

Nukelta į
lapą Nr.10

(3)

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

INSPECTION OF PIPELINE CIRCUMFERENTIAL WELD



810 DISTANCE BETWEEN WELDS



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.

10	100	114.3	FWI-005	300	800	2	1
9	100	114.3	FWI-005	340		1	1
8	100	114.3	FWI-005	340		1	1
7	100	114.3	FWI-005	340		1	1
6	80	88.9	IS-240	A		1	1
5	80	88.9	FWI-005	1140		1	1
4	80	88.9	FWI-005	700		1	1
3	100	114.3	FWI-002	100	300	7	1
2	100	114.3	FWI-002	100	300	4	1
1	100	114.3	FWI-002	100	300	1	1
No.	DN	O.D.	Port	WPE	H	V	Z
Description							
UNIT							
G-ty Unit							
Photo/Notes							

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

MINIMUM ALLOWABLE WALL THK.				INSULATION			
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HEATING	WT	MATERIAL	CS	CLASS
CODES	PED, ASME B31.3			

PIPING LAYOUT DWG. NO.	10
P&I DIAGRAM NO.	GP2-S001/1-20
BILL OF MATERIAL NO.	BD0314A-57-0208/0209/0210/0216/0219/0220-603-64-PK-615/5
INSPECTION BY	WT
CLASS ACC. TO PED	1-1

0 AS BUILT, FOR PASSPORT DOC. ONLY

REV. REVISION DESCRIPTION

0 T. Nawrocki R. Tokarczyk K. Radomski

REV. PREPARED BY SIGN CHECKED BY SIGN APPROVED BY

INVESTOR: AB MAZEKU NAFTA
PLANT: VACUUM UNIT

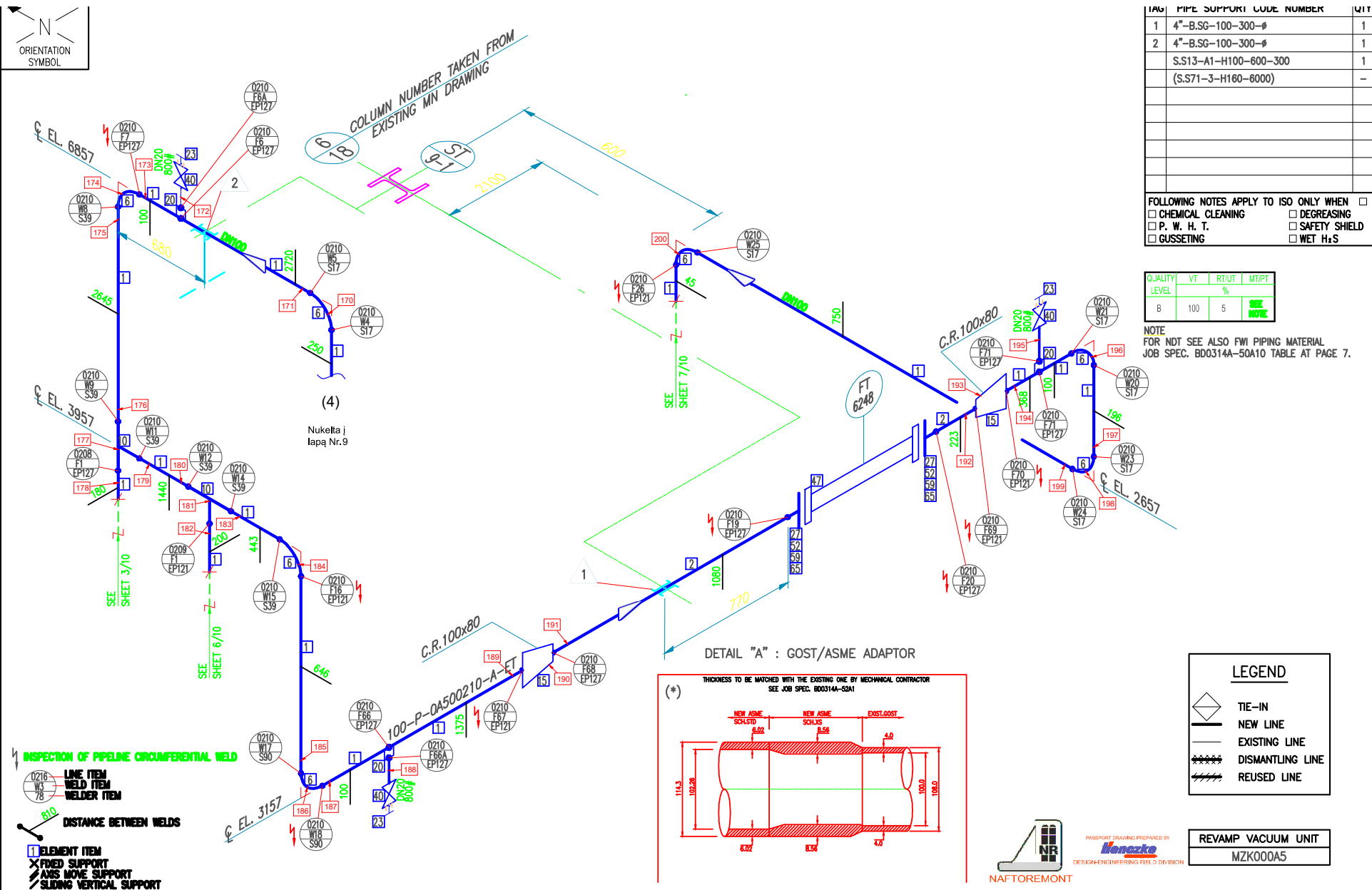
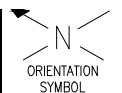
PROJECT: VACUUM UNIT REBUILDING
TITLE:


