

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			IS-013	A		600			2		
9	100	114.3	PFO-005			300			1		
8	100	114.3	PFO-005			340			1		
7	100	114.3	PFO-005			340			1		
6	80	88.9	IS-010	A					1		
5	80	88.9	PFO-005			1140			1		
4	80	88.9	PFO-005			700			1		
3	100	114.3	PFO-002			100	300		7		
2	100	114.3	PFO-002			100	300		4		
1	100	114.3	PFO-002			100	300		1		
No.	DN	O.D.	Part Description	TYPE	H	V	X	Y	Z	Q-ty	Unit

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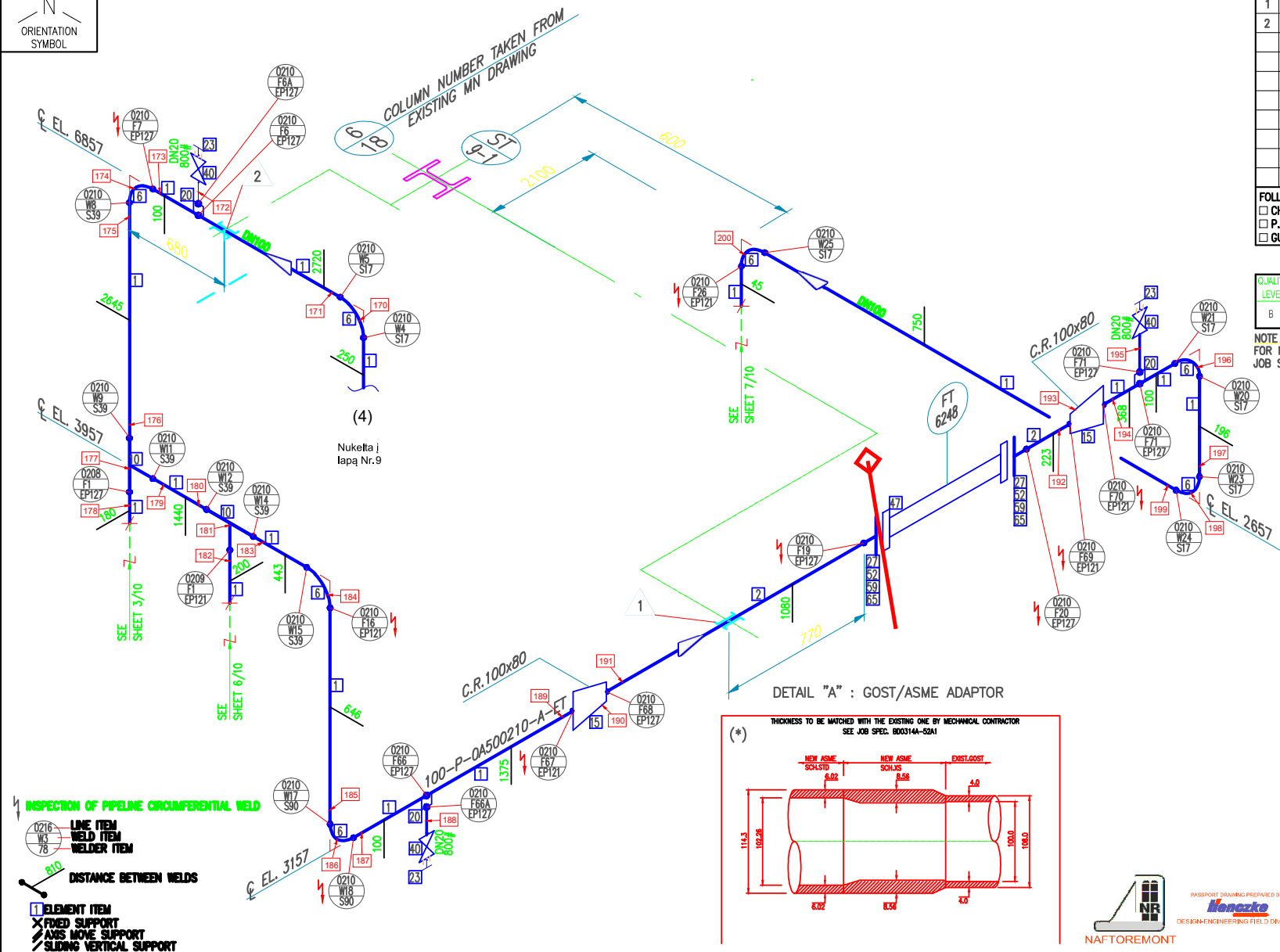
01	13
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TAG	PIPE SUPPORT CODE NUMBER	UNIT
1	4"-B.SG-100-300-Ø	1
2	4"-B.SG-100-300-Ø	1
	S.S13-A1-H100-600-300	1
	(S.S71-3-H160-6000)	-






