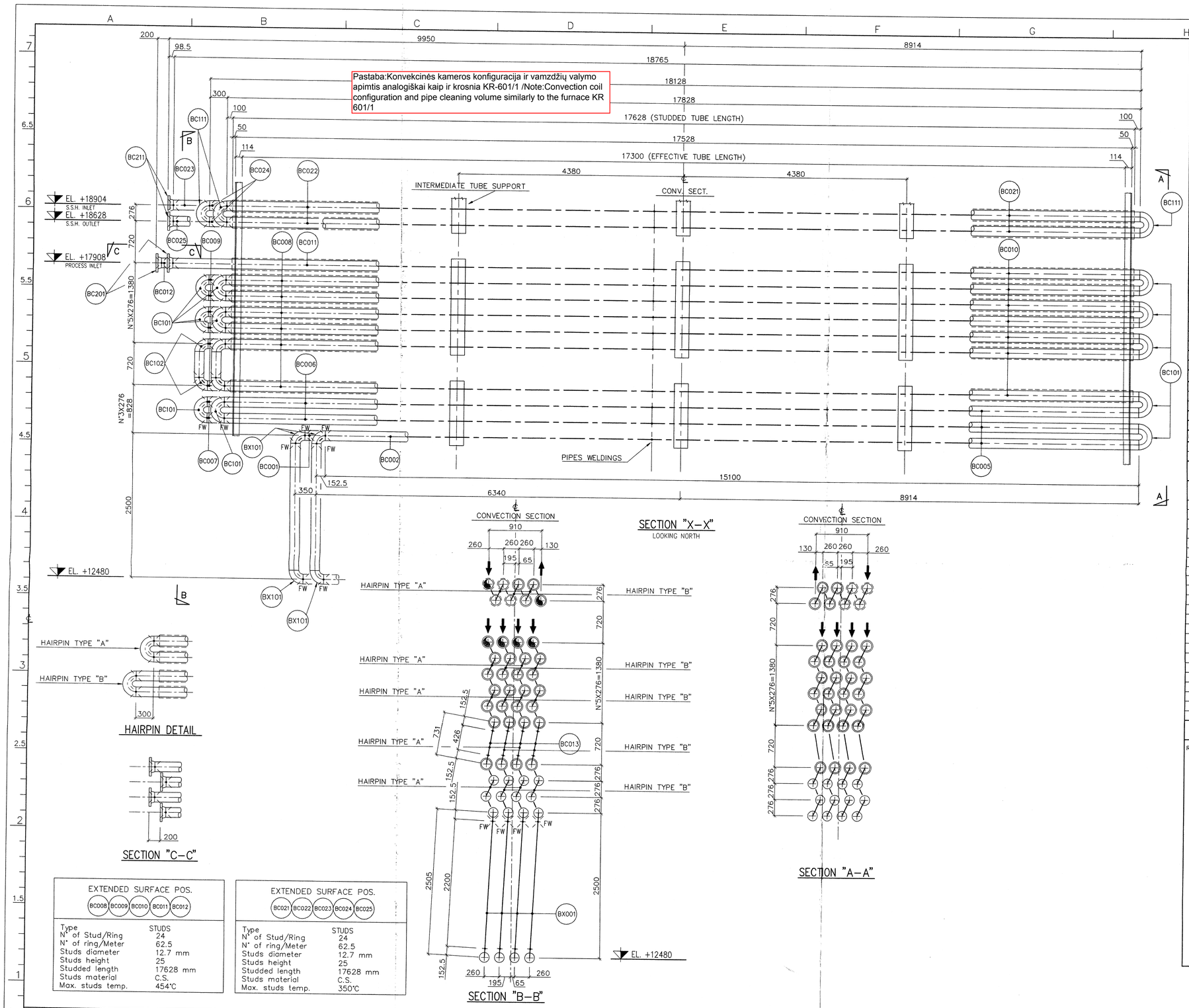
Pastaba:Konvekcinės kameros konfiguracija ir vamzdžių valymo apimtis analogiškai kaip ir krosnia KR-601/1 /Note:Convection coil configuration and pipe cleaning volume similarly to the furnace KR 601/1



EXTENDED SURFACE POS.	
BC008 BC009 BC010 BC011 BC012	
Type	STUDS
N° of Stud/Ring	24
N° of ring/Meter	62.5
Studs diameter	12.7 mm
Studs height	25
Studded length	17628 mm
Studs material	C.S.
Max. studs temp.	454°C

