

(100 SERIES)			PIPES									
REV.	ITEM	QTY	DESCRIPTION	NO. [in]	THK [mm]	AW [mm]	LENGTH [mm]	EXTRA LENGTH [mm]	TOTAL LENGTH [mm]	MATERIAL ASTM A312	ASTME	NOTES
0	C-100	2	SEAMLESS PIPE	6	168.3	7.11	AW 13014.1		13014.1	A312 TP304		NOTE 10
0	C-101	2	SEAMLESS PIPE	6	168.3	7.11	AW 13414.1		13414.1	A312 TP304		NOTE 10
0	C-102	40	SEAMLESS PIPE	6	168.3	7.11	AW 12426		12426	A312 TP304		NOTE 10
0	C-103	4	SEAMLESS PIPE	6	168.3	7.11	AW 13414.1		13414.1	A312 TP304		NOTE 10
0	X-100	4	SEAMLESS PIPE	6	168.3	7.11	AW 807.9	100	907.9	A312 TP304		NOTE 2-10
0	X-101	1	SEAMLESS PIPE	6	168.3	7.11	AW 1150	100	1250	A312 TP304		NOTE 2-10
1	X-102	1	SEAMLESS PIPE	6	168.3	7.11	AW 650	100	750	A312 TP304		NOTE 2-10
0	X-103	1	SEAMLESS PIPE	6	168.3	7.11	AW 650	100	750	A312 TP304		NOTE 2-10
0	X-104	1	SEAMLESS PIPE	6	168.3	7.11	AW 1150	120	1270	A312 TP304		NOTE 2-10
1	X-105	1	SEAMLESS PIPE	6	168.3	7.11	AW 465.2	100	565.2	A312 TP304		NOTE 2-10
1	X-106	1	SEAMLESS PIPE	6	168.3	7.11	AW 530	100	630	A312 TP304		NOTE 2-10
1	X-107	SEAMLESS PIPE	6	168.3	7.11	AW 650	100	463.2	A312 TP304		NOTE 2-10	
1	X-108	SEAMLESS PIPE	6	168.3	7.11	AW 650	100	463.2	A312 TP304		NOTE 2-10	

(400 SERIES)			FITTINGS							
REV.	ITEM	QTY	DESCRIPTION	SR	ND [in]	OD [mm]	THK [mm]	AW MW	MATERIAL ASTM / ASME	NOTES
0	C-400	44	RETURN BEND 180°	SR	6	168,3	7,11	AW	A403 TP347	
0	X-400	12	ELBOW 90°	LR	6	168,3	7,11	AW	A403 TP347	

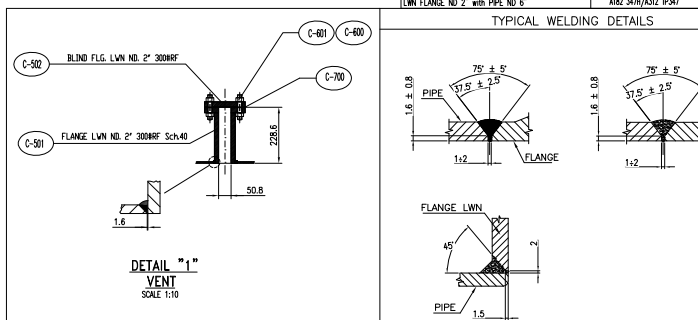
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(600 SERIES)			STUD BOLTS				
REV.	ITEM	QTY	DESCRIPTION	Ø [in]	LENGTH [mm]	MATERIAL ASTM/ASME	NOTES
0	C-600	32	STUD BOLT	5/8	100	A193 GR. B8C	
0	C-601	64	NUT	5/8		A194 GR.8C	
1	X-600		DELETED				
1	X-601		DELETED				

(700 SERIES)		GASKETS							
REV.	ITEM	QTY	DESCRIPTION	ND [in]	RATING [psi]	END	TYPE	MATERIAL ASTM / ASME	NOTES
0	C-700	4	SPIRAL W. GASKET	2	300	RF		SS316 GRAPHITE	
1	X-700		DELETED						