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

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

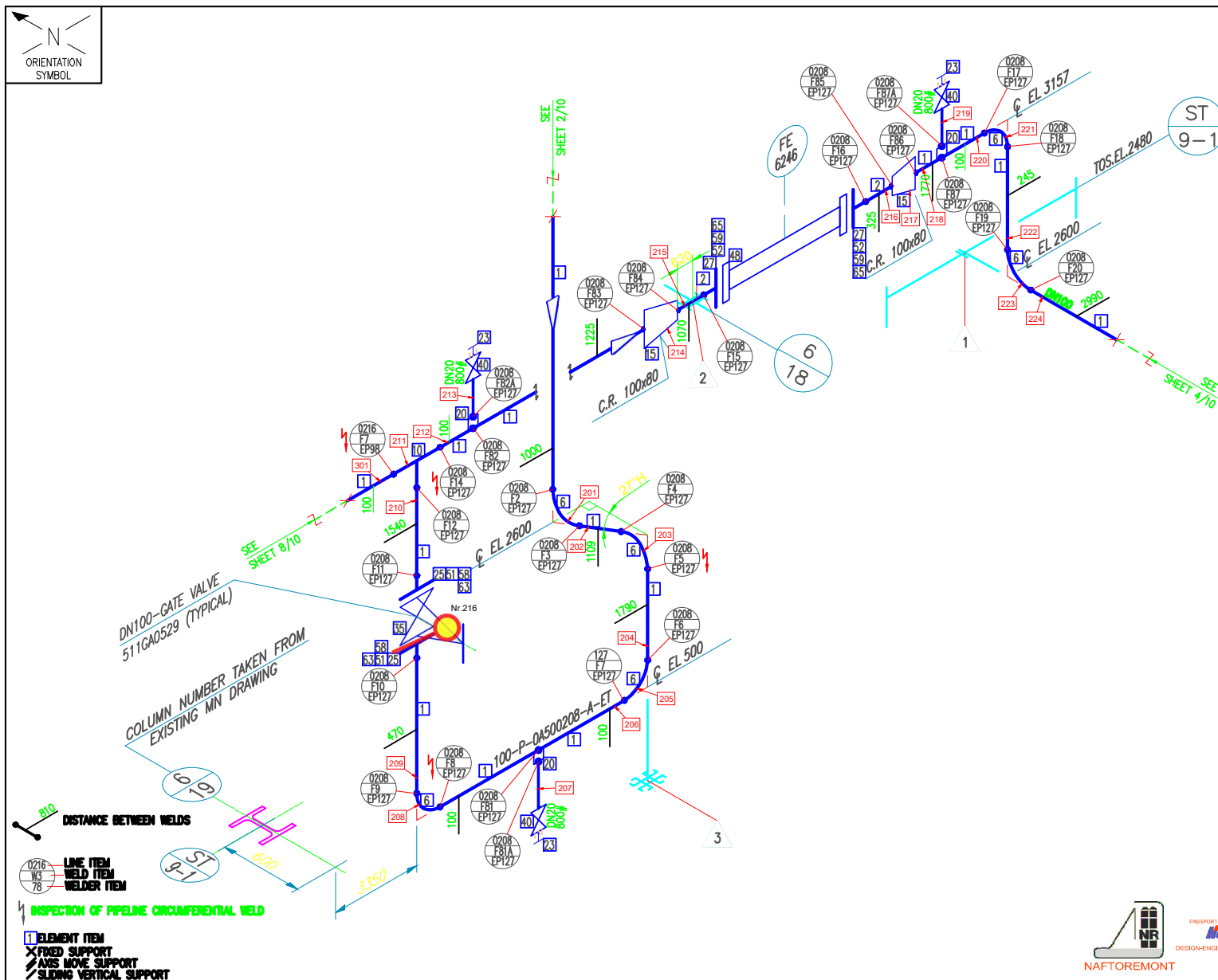
NOTE
FOR NDT SEE ALSO FWI PIPING MATERIAL
JOB SPEC. BD0314A-50A10 TABLE AT PAGE 7.

