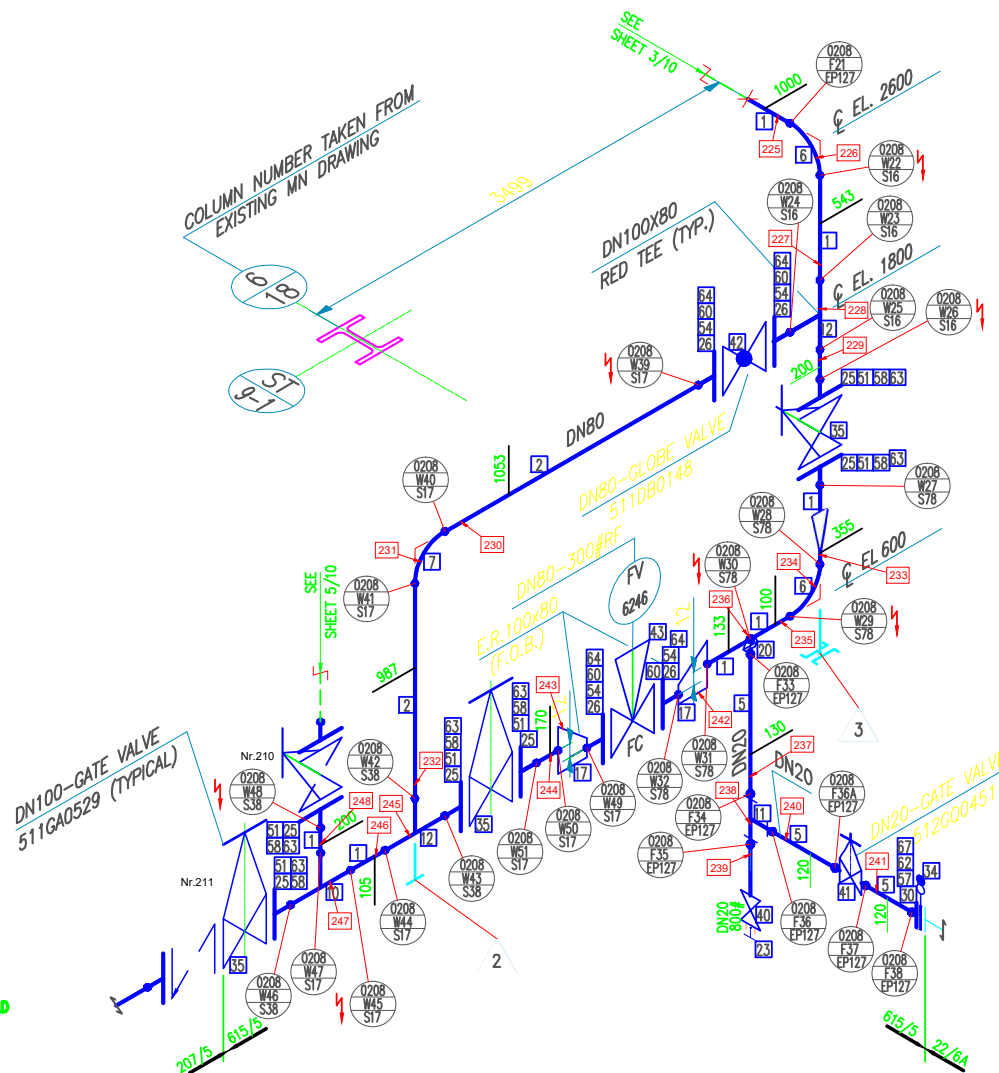
LEGEND

-  TIE-IN
-  NEW LINE
-  EXISTING LINE
-  DISMANTLING LINE
-  REUSED LINE








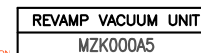
REVAMP VACUUM UNIT
MZK000A5


										0	01-2008	AS BUILT. FOR PASSPORT DOC. ONLY	T.N.	D.K.					R.M.	FWI CONTRACT:	1-BD-0314A	 MAŽEIKIŲ NAFTA
										S03	14-08-07	REVISED WITHOUT HOLD	M.D.	I.C.	M.A.	C.E.	D.M.	B.G.		SUBPROJECT CODE:	MZK000A5	
										R02	01-08-07	REVISED WHERE INDICATED	M.D.	I.C.	M.A.	E.C.	D.M.	B.G.		MATERIAL TYPE:	C.S.	
										R01	05-07-07	ISSUED FOR CONSTRUCTION	M.D.	I.C.	M.A.	E.C.	D.M.	B.G.			SHEET SHEETS	
										A00	23-05-07	PRELIMINARY ISSUE	M.D.									
SIZE	LINE N°.	SPEC.	TURN. SYS	OPER. TEMP.	DES. TEMP.	DES. PRES.	TEST PRES.	TYPE	THK	REV	DATE	REVISION DESCRIPTION	DRAW	CHKC	SUPP	PIPING	STRESS	MITO		N°	REV.	
																				800314A-57-0206/0209/0210/0216/0219/0220-615/G	Rev. 0	
																				800314A-57-0206/0209/0210/0216/0219/0220-615/G	Rev. 0	