DESCRIPTION	ASTM MATERIAL	S.W.	F.W.
PIPE IN 6" with PIPES/ELBOWS and RETURN BENDS	A312 TP347/A303 TP347	120	-
PIPE IN 6" with PIPES/FLANGES	A312 TP347/A182 TP347H	16	-
LWN FLANGE IN 2" with PIPE IN 6"	A182 347H/A312 TP347	4	-

TYPICAL WELDING DETAILS



DRAWING Nr.	DESCRIPTION

FABRICATION AND WELDING DATA			CONVECTION COILS		X-OVER
TUBE MATERIALS			A312 TP307 G3EE, NOTE 10		A312 TP307 G3EE, NOTE 10
DESIGN CODE			API 57B 530 7th Ed.		API 57B 530 7th Ed.
RUPTURE STRENGTH			MINIMUM		MINIMUM
DESIGN PRESSURE			Bar (g)	18	18
TEMPERATURE ALLOWANCE			°C	-	-
CORROSION ALLOWANCE			mm	3	3
HYDROSTATIC TEST PRESSURE			Kpa(g)	27	27
POST WELD HEAT TREATMENT			YES	YES	YES
PERCENT OF WELD FULLY RADIOGRAPHED			100% of 100%		100% of 100%
DESIGN TUBE METAL TEMPERATURE Min/Max °C			Δ -36 / 550		Δ -36 / 550
PMI			YES - 100%		YES - 100%
FLUID			NOT STABLE HYDROGENATE		NOT STABLE HYDROGENATE
DENSITY			kg	1780	1780
FILL OF WATER			kg	29500	950
VOLUME			m ³	12	3

- 2) ALL WELDINGS MUST BE PERFORMED AT SHOP UNLESS WHERE INDICATED F.W.
- 3) F.W.=WELDED IN FIELD
- 4) ALL PIPES INDICATED WITH FLAST MUST HAVE 100MM OF EXTRA LENGTH FOR ADJUSTMENT IN FIELD
- 5) ALL DIMENSIONS ARE IN MILLIMETER
- 6) ALL PREFABRICATED SECTOR OF PIPES MUST BE HYDRO TESTED
- 7) AFTER HYDRO TEST THE COLLS SHALL BE DRAINED AND DRYED
- 8) FINISHED GRADE LEVEL +0.00
- 9) S.W.=SHOP WELDING
- 10) PLEASE INSTALL THE BLIND FLANGES COMPLETE WITH STUD BOLTS AND GASKETS AT THE DESIGN SHOP PRESSURE PASS BEFORE SHIPPING (TEMPORARY BLIND FLANGES)
- 11) HYDRO TESTING SHALL BE DONE AFTER FINAL WELDING OF SUB ASSEMBLIES OF COLLS AT SHOP
- 12) FURTHER HOOD PARTS AT SITE BY THE LINE AFTER COLLS BEING WELDED
- 13) ALL COLLS PARTS AND WELDED Joints SHALL BE SUBJECTED TO ANIGC TEST IN ACCORDANCE WITH THE SPECIFICATION

1	15-06-2022	ISSUE AFTER CLIENT COMMENTS	C.C.			
0	15-06-2022	ISSUED FOR COMMENTS	C.C.			
REV.Nr.	DATE	DESCRIPTION	PREP.	CHECK.	REV.	APPR.

Client:  ORLEN Lietuva		 SB SETEC ENGINEERING & CONTRACTING	
Project:	Replacement of Fired Heater KR-102 at KT-1/1 Vacuum Gasoil Hydrotreatment Unit	Job Nr.:	Client Ref.
		8242	OLP 01952
		Plant:	Scale:
		KT/1 VGU Unit	1:50
Object:	GENERAL ARRANGEMENT CONVECTION COIL		
Document:		Sheet:	File Name:
SE-T-8242-DA-TF-003		1 / 1	8242_00AT0F03
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