LEGEND

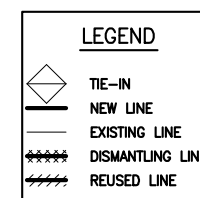
-  TIE-IN
-  NEW LINE
-  EXISTING LINE
-  DISMANTLING LINE
-  REUSED LINE

REVAMP VACUUM UNIT
MZK000A5

[illegible]

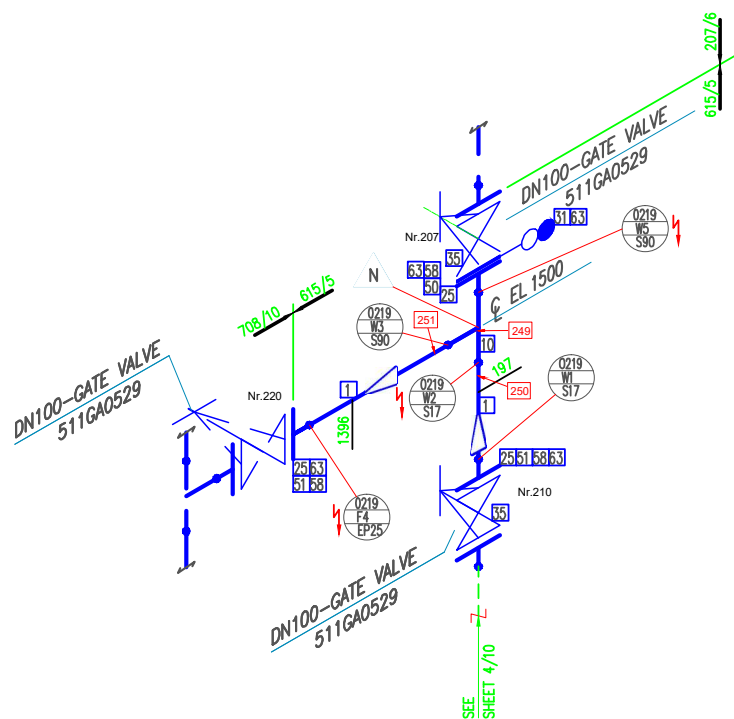
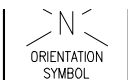


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JOB SPEC. BD0314A-50A10 TABLE AT PAGE 7.



REVAMP VACUUM UNIT
MZK000A5

[illegible]



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"/> 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 NOTE