LINE NO.: 615/5

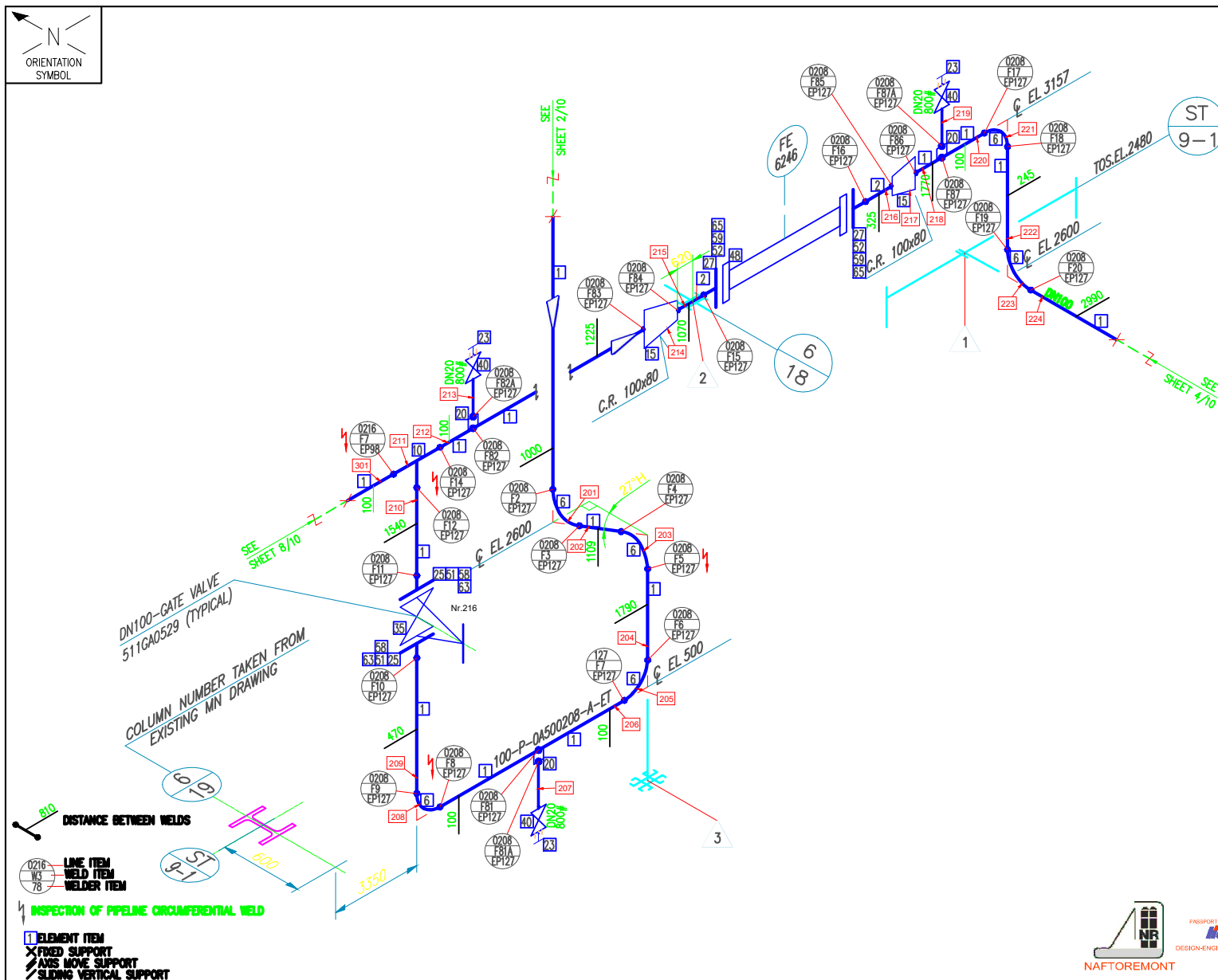


NAFTOREMONT		SHEET SHEE	
SIZE	ISO. NO.	01	13
AS	BD0314A-57-0208/0209/0210/0216/0219/0220-615/5 603-64-PK-615/5		

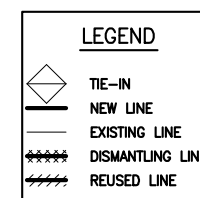
- Rekonstrukcija 2007.11.21 (naftoremont)
- Rekonstrukcija 2000.10.12 (iremas)
- Rekonstrukcija 2000.10.11 (TSK)



										0	01-2008	AS BUILT. FOR PASSPORT DOC. ONLY	T.N.	D.K.						APPROVED FOR CONSTRUCTION	FW CONTRACT: 1-BD-0314A		<div></div> <div>KT MODERNIZATION PROGRAM</div>	
										S03	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 WERE 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													<div><div>SHEET</div><div>02</div></div> <div><div>SHEETS</div><div>13</div></div>	<div>N - BD0314A-57-0208/0209/0210/0216/0219/0220-615/5 603-64-PX-615/5</div>	REV. 0
SIZE	LINE N°.	SPEC.	TURN. SYS	OPER. TEMP.	DES. TEMP.	DES. PRES.	TEST PRES.	TYPE INSULATION	THK	REV	DATE	REVISION DESCRIPTION	DRAW	CHKC	SUPP	PIPING	STRESS	MTO						