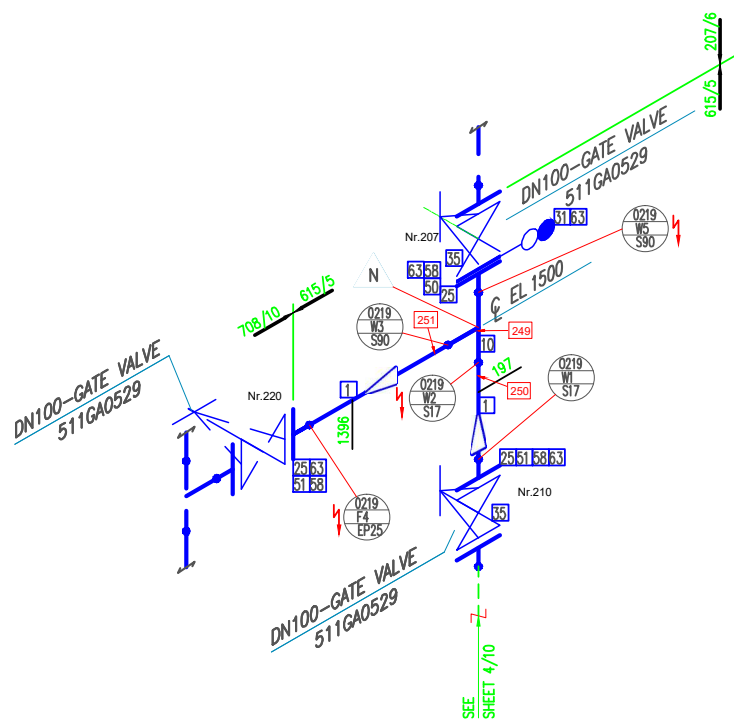
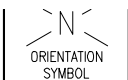


LEGEND

-  TIE-IN
-  NEW LINE
-  EXISTING LINE
-  DISMANTLING LINE
-  REUSED LINE



										0	01-2008	AS BUILT. FOR PASSPORT DOC. ONLY	T.N.	D.K.							APPROVED FOR CONSTRUCTION	R.M.	FWI CONTRACT: 1-BD-0314A			KT MODERNIZATION PROGR
										S03	14-08-07	REVISED WITHOUT HOLD	M.D.	I.C.	M.A.	C.E.	D.M.	B.G.					SUBPROJECT CODE: MZK000A5			
										R02	01-08-07	REVISED WHERE INDICATED	M.D.	I.C.	M.A.	E.C.	D.M.	B.G.					MATERIAL TYPE: C.S.			
										R01	05-07-07	ISSUED FOR CONSTRUCTION	M.D.	I.C.	M.A.	E.C.	D.M.	B.G.								
										A00	23-05-07	PRELIMINARY ISSUE	M.D.													
100	615/5	A	N/A	35	100	16.0	26	ET	40																	
SIZE	LINE N°.	SPEC.	TURN. SYS.	OPER. TEMP.	DES. TEMP.	DES. PRES.	TEST PRES.	TYPE	THK	REV	DATE	REVISION DESCRIPTION	DRAW	CHK	SUPP	PIPE	STRESS	MT								



4 INSPECTION OF PIPELINE CIRCUMFERENTIAL WELD



DISTANCE BETWEEN WELDS



1 ELEMENT ITEM
X FIXED SUPPORT
/// AXIS MOVE SUPPORT
/ SLIDING VERTICAL SUPPORT

[illegible]






FOLLOWING NOTES APPLY TO ISO ONLY WHEN

<input type="checkbox"/> CHEMICAL CLEANING	<input type="checkbox"/> DEGREASING
<input type="checkbox"/> P. W. H. T.	<input type="checkbox"/> SAFETY SHIE
<input type="checkbox"/> GUSSETING	<input type="checkbox"/> WET H ₂ S

QUALITY LEVEL	VT	RT/UT	MT/PT
	%		
B	100	5	SEE NOTES

NOTE
FOR NDT SEE ALSO FWI PIPING MATERIAL
JOB SPEC. BD0314A-50A10 TABLE AT PAGE 7.

