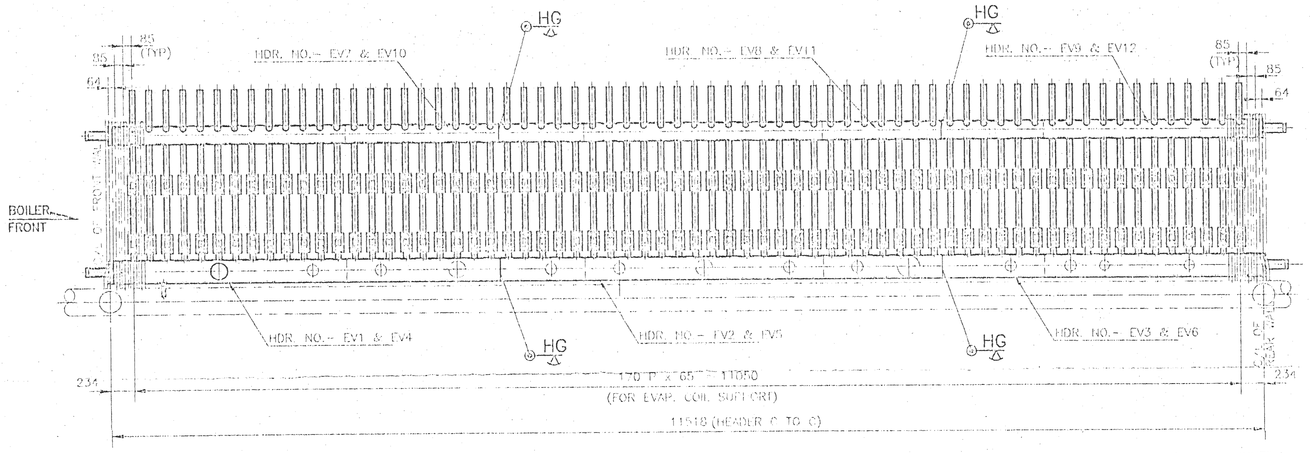
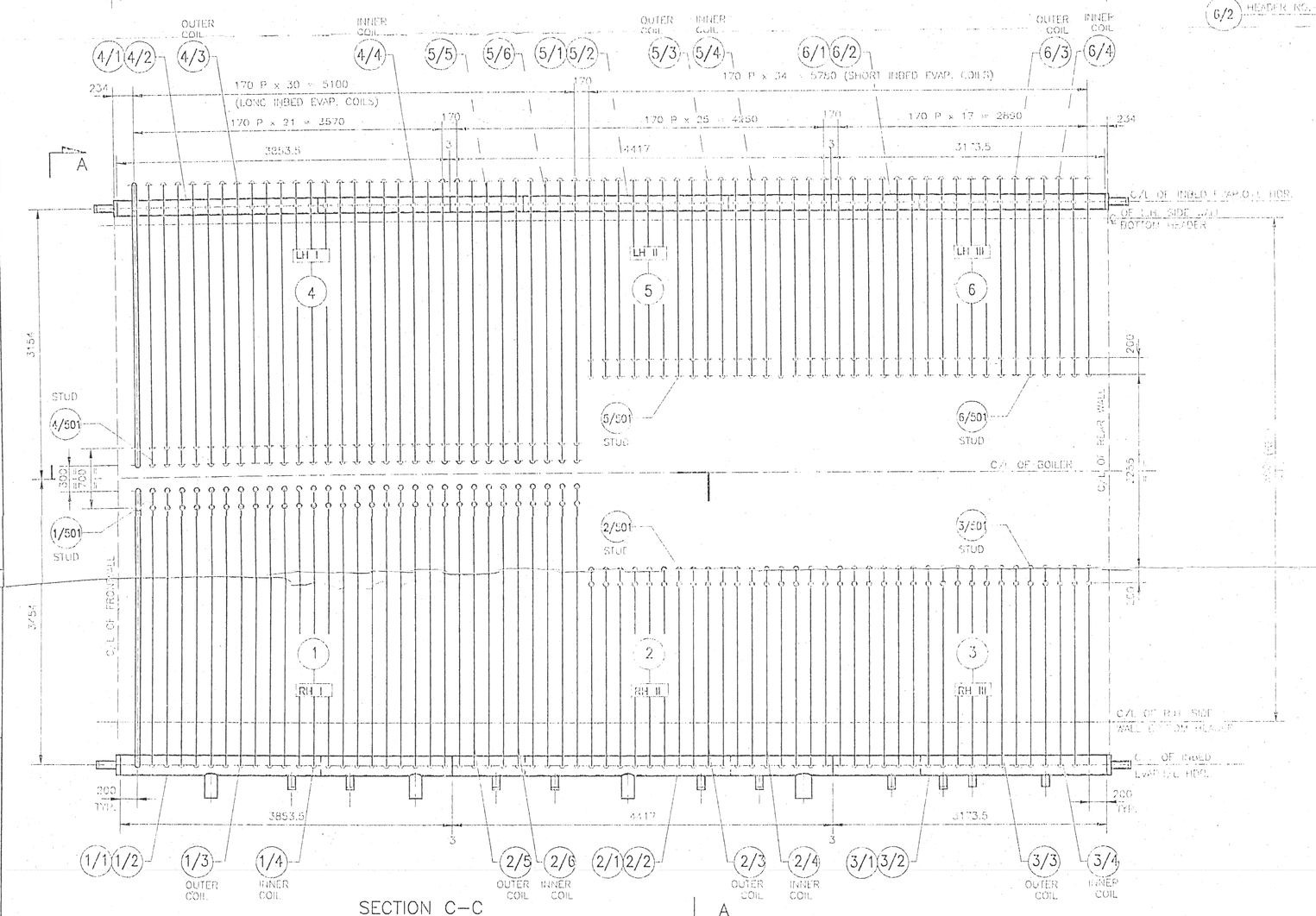