NOTE
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LEGEND

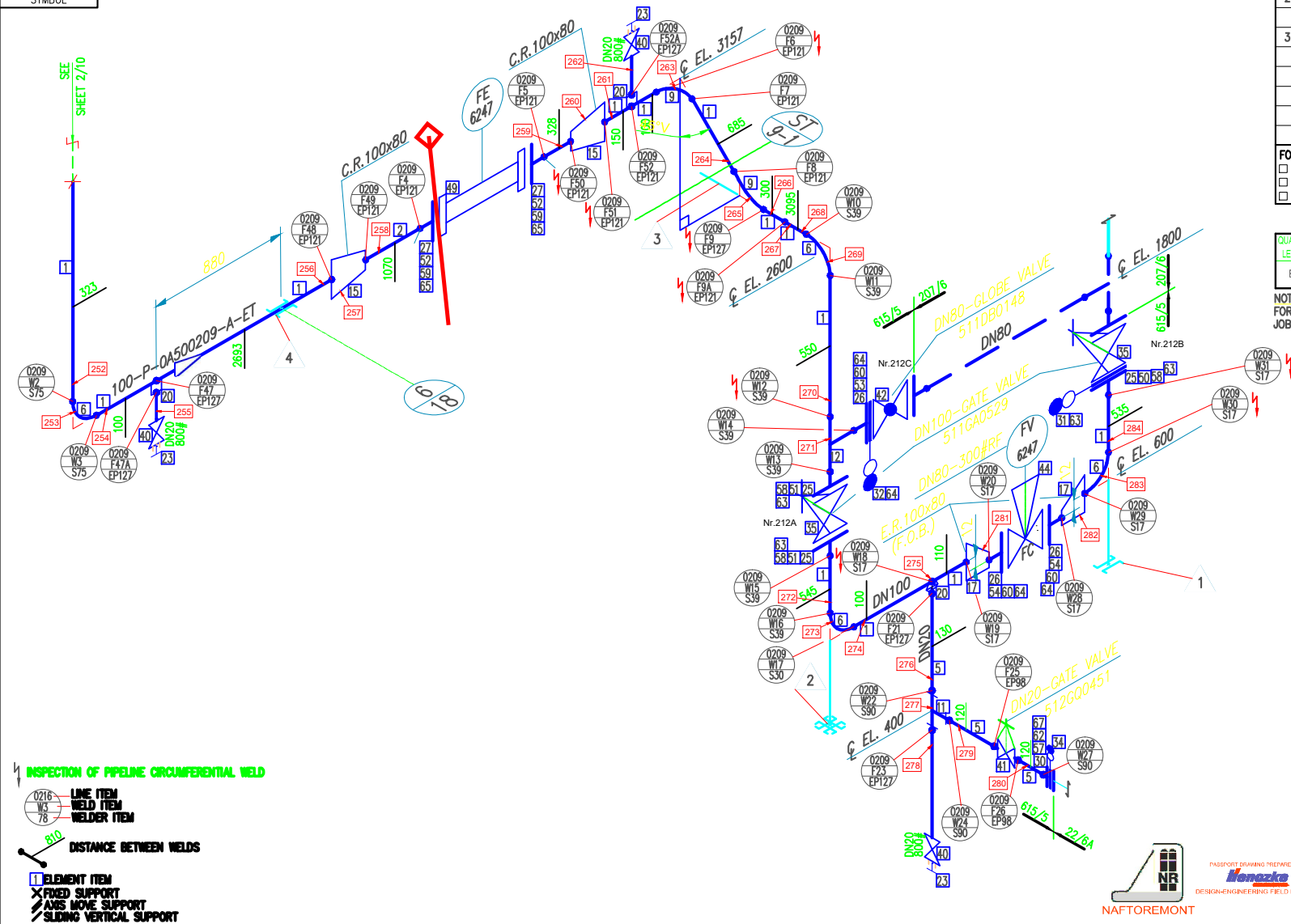
-  TIE-IN
-  NEW LINE
-  EXISTING LINE
-  DISMANTLING LINE
-  REUSED LINE



PASSPORT DRAWING PREPARED BY
henczo
DESIGN-ENGINEERING FIELD DIVISION

REVAMP VACUUM UNIT
MZK000A5

[illegible]