LEGEND

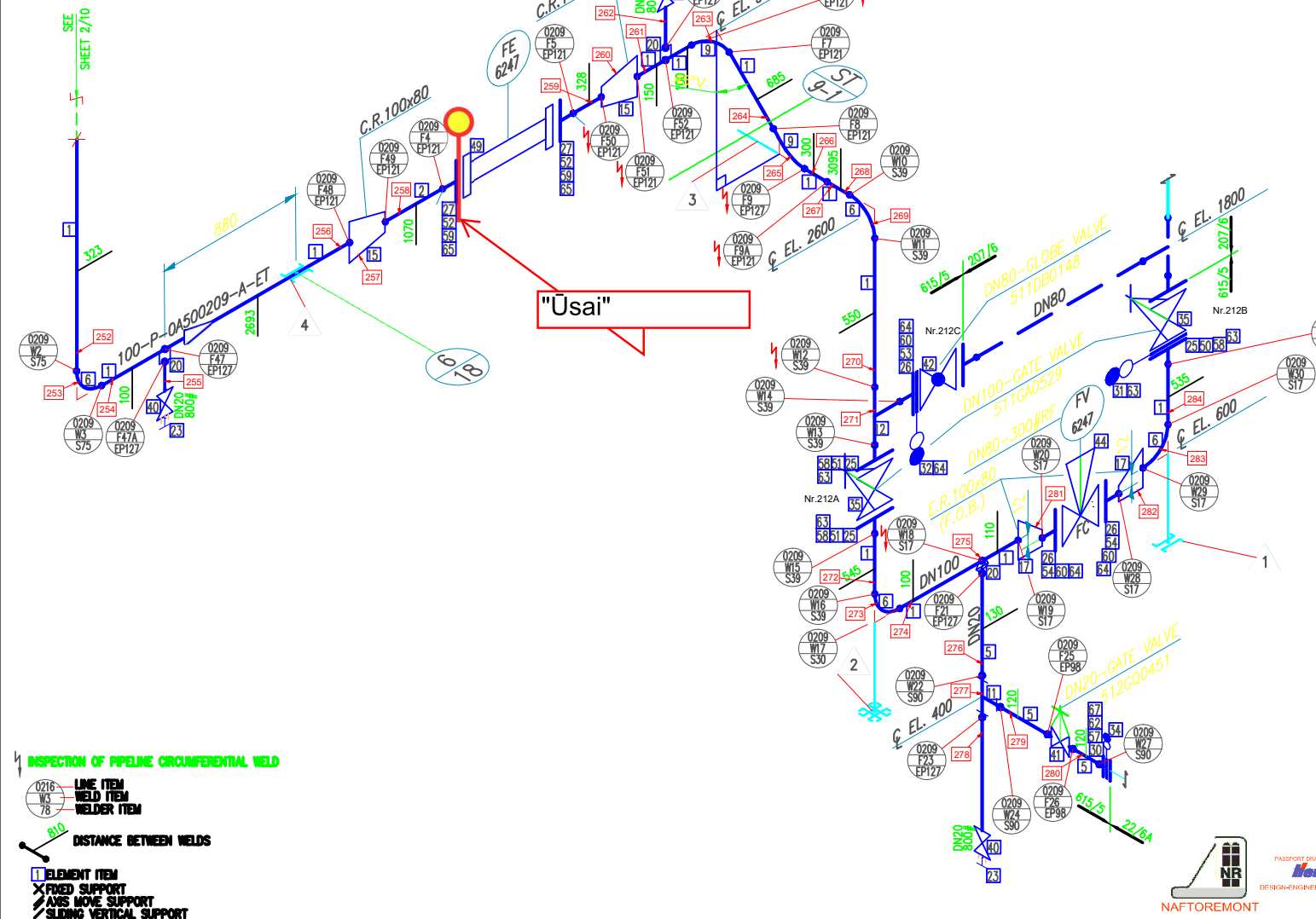
-  TIE-IN
-  NEW LINE
-  EXISTING LINE
-  DISMANTLING LINE
-  REUSED LINE



PASSPORT DRAWING PREPARED BY
henczo
DESIGN-ENGINEERING FIELD DIVISION

REVAMP VACUUM UNIT
MZK000A5

[illegible]



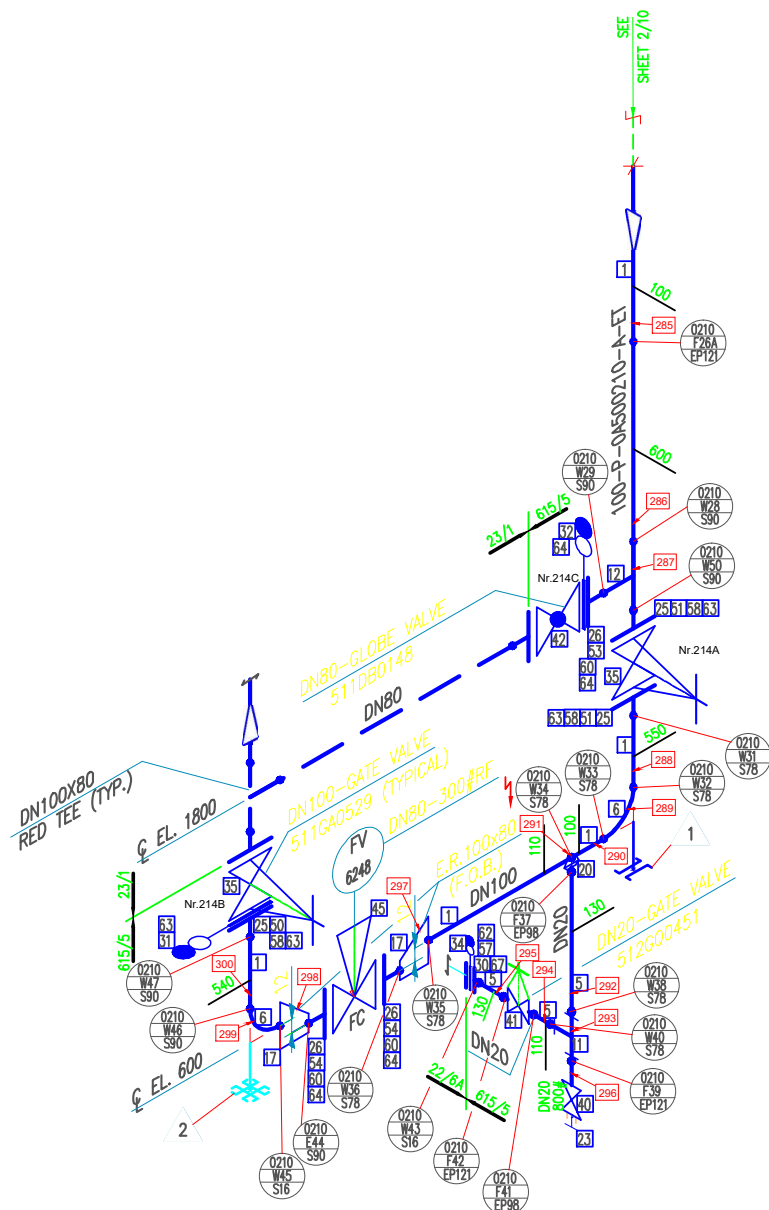
FOLLOWING NOTES APPLY TO ISO ONLY WHEN ☐

<input type="checkbox"/> CHEMICAL CLEANING	<input type="checkbox"/> DEGREASING
<input type="checkbox"/> P. W. H. T.	<input type="checkbox"/> SAFETY SHIELD
<input type="checkbox"/> GUSSETING	<input type="checkbox"/> WET H ₂ S

NOTE
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JOB SPEC. BD0314A-50A10 TABLE AT PAGE 7.