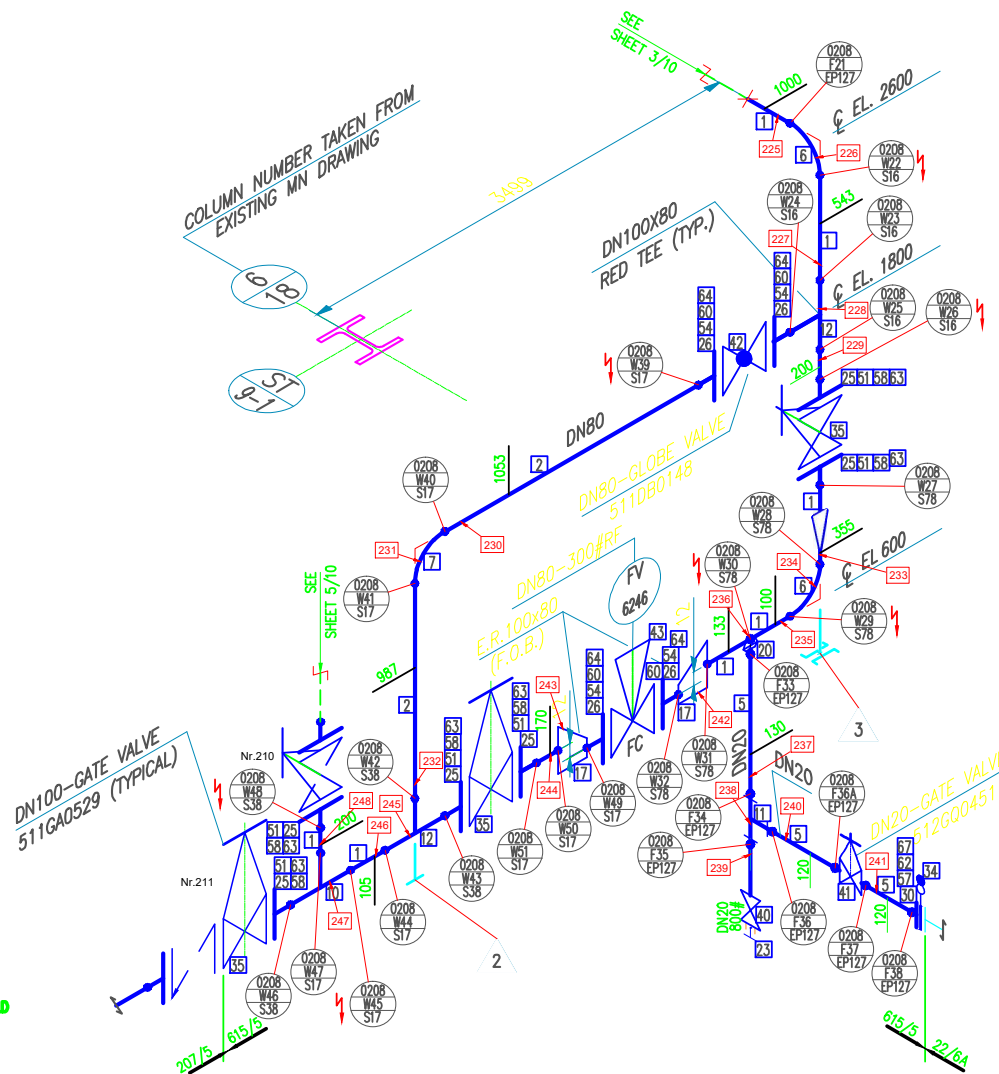
NOTE
FOR NDT SEE ALSO FWI PIPING MATERIAL
JOB SPEC. BD0314A-50A10 TABLE AT PAGE 7.



PASSPORT DRAWING PREPARED BY
Konezko
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 SH
<input type="checkbox"/> GUSSETING	<input type="checkbox"/> WET H ₂ S

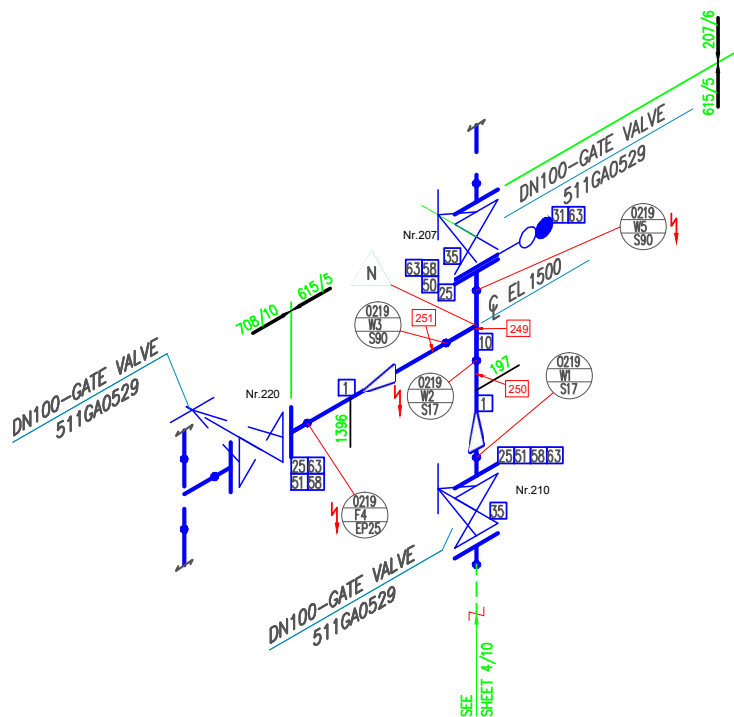
NOTE
FOR NDT SEE ALSO FWI PIPING MATERIAL
JOB SPEC. BD0314A-50A10 TABLE AT PAGE :

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



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		
										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												<div><div>SHEET</div><div>04</div></div>	<div><div>SHEETS</div><div>13</div></div>	N° 8003144-57-0208/0209/0210/0216/0219/0220-615/5 RE
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					



INSPECTION OF PIPELINE CIRCUMFERENTIAL WELD



DISTANCE BETWEEN WELDS

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

[illegible]