EXTENDED SURFACE POS.	
BC021 BC022 BC023 BC024 BC025	
Type	STUDS
N° of Stud/Ring	24
N° of ring/Meter	62.5
Studs diameter	12.7 mm
Studs height	25
Studded length	17628 mm
Studs material	C.S.
Max. studs temp.	350°C

BILL of MATERIAL

TUBES

M.T.O. N° 30589-601-MTO-0122-001 REV.A
KTI DWG. N° 30589-601-DW-0127-001-02 REV.A

REV.	POS.N	QTY	DESCRIPTION	LENGTH	EXTRA LENGTH	TOTAL LENGTH		MATERIAL	STUDS OR FINS	REMARKS
A	BC001+BC005	2	6" SCH.40 PIPE	15450		15450		A 335 P5		
A	BC002+BC005	2	6" SCH.40 PIPE	15100		15100		A 335 P5		
A	BC005+BC006	4	6" SCH.40 PIPE	17828		17828		A 335 P5		
A	BC005+BC007	4	6" SCH.40 PIPE	18128		18128		A 335 P5		
A	BC008+BC010	12	6" SCH.40 PIPE	17828		17828		A 335 P5	STUDS	
A	BC009+BC010	12	6" SCH.40 PIPE	18128		18128		A 335 P5	STUDS	
A	BC011+BC010	2	6" SCH.40 PIPE	18765		18765		A 335 P5	STUDS	
A	BC012+BC010	2	6" SCH.40 PIPE	18965		18965		A 335 P5	STUDS	
A	BC013	4	6" SCH.40 PIPE	426	100	526		A 335 P5		
A	BC022+BC021	4	6" SCH.40 PIPE	17828		17828		A 335 P5	STUDS	
A	BC024+BC021	2	6" SCH.40 PIPE	18128		18128		A 335 P5	STUDS	
A	BC023+BC021	1	6" SCH.40 PIPE	18765		18765		A 335 P5	STUDS	
A	BC025+BC021	1	6" SCH.40 PIPE	18765		18765		A 335 P5	STUDS	
A	BX001	4	6" SCH.40 PIPE	2200	100	2300		A 335 P5		

FITTINGS (BENDS,ELBOWS,CAPS,REDUCTIONS,TEES)

M.T.O. N° 30589-601-MTO-0122-001 REV.A
KTI DWG. N° 30589-601-DW-0127-001-02 REV.A

REV.	POS.N	QTY	DESCRIPTION	MATERIAL	REMARKS
A	BC101	32	6" SCH.40 180° S.R. RETURN BEND	A 234 WP5	
A	BC102	8	6" SCH.40 90° S.R. ELBOW	A 234 WP5	
A	BC111	7	6" SCH.40 180° S.R. RETURN BEND	A 234 WP5	
A	BX101	8	6" SCH.40 90° S.R. ELBOW	A 234 WP5	

FORGED FITTINGS (FLANGES,WELDOLETS,ELBOLETS,ETC.)

M.T.O. N° 30589-601-MTO-0122-001 REV.A
KTI DWG. N° 30589-601-DW-0127-001-02 REV.A

REV.	POS.N	QTY	DESCRIPTION	MATERIAL	REMARKS
A	BC201	4	6" 300# W.N. R.F. FLANGE SCH.40	A 182 F5	
A	BC211	2	6" 300# W.N. R.F. FLANGE SCH.40	A 182 F5	

MISCELLANEOUS (GASKETS,STUD BOLTS,NUTS,ETC)

M.T.O. N° 30589-601-MTO-0122-001 REV.A
KTI DWG. N° 30589-601-DW-0127-001-02 REV.A

REV.	POS.N	QTY	DESCRIPTION	MATERIAL	REMARKS

DESIGN DATA

PART		PROCESS	S.S.H.
DESIGN PRESSURE IN/ OUT	bar (g)	6	16
DESIGN TEMPERATURE	°C	534	378
CORROSION ALLOWANCE	mm	3	3
HYDRO-TEST/PRESSURE (SHOP)	bar (g)	N/A	N/A
HYDRO-TEST/PRESSURE (FIELD)	bar (g)	24	24
ERECTION WEIGHT	kg	39500	9500
OPERATING WEIGHT	kg	50700	9500
WEIGHT FULL OF WATER	kg	53500	12500
TOTAL VOLUME	m³	14	3
POST WELD HEAT - TREATMENT		YES (9)	YES (9)
RADIOGRAPHING SHOP WELD PERC.	%	100 (7)	100 (7)
RADIOGRAPHING FIELD PERC.	%	100 (7)	100 (7)
DYE PENETRANT	%	(8)	(8)
MAGNETIC EXAMINATION	%	100 (8)	100 (8)
ULTRASONIC EXAMINATION	%	(8)	(8)
HARDNESS	HB	241 MAX (9)	241 MAX (9)
POSITIVE MATERIAL IDENTIFICATION		YES (10)	YES (10)
CONSTRUCTION AS PER		API 530 / KTI ENG. SPEC.	ASME I
INSPECTION BY		KTI/CLIENT NOTIFIED BODY	KTI/CLIENT NOTIFIED BODY
CATEGORY		IV	IV
GROUP		1	1
MODULE		G	G

GENERAL NOTES FOR MATERIALS / PREFABRICATION

REV.