REVAMP VACUUM UNIT
MZK000A5

[illegible]



FOLLOWING NOTES APPLY TO ISO ONLY WHEN ☐


<input type="checkbox"/> CHEMICAL CLEANING	<input type="checkbox"/> DEGREASING
<input type="checkbox"/> P. W. H. T.	<input type="checkbox"/> SAFETY SHIELD
<input type="checkbox"/> GUSSETING	<input type="checkbox"/> WET H ₂ S

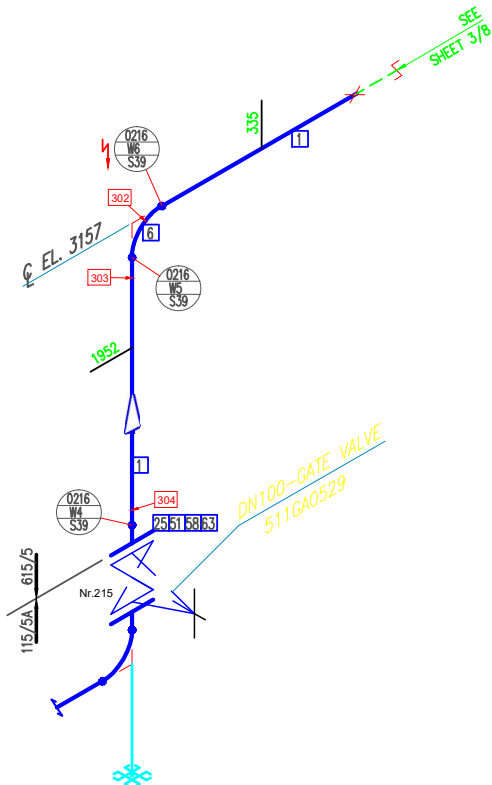
NOTE
FOR NDT SEE ALSO FWI PIPING MATERIAL
JOB SPEC. BD0314A-50A10 TABLE AT PAGE 7.

NOTE
FOR NDT SEE ALSO FWI PIPING MATERIAL
JOB SPEC. BD0314A-50A10 TABLE AT PAGE 7.



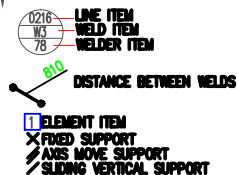
REVAMP VACUUM UNIT
MZK000A5

										0	01-2008	AS BUILT. FOR PASSPORT DOC. ONLY	T.N.	R.T.						APPROVED FOR CONSTRUCTION	FMI CONTRACT: 1-BD-0314A SUBPROJECT CODE: MZK000A5 MATERIAL TYPE: C.S.	 KT MODERNIZATION PROGRAM	SHEET 07 SHEETS 13 N° B00314A-57-0208/0209/0210/0216/0219/0220-615/5 603-R4-PK-615/5	REV.
										SO4	14-08-07	REVISED WITHOUT HOLD	M.D.	I.C.	M.A.	C.E.	D.M.	B.G.						
										RO3	06-08-07	REVISED WHERE INDICATED	M.D.	I.C.	M.A.	E.C.	D.M.	B.G.						
										RO2	01-08-07	REVISED WHERE INDICATED	M.D.	I.C.	M.A.	E.C.	D.M.	B.G.						
100	615/5	A	N/A	35	100	16.0	26	ET	40	RO1	05-07-07	ISSUED FOR CONSTRUCTION	G.M.	I.C.	M.A.	E.C.	D.M.	B.G.						
SIZE	LINE N°.	SPEC.	TURN. SYS.	OPER. TEMP.	DES. TEMP.	DES. PRES.	TEST PRES.	TYPE	THK	REV	DATE	REVISION DESCRIPTION	DRAW	CHK	SUPP	PIPING	STRESS	MTO						