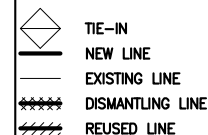
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<input type="checkbox"/> P. W. H. T.	<input type="checkbox"/> SAFETY SHIE
<input type="checkbox"/> GUSSETING	<input type="checkbox"/> WET H ₂ S

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

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

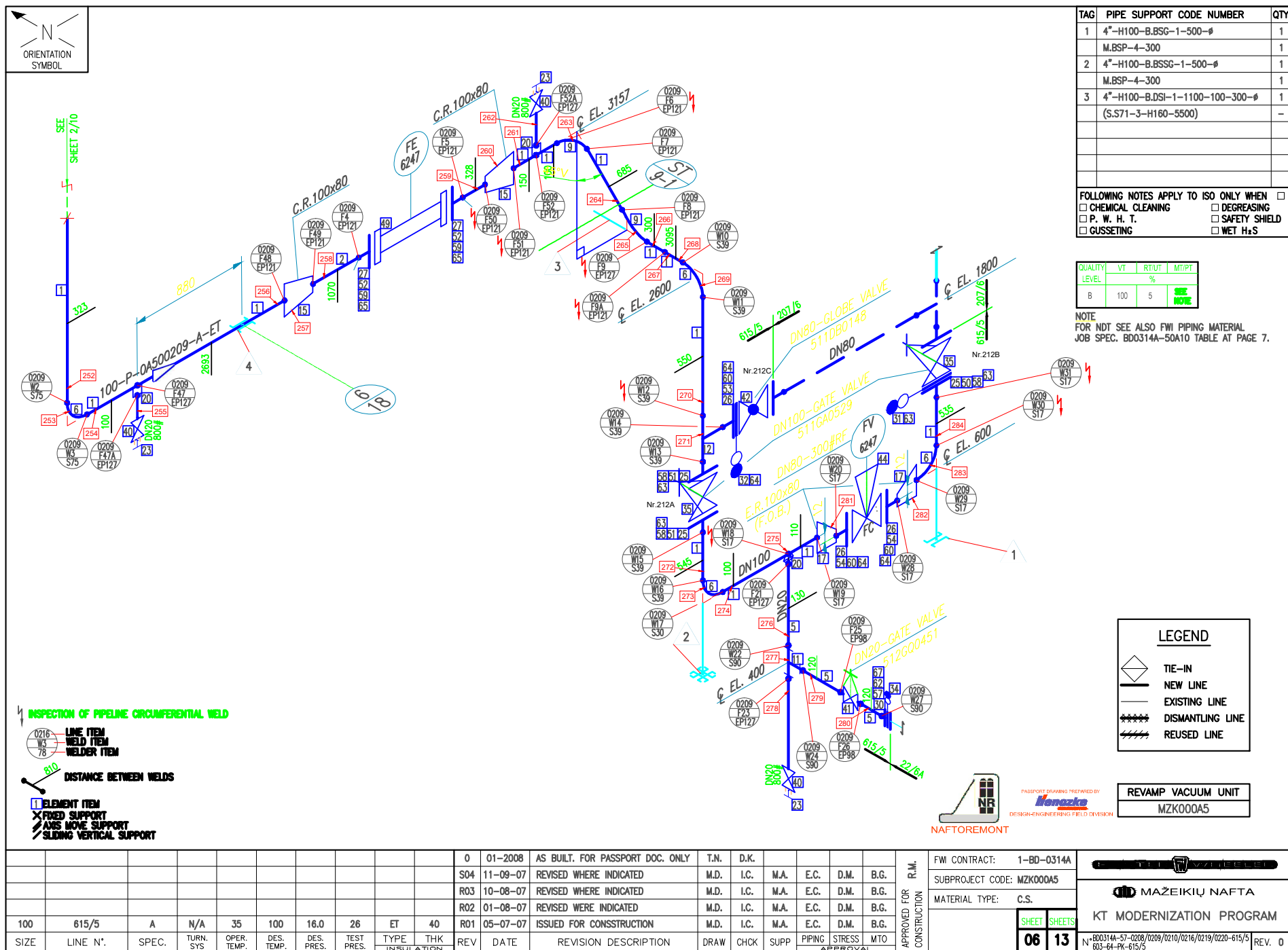
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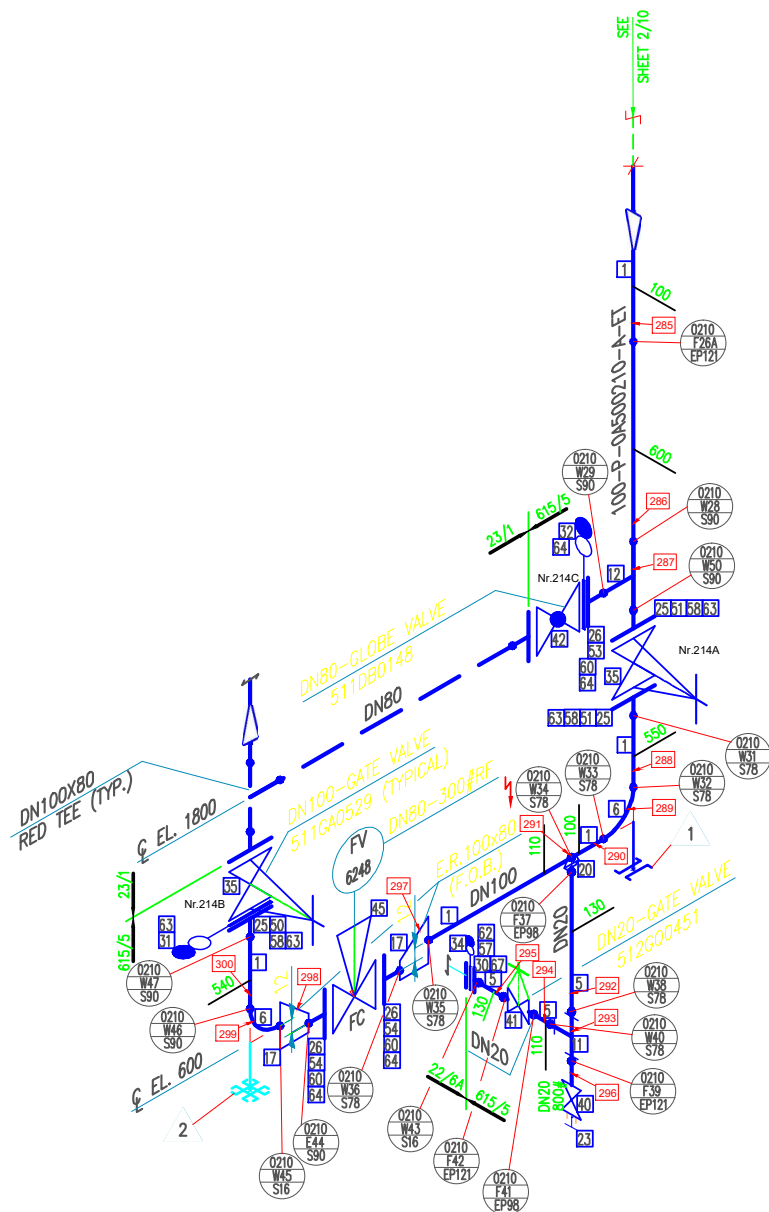