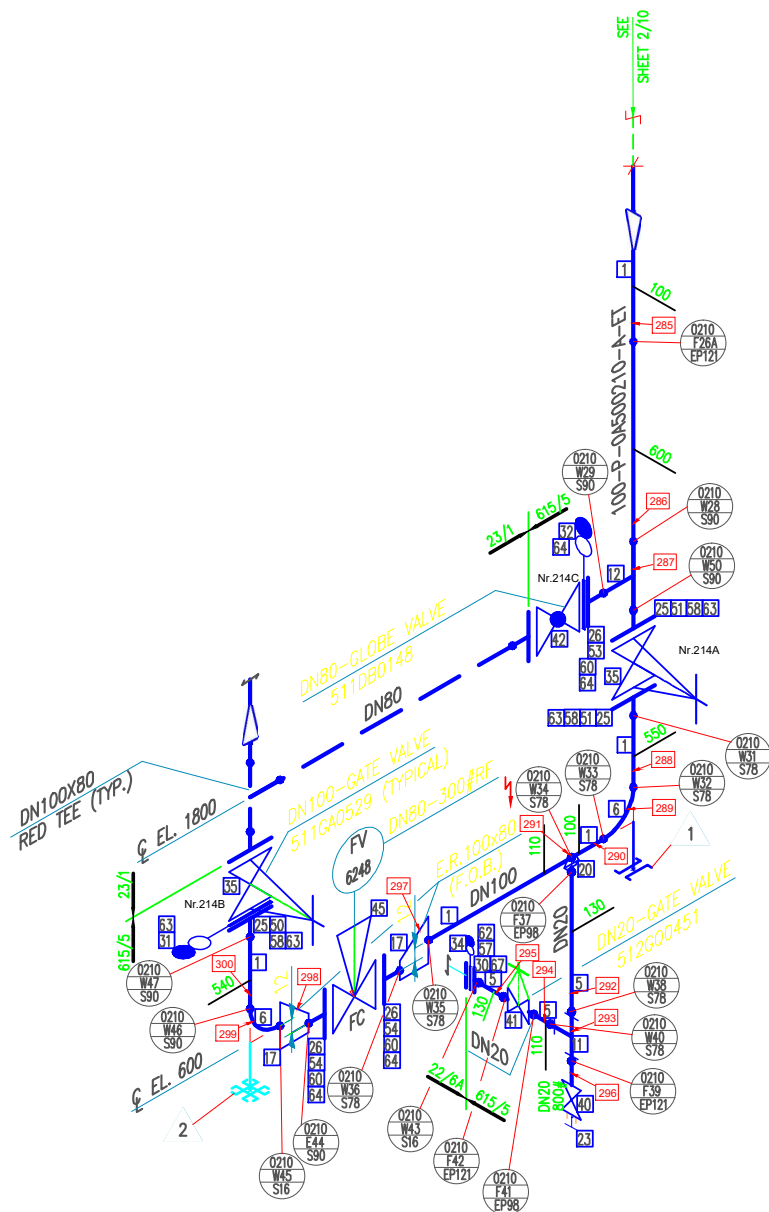


FOLLOWING NOTES APPLY TO ISO ONLY WHEN		<input type="checkbox"/>
<input type="checkbox"/> CHEMICAL CLEANING	<input type="checkbox"/> DEGREASING	
<input type="checkbox"/> P. W. H. T.	<input type="checkbox"/> SAFETY SHIELD	
<input type="checkbox"/> GUSSETING	<input type="checkbox"/> WET H ₂ S	

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

REVAMP VACUUM UNIT
MZK000A5

[illegible]



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

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




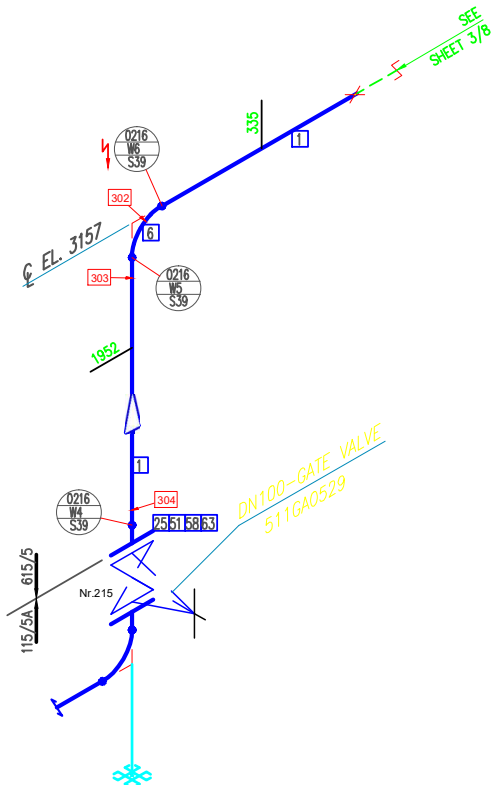
1 ELEMENT ITEM
X FIXED SUPPORT
/ AXIS MOVE SUPPORT
/ SLIDING VERTICAL SUPPORT



NAFTOREMONT

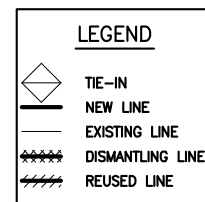
REVAMP VACUUM UNIT
MZK000A5

										0	01-2008	AS BUILT. FOR PASSPORT DOC. ONLY	T.N.	R.T.						APPROVED FOR CONSTRUCTION	FWI CONTRACT: 1-BD-0314A			KT MODERNIZATION PROGRAM	N° RD0314A-57-0208/0209/0210/0216/0219/0220-615/S 603-R4-PX-615/S	REV.
										S04	14-08-07	REVISED WITHOUT HOLD	M.D.	I.C.	M.A.	C.E.	D.M.	B.G.	SUBPROJECT CODE: MZK000A5							
										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.								
										R01	05-07-07	ISSUED FOR CONSTRUCTION	G.M.	I.C.	M.A.	E.C.	D.M.	B.G.								
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	PIPING	STRESS	MTG			<div><div>SHEET</div><div>SHEETS</div></div> <div>0713</div>					