QUALITY LEVEL	VT	RT/UT	MT/PT
B	100	5	SEE NOTE

INSPECTION OF PIPELINE CIRCUMFERENTIAL WELD



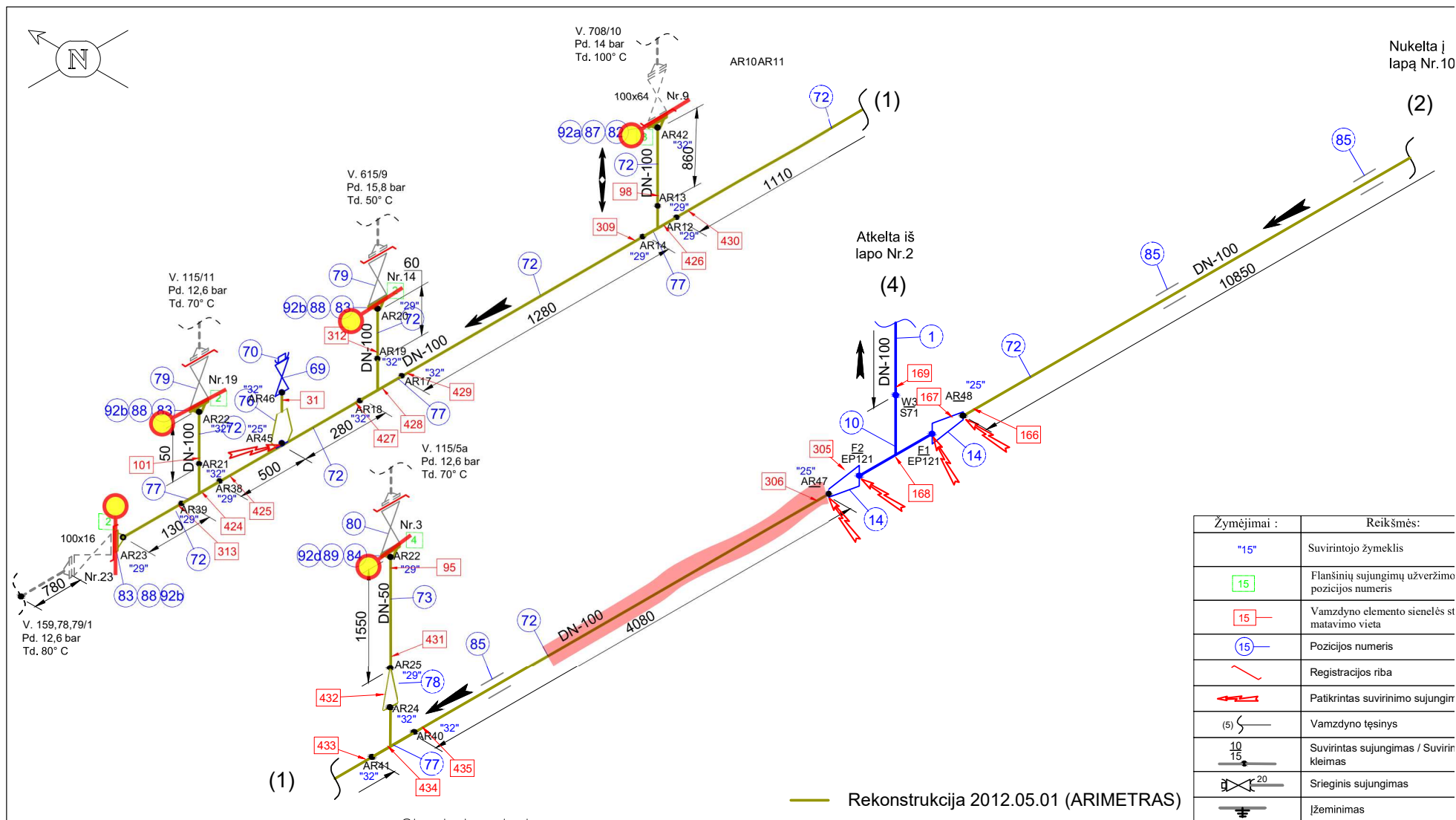
LEGEND



-  TIE-IN
-  NEW LINE
-  EXISTING LINE
-  DISMANTLING LINE
-  REUSED LINE

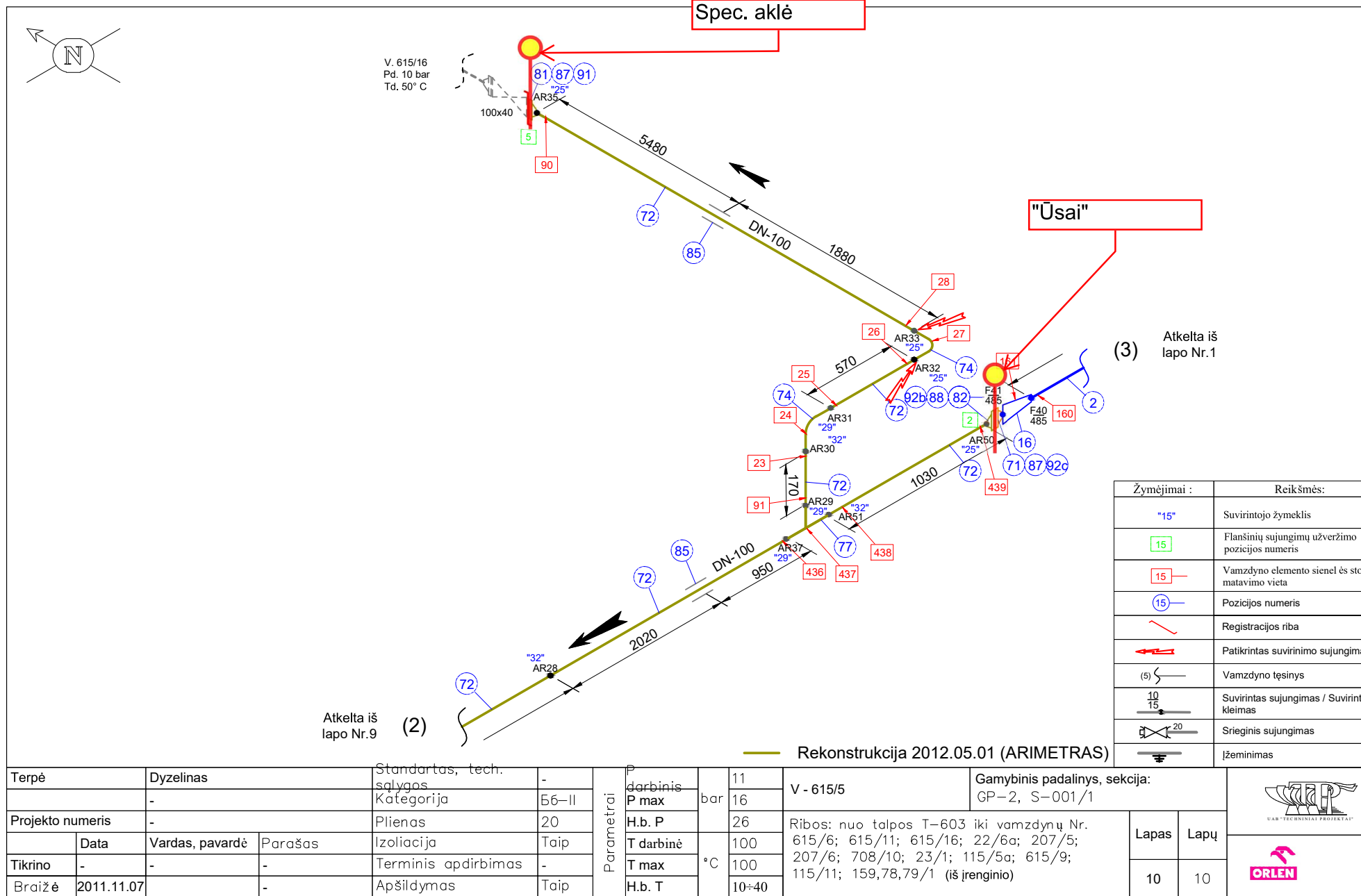


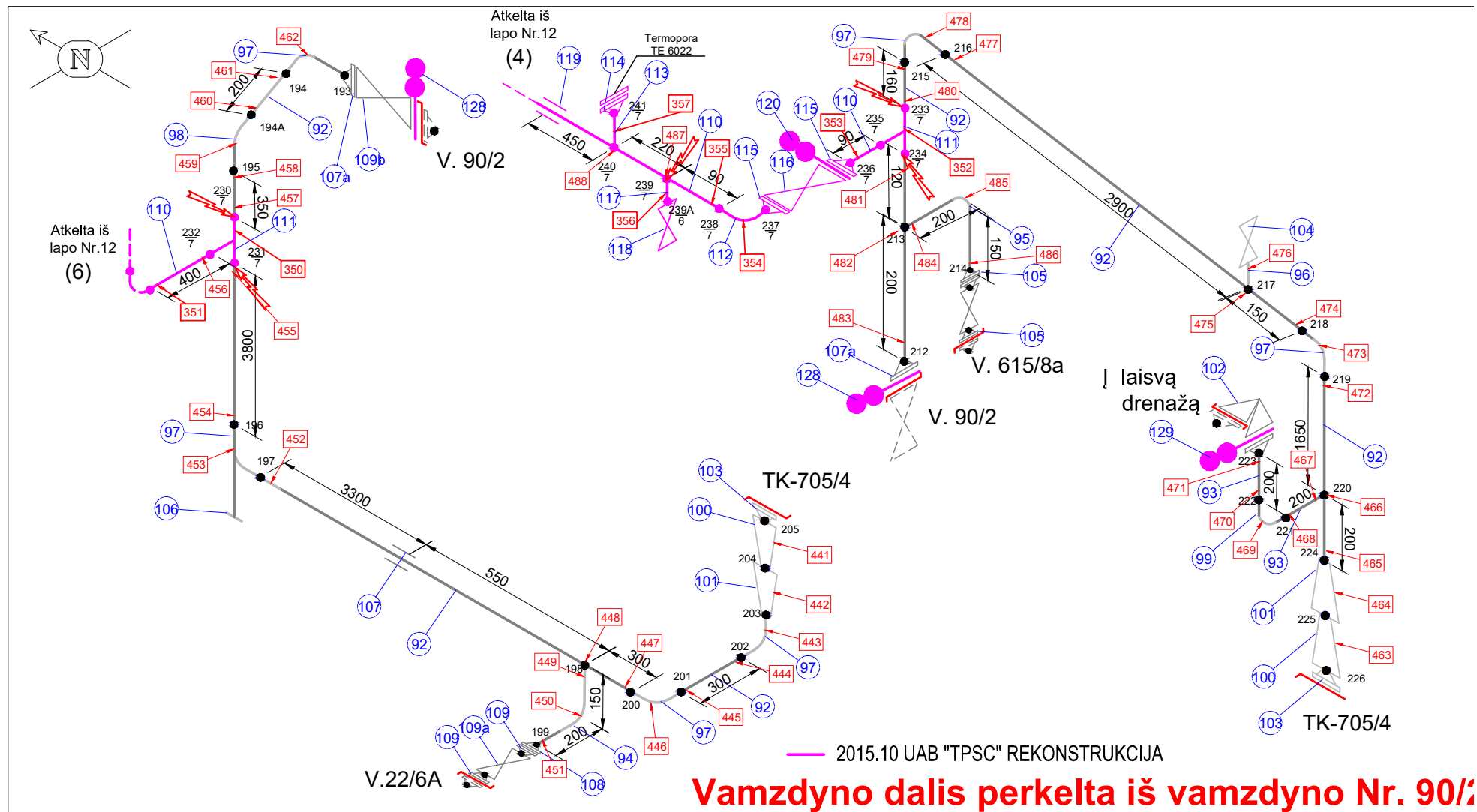
REVAMP VACUUM UNIT