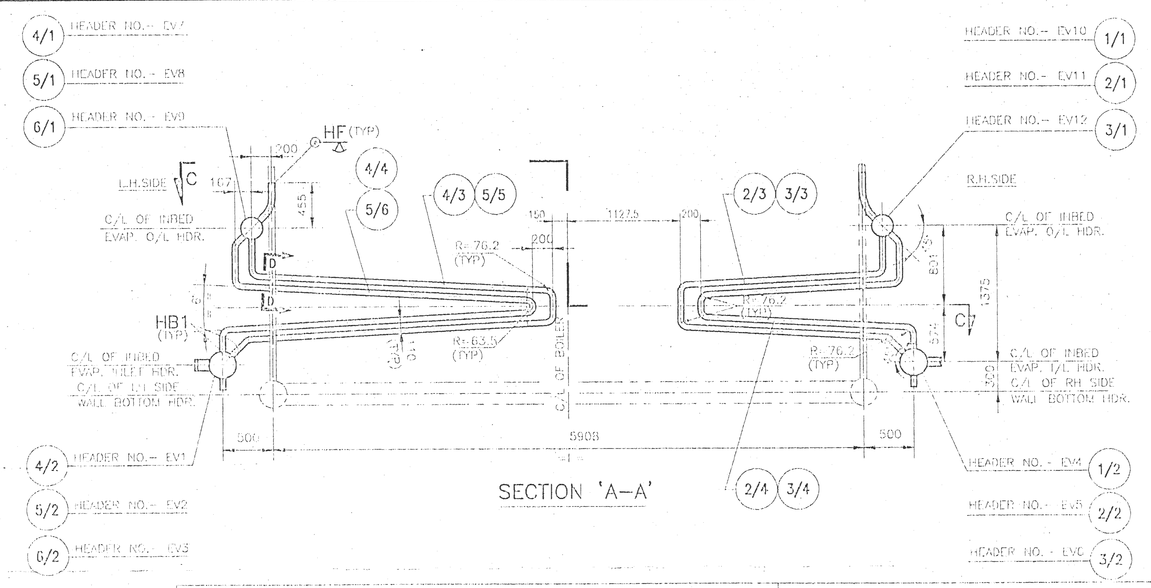
DO NOT SCALE
IF IN DOUBT, ASK