PASSPORT DRAWING PREPARED BY
henczko
DESIGN-ENGINEERING FIELD DIVISION

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
FOR NDT SEE ALSO FWI PIPING MATERIAL
JOB SPEC. BDO314A-50A10 TABLE AT PAGE 7.

NOTE
FOR NDT SEE ALSO FWI PIPING MATERIAL
JOB SPEC. BDO314A-50A10 TABLE AT PAGE 7.



REVAMP VACUUM UNIT
MZK000A5

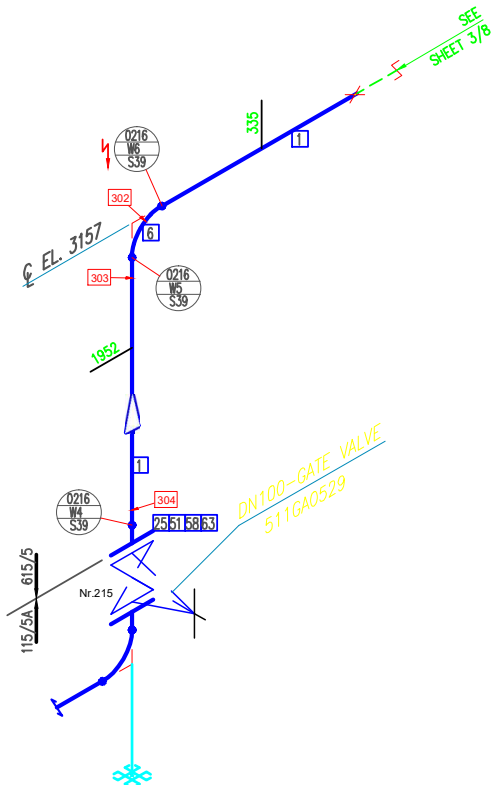
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									S04	14-08-07	REVISED WITHOUT HOLD	M.D.	I.C.	M.A.	C.E.	D.M.	B.G.		SUBPROJECT CODE: MZK000A5		KT MODERNIZATION PROGRAM		
									R03	06-08-07	REVISED WHERE INDICATED	M.D.	I.C.	M.A.	E.C.	D.M.	B.G.		MATERIAL TYPE: C.S.				
									R02	01-08-07	REVISEDWHERE 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	R01	05-07-07	ISSUED FOR CONSRUCTION	G.M.	I.C.	M.A.	E.C.	D.M.	B.G.			<div>SHEET SHEETS</div>		
SIZE	LINE N°.	SPEC.	TURN. SYS	OPER. TEMP.	DES. TEMP.	DES. PRES.	TEST PRES.	TYPE INSULATION	THK	REV	DATE	REVISION DESCRIPTION	DRAW	CHK	SUPP	PIPING	STRESS	MTO			<div>07 13</div>		

N°

B00314A-57-0208/0209/0210/0216/0219/0220-615/5

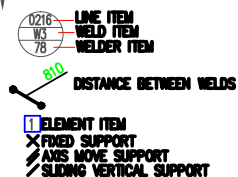
REV.