MZK000A5



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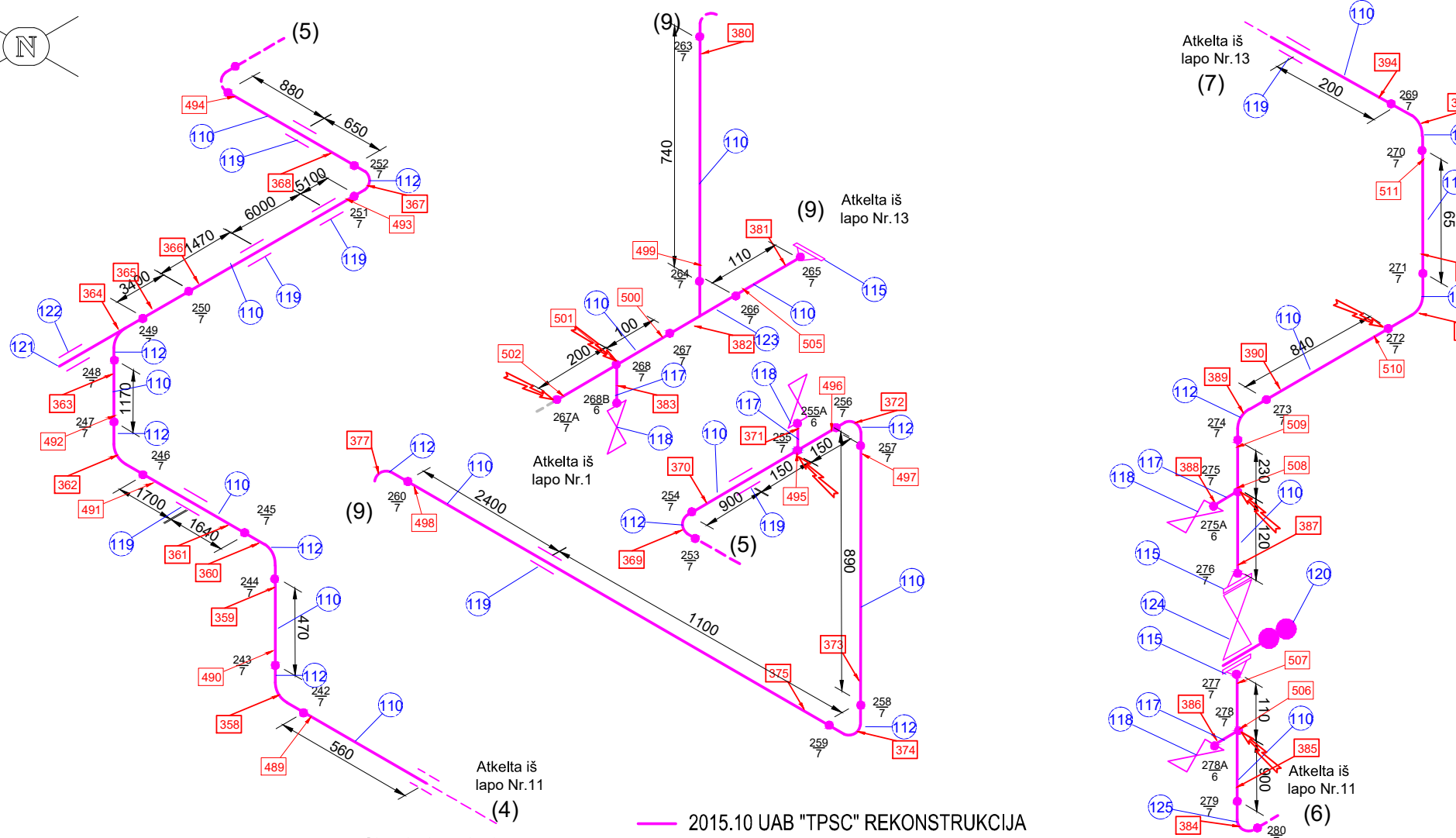
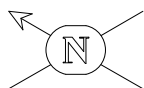
Terpė	Dyzelinas	Standartas, tech. sąlygos	-	Parametrai	P darbinis	11	V - 615/5	Gamybinis padalinys, sekcija:		
	-	Kategorija	66-II	P max	bar	16		GP-2, S-001/1		
Projekto numeris	-	Plienai	20	H.b. P		26	Ribos: nuo talpos T-603 iki vamzdynų Nr. 615/6; 615/11; 615/16; 22/6a; 207/5; 207/6; 708/10; 23/1; 115/5a; 615/9; 115/11; 159,78,79/1 (iš įrenginio)	Lapas	Lapų	
Tikrino	-	Vardas, pavardė	Parašas	Izoliacija	Taip	100		9	10	
Braižė	2011.11.07	-	-	Terminis apdirbimas	-	100				
		-	-	Apšildymas	Taip	10÷40				