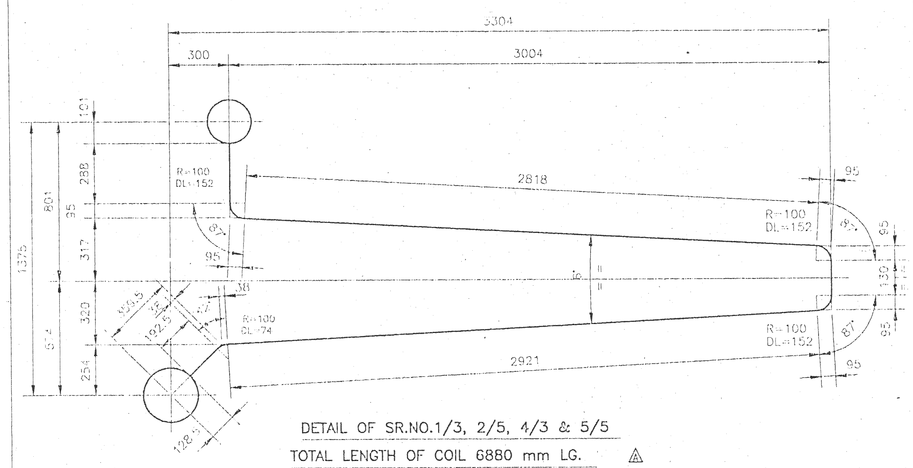




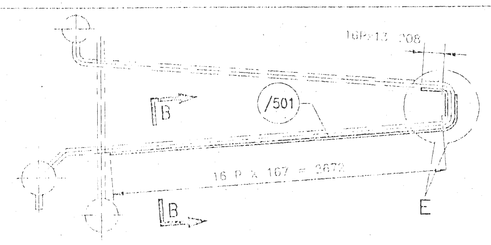
SECTION C–C
(ROTATED 90°)

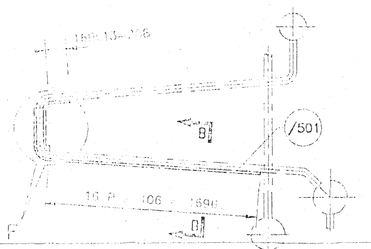


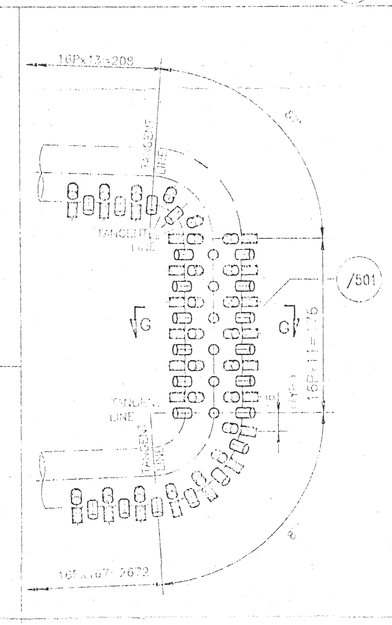
SECTION 'A–A'