603-R4-PK-615/5








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

4 INSPECTION OF PIPELINE CIRCUMFERENTIAL WELD



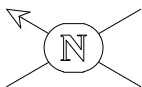
LEGEND

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

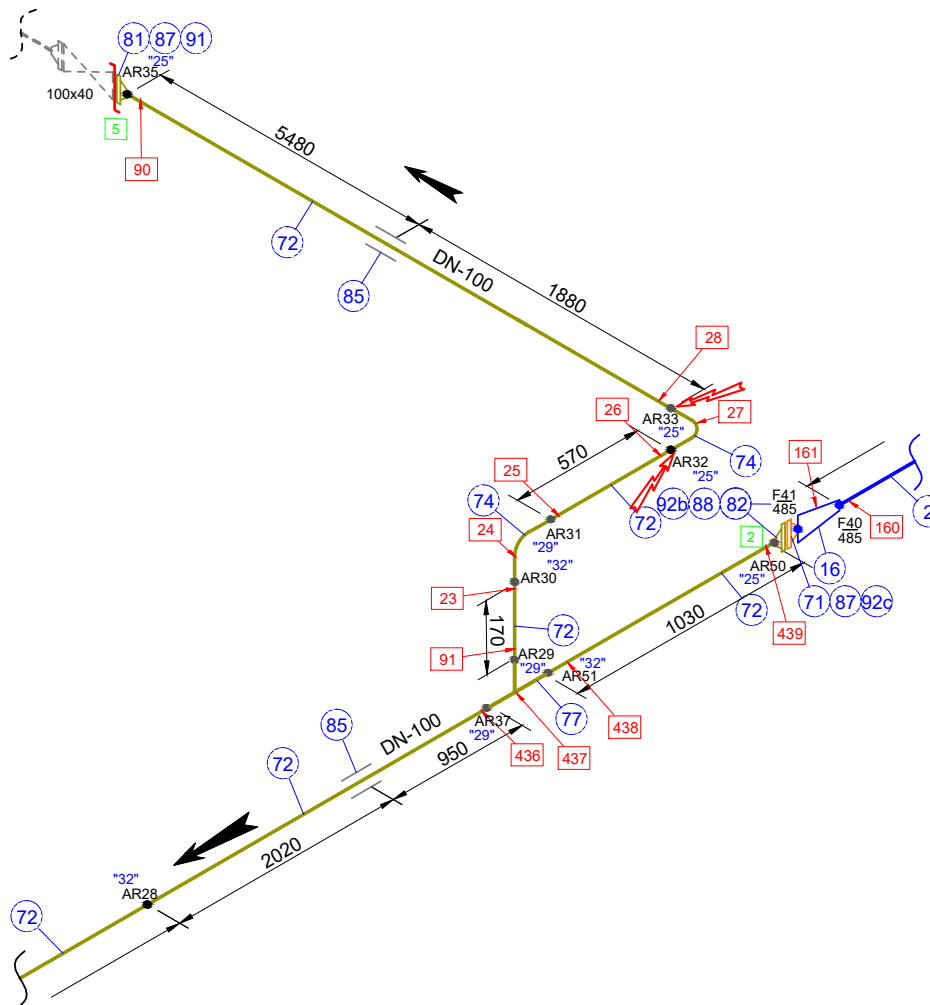


REVAMP VACUUM UNIT
MZK000A5

[illegible]



V. 615/16
Pd. 10 bar
Td. 50° C




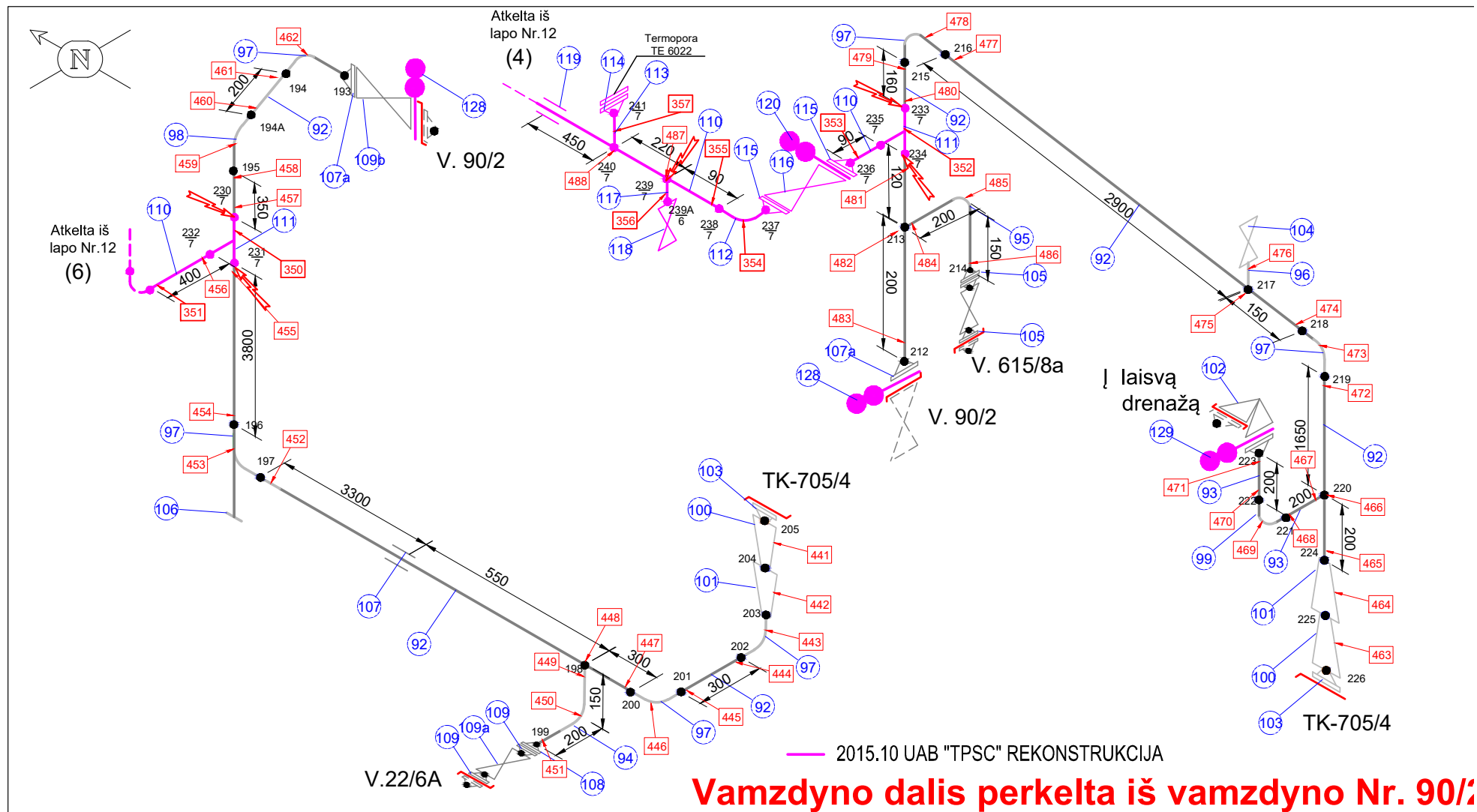
Atkelta iš
lapo Nr.9 (2)