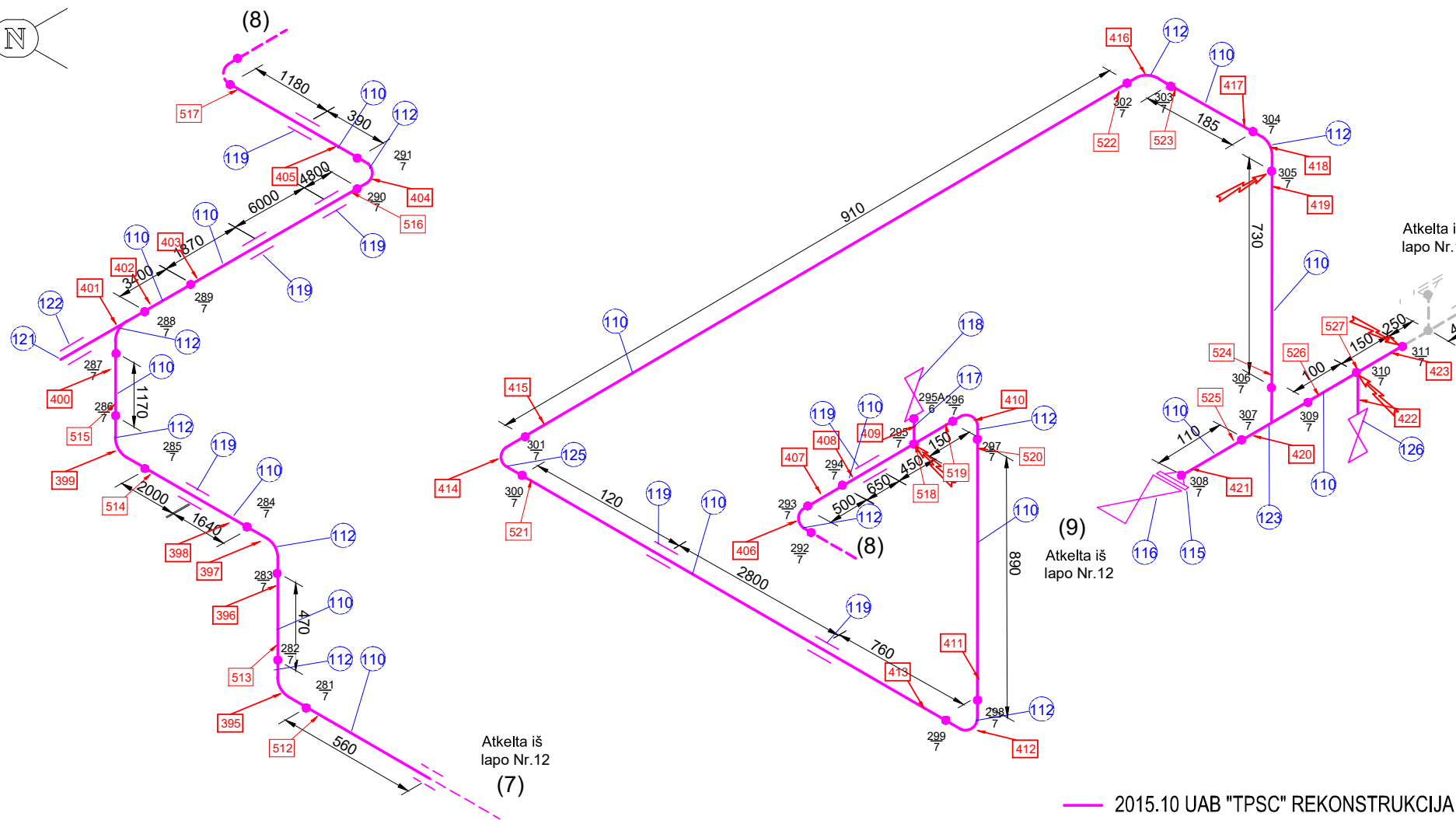
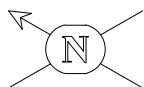


Terpė		Dyzelinas		Standartas, tech. sąlygos		-	Parametrai	P darbinis	bar	11	V - 615/5	Gamybinis padalinys, sekcija: GP–2, S–001/1			
		-		Kategorija	B6–II	P max		16							
Projekto numeris		-		Plienias	20	H.b. P		26	Ribos: nuo talpos T–603 iki vamzdinių Nr. 615/6; 615/11; 615/16; 22/6a; 207/5; 207/6; 708/10; 23/1; 115/5a; 615/9; 115/11; 159,78,79/1 (iš įrenginio)		Lapas	Lapų			
	Data	Vardas, pavardė	Parašas	Izoliacija	Taip	T darbinė		100			*C	100	11		13
Tikrino	-	-	-	Terminis apdirbimas	-	T max		100				H.b. T			
Braižė	2011.11.07		-	Apšildymas	Taip										





Terpė		Dyzelinas		Standartas, tech. sąlygos		-	Parametrai	P darbinis	bar	11	V - 615/5		Gamybinis padalinys, sekcija: GP–2, S–001/1			
		-		Kategorija		B6–II		P max		16						
Projekto numeris		-		Plienas		20		H.b. P	26	Ribos: nuo talpos T–603 iki vamzdinių Nr. 615/6; 615/11; 615/16; 22/6a; 207/5; 207/6; 708/10; 23/1; 115/5a; 615/9; 115/11; 159,78,79/1 (iš įrenginio)		Lapas	Lapų			
	Data	Vardas, pavardė	Parašas	Izoliacija	Taip	T darbinė		95								
Tikrino		-	-	-	Terminis apdirbimas	-		T max	100							
Braižė	2011.11.07	-		Apšildymas		Taip	H.b. T	10÷40			12	13				



Terpė		Dyzelinas		Standartas, tech. sąlygos		-	Parametrai	P darbinis	bar	11	V - 615/5		Gamybinis padalinys, sekcija: GP–2, S–001/1		
		-		Kategorija		E6–II		P max		16					
Projekto numeris		-		Plienas		20		H.b. P	26	Ribos: nuo talpos T–603 iki vamzdynų Nr. 615/6; 615/11; 615/16; 22/6a; 207/5; 207/6; 708/10; 23/1; 115/5a; 615/9; 115/11; 159,78,79/1 (iš įrenginio)		Lapas	Lapų		
	Data	Vardas, pavardė	Parašas	Izoliacija	Taip	T darbinė		100							
Tikrino		-	-	Terminis apdirbimas	-	T max		100							
Braižė		2011.11.07	-	Apšildymas	Taip	H.b. T		10÷40			13	13			