1. ALL DIMENSIONS ARE IN mm EXCEPT OTHERWISE NOTED ON THIS DWG AND/OR DETAIL DRAWINGS
2. ALL ELEVATIONS ARE RELATIVE TO CLIENT REFERENCE EL.+0.00
3. ALL WELD PREPARATIONS CONFORM TO ANSI B 16.25/ANSI B 31.3 AND WPS-PQR-WPQ ACCORDING TO APPLICABLE CODE ASME VIII + IX
4. BOLTSHOLES IN FLANGE TO STRADDLE THE HORIZONTAL AND VERTICAL CENTERLINE EXCEPT OTHERWISE NOTED ON THIS DRAWING AND/OR DETAIL DRAWINGS.
5. ALL REQUIREMENTS AS SPECIFIED IN PERTAINING REQUISITIONS AND SPECIFICATIONS HAVE TO BE MET BY VENDOR.
6. F.W. = FIELD WELD
7. RADIOGRAPHIC AND MAGNETIC EXAMINATIONS SHALL BE PERFORMED UPON COMPLETION OF P.W.H.T.
8. FOR NOT RADIOGRAPHABLE JOINTS OR IN CASES WHERE RADIOGRAPHIC EXAMINATION IS DIFFICULT TO INTERPRET, ULTRASONIC EXAMINATION MAY BE SUBSTITUTED. WHEN ULTRASONIC IS IMPRACTICAL, LIQUID PENETRANT OR MAGNETIC EXAMINATION MAY BE SUBSTITUTED, UPON COMPLETION OF P.W.H.T.
9. POST WELD HEAT TREATMENT SHALL BE EXECUTED ACCORDING TO THE ASME B31.3 CODE AND MN SPEC. (MN-PG-1000) PWHT SHALL BE FOLLOWED BY HARDNESS TEXT EXECUTION TO MEET 241 HB (TEST WILL BE EXECUTED ON WELDING JOINT AND ON EACH HAZ AT THE TOE OF WELD)
10. 100% POSITIVE MATERIAL IDENTIFICATION (PMI) ON TUBES, FITTINGS AND WELDS SHALL BE PERFORMED
11. SUPPLY / PREFABRICATION SHALL COMPLY WITH 97/23/CE (PED) REQUIREMENTS
12. IMPACT TEST SHALL BE PERFORMED ON BASE MATERIAL AND WELD , ACCORDING TO PED REQUIREMENTS. 27 J MINIMUM SHALL BE GUARANTEED AT MINIMUM METAL TEMPERATURE OF 20°C

AS BUILT

REFERENCE DRAWINGS

30589.601.DW.0131.002.01	GENERAL ARRANGEMENT -LONGITUDINAL VIEW
30589.601.DW.0131.002.02	GENERAL ARRANGEMENT -CROSS SECTION
30589.601.DW.0122.001.01	RADIANT COIL KR-601/1
30589.601.DW.0122.001.02	RADIANT COIL SECTION & BILL OF MATERIAL KR-601/1
30589.601.DW.0122.001.03	RADIANT COIL KR-601/2
30589.601.DW.0122.001.04	RADIANT COIL SECTION & BILL OF MATERIAL KR-601/2
30589.601.DW.0127.001.01	CONVECTION COIL & CROSSOVER KR-601/1

HOLD LIST

GENERAL NOTES FOR MATERIALS / PREFABRICATION

REV.	DESCRIPTION	ISS.	CHK.	APP.	AUTH.	DATE
0	FOR CONSTRUCTION					10/7 2007
A	FOR APPROVAL			F.P.	PCO	11/05 2007

MAZEIKIU NAFTA — LITHUANIA

INTERNAL REVISION

AB MAZEIKIU NAFTA MAZEIKIAI, LITHUANIA

Technip KTI

CAD CODE: 30589-601-DW-0127-001-02

PROJ. N: 30589

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CRUDE OIL PLANT
VACUUM HEATER KR-601/2
CONVECTION COIL & CROSSOVER

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