(3) Atkelta iš
lapo Nr.1

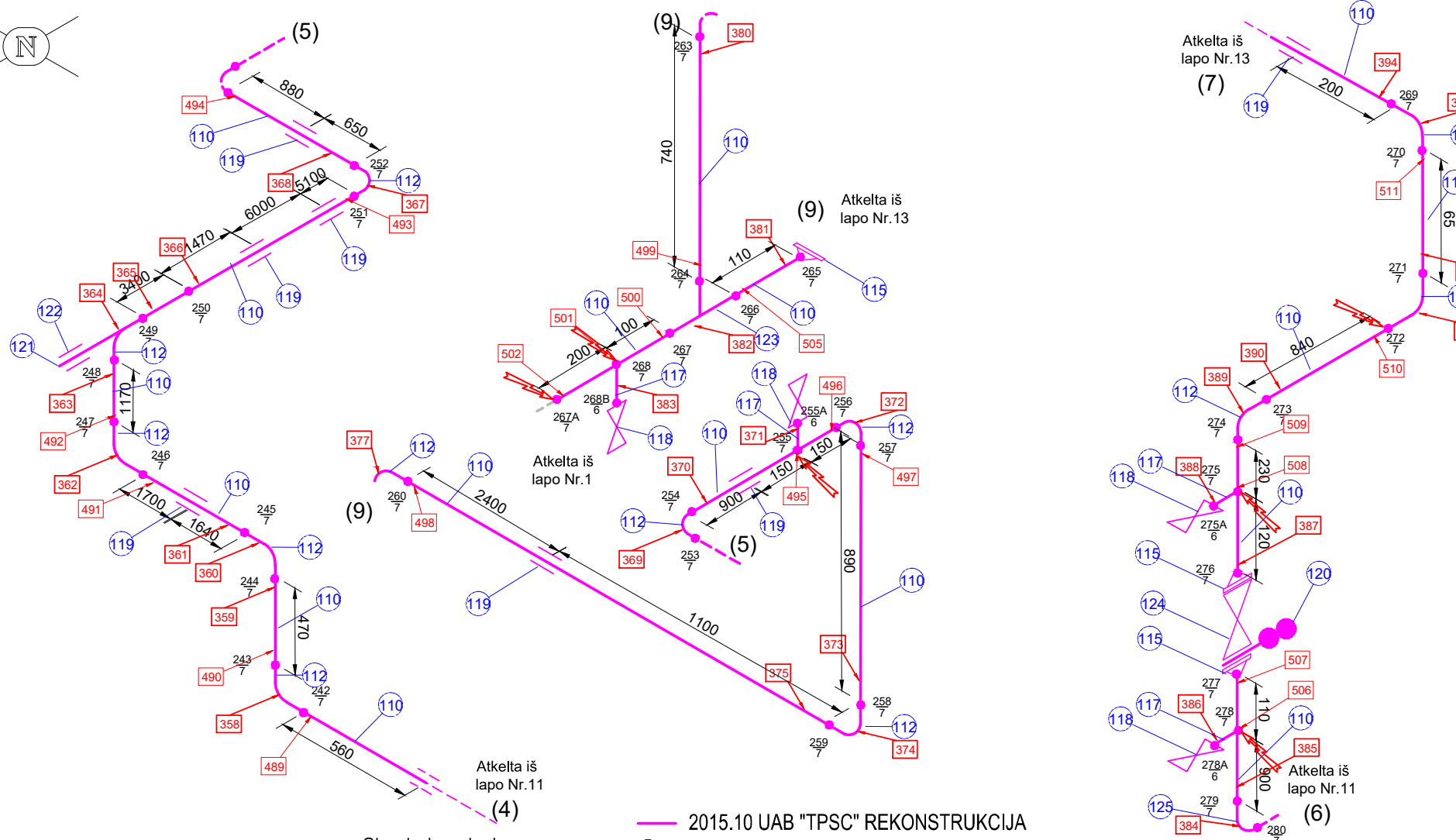
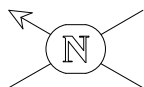
Žymėjimai :	Reikšmės:
"15"	Suvirintojo žymeklis
15	Flanšinių sujungimų užveržimo pozicijos numeris
15	Vamzdyno elemento sienelės sto matavimo vieta
15	Pozicijos numeris
	Registracijos riba
	Patikrintas suvirinimo sujungimas
(5)	Vamzdyno tęsinys
10 15	Suvirintas sujungimas / Suvirint kleimas
20	Srieginis sujungimas
	Ižeminimas

Rekonstrukcija 2012.05.01 (ARIMETRAS)

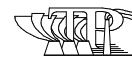

Terpė		Dyzelinas		Standartas, tech. sąlygos		-	Parametrai	P darbinis	bar	11	V - 615/5	Gamybinis padalinys, sekcija: GP-2, S-001/1			
				Kategorija		B6-II		P max		16					
Projekto numeris		-		Plienas		20		H.b. P	26	Ribos: nuo talpos T-603 iki vamzdinių Nr. 615/6; 615/11; 615/16; 22/6a; 207/5; 207/6; 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		100	°C				100	10	
Tikrino	-	-	-	Terminis apdirbimas	-	T max		100							
Braižė	2011.11.07		-	Apšildymas	Taip	H.b. T		10÷40							