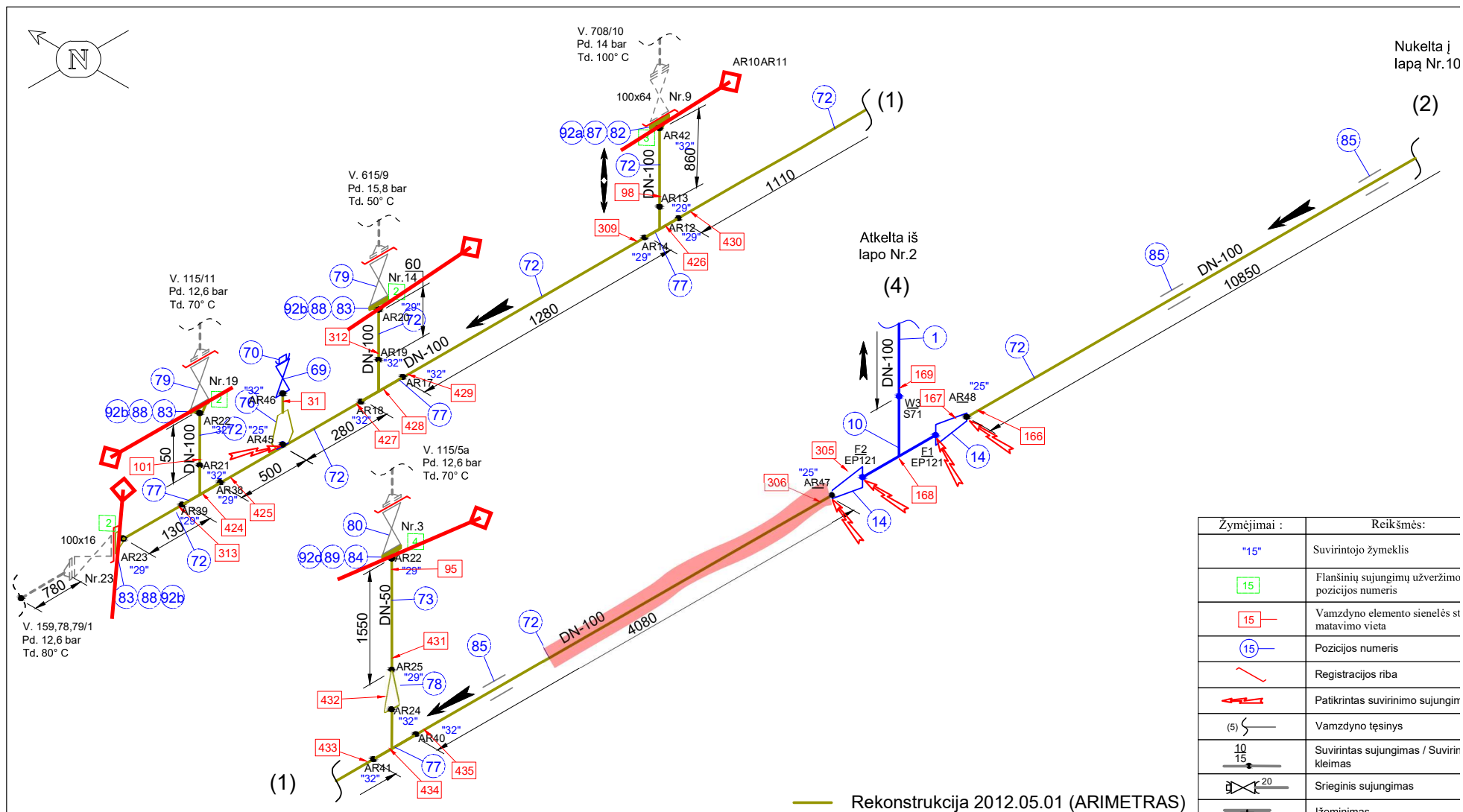
QUALITY LEVEL	VT	RT/UT	MT/PT
	%		
B	100	5	SEE NOTE