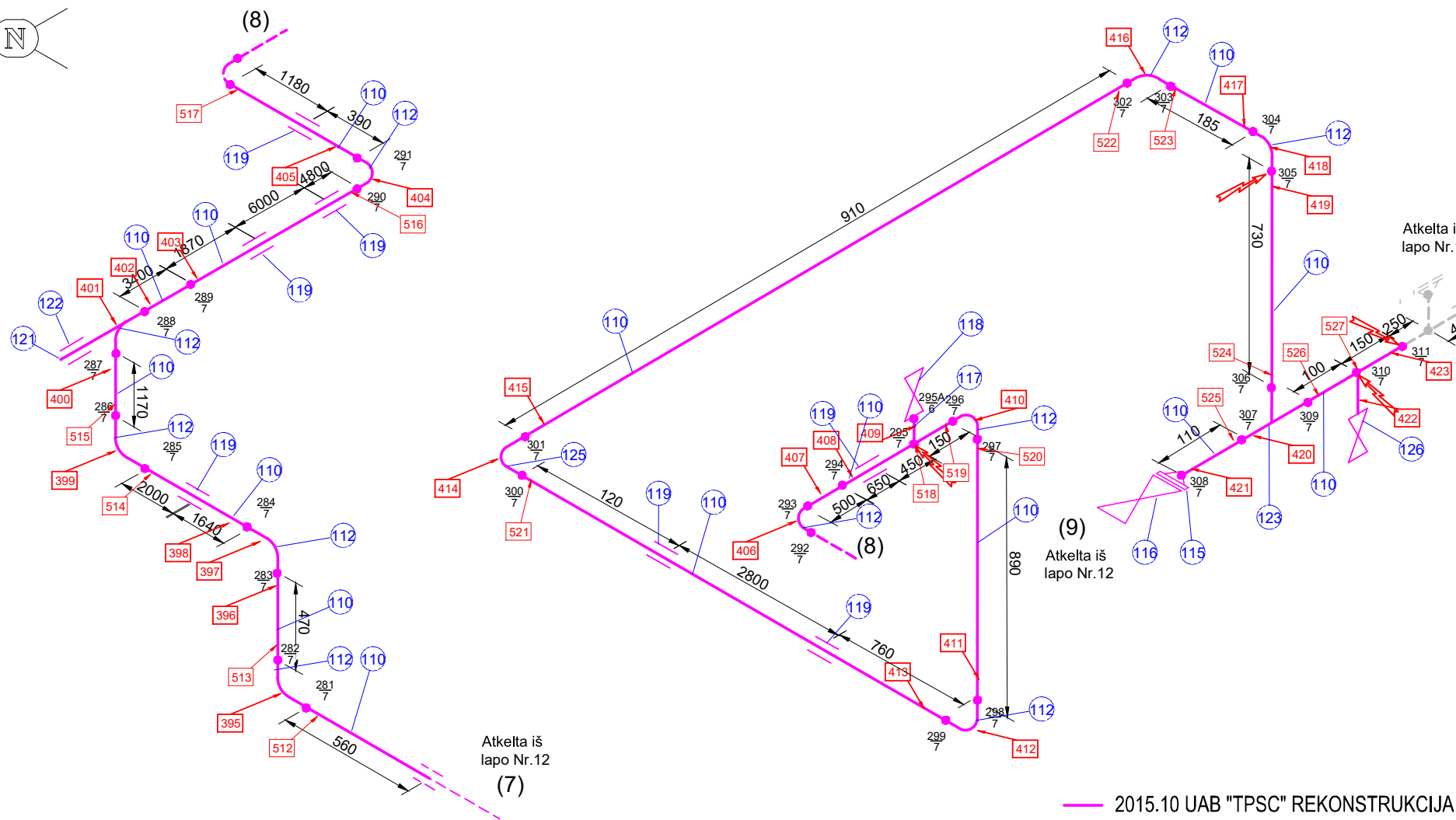
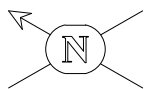
Terpė		Dyzelinas		Standartas, tech. sąlygos		-	Parametrai	P darbinis	bar	11	V - 615/5	Gamybinis padalinys, sekcija: GP–2, S–001/1		
		-		Kategorija	B6–II	16								
Projekto numeris		-		Plienias	20	H.b. P		26	Ribos: nuo talpos T–603 iki vamzdinių Nr. 615/6; 615/11; 615/16; 22/6a; 207/5; 207/6; 708/10; 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						
Tikrino	-	-	-	Terminis apdirbimas	-	T max		100			*C	10÷40		
Braižė	2011.11.07		-	Apšildymas	Taip	H.b. T		11	13					




— 2015.10 UAB "TPSC" REKONSTRUKCIJA

Terpė		Dyzelinas		Standartas, tech. sąlygos		-	Parametrai	P darbinis P max H.b. P T darbinė T max H.b. T	bar	11	V - 615/5	Gamybinis padalinys, sekcija: GP-2, S-001/1				
		-		Kategorija	B6-II	16										
Projekto numeris		-		Plienas	20	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	95							12	13		
Tikrino	-	-	-	Terminis apdirbimas	-	100										
Braižė	2011.11.07		-	Apšildymas	Taip	10÷40										

ORLEN



Terpė		Dyzelinas		Standartas, tech. sąlygos		-	Parametrai	P darbinis		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 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				
Tikrino		-	-	-	Terminis apdirbimas	-		T max		100							
Braižė		2011.11.07		-	Apšildymas	Taip		H.b. T		10÷40						13	13