4 INSPECTION OF PIPELINE CIRCUMFERENTIAL WELD

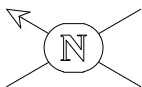


REVAMP VACUUM UNIT
MZK000A5

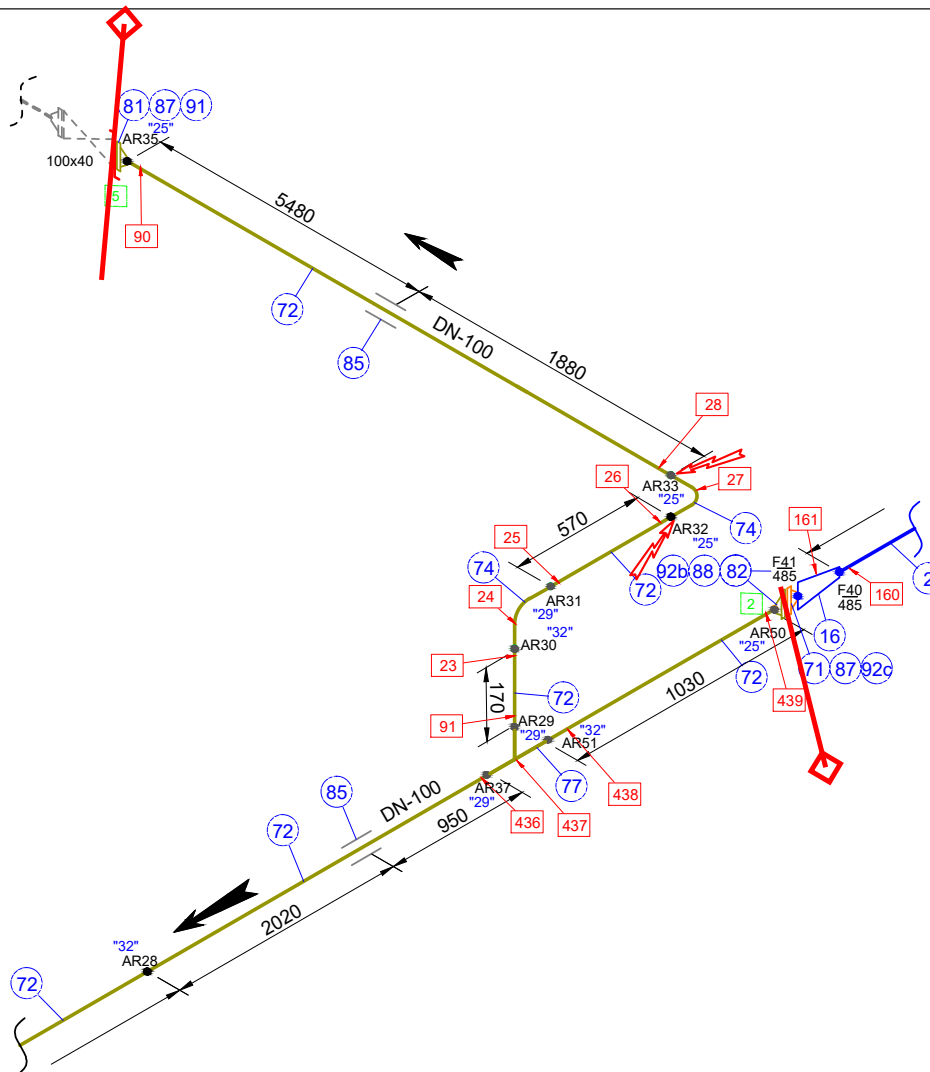
[illegible]



Terpė		Dyzelinas		Standartas, tech. sąlygos		-	Parametrai	P darbinis	11	V - 615/5	Gamybinis padalinys, sekcija: GP-2, S-001/1			<div></div> <div></div>	
		-	Kategorija	E6-II	P max	bar		16							
Projekto numeris		-	Plienas	20	H.b. P	26		°C	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		9	10					




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

Terpė		Dyzelinas		Standartas, tech. sąlygos		-	Parametrai	P darbinis	bar	11	V - 615/5		Gamybinis padalinys, sekcija: GP-2, S-001/1		 UAB "TECHNINIAI PROJEKTAI"		
				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	10
Tikrino	-	-	-	Terminis apdirbimas	-	T max		100									
Braižė	2011.11.07		-	Apšildymas	Taip	H.b. T		10÷40									