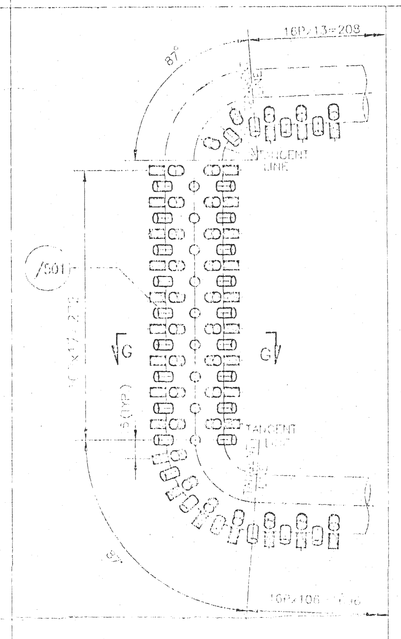


TOTAL LENGTH OF COIL 6880 mm LG. ⚠









DESIGN DATA

- DESIGN & CONSTRUCTIONS CODE ——— I.B.R.
- MAX. WORKING PRESSURE/DESIGN PRESSURE ——— 75 kgf/cm2 (g)
- HYDRAULIC TEST PRESSURE (AT SITE) ——— 112.5 kgf/cm2(g)
- DESIGN METAL TEMP. FOR COIL ——— 318° C
- DESIGN METAL TEMP. FOR HDR ——— 318° C
- STRESS RELIEVING FOR COIL ——— AS PER IBR
  FOR HEADER ——— AS PER IBR
- RADIOGRAPHY FOR COIL ⚠ ——— AS PER IBR
  FOR HDR. ⚠ ——— AS PER IBR

MATERIAL DATA

SR.NO.	DESCRIPTION	SIZE	MATERIAL	QTY
1/3, 1/4 4/3, 4/4	COIL	57.15 OD x 6.35 THK	D 15M03-I	22 NOS EACH
3/3, 3/4 6/3, 6/4	COIL	57.15 OD x 6.35 THK	D 15M03-I	18 NOS EACH
2/3, 2/4 5/3, 5/4	COIL	57.15 OD x 6.35 THK	D 15M03-I	17 NOS EACH
2/5, 5/5 2/6, 5/6	COIL	57.15 OD x 6.35 THK	D 15M03-I	9 NOS EACH
1/2,2/2,3/2 4/2,5/2,6/2	LVA/L HDR	250 NB x 100 SCH	SA 106 GR-B	1 NO. EACH
1/1,2/1,3/1 4/1,5/1,6/1	LVA/L HDR	200 NB x 100 SCH	SA 106 GR-B	1 NO. EACH

STUD: 25Ø* (MAX.) FOR NON-IBR PARTS.

NOTES :

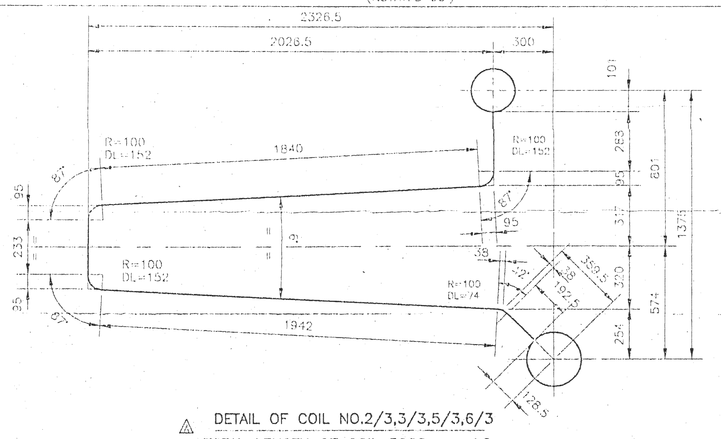
1) ALL DIMENSIONS ARE IN mm.
2) PAINTING TWO COATS OF RED OXIDE PRIOR TO DESPATCH.
3) PANEL MODULE NO. :PM1/PM1R/RH & LH/LH1/LH2.
   ON BOTTOM HDRS. PRIOR TO DESPATCH.
4) COIL BENDING RADIUS ON MEAN DIA BASIS
5) STUD PATTERN SHOWN ARE SUGGESTED PATTERN. SHOP TO PACK STUDS AS PER WPS ON INSERT OF 15 mm NOMINAL STAGGERED CENTERS.
6) STUD MATERIAL AISI 1004
7) FOR SEMI-AUTOMATIC MACHINE STUD WELDING PREHEATING & POST WELD HEAT TREATMENT NOT REQUIRED.
8) FOR MANUAL STUD WELDING PREHEATING UP TO 150° C BEFORE WELDING STUDS.
9) ADDITIONAL SHOP JOINT FOR COIL SHOULD BE TAKEN AS PER MATERIAL AVAILABILITY.
10) ▭▭▭ INDICATE, ROUND STUDDED AREA
11) ⊙—⊼ INDICATES SITE WELD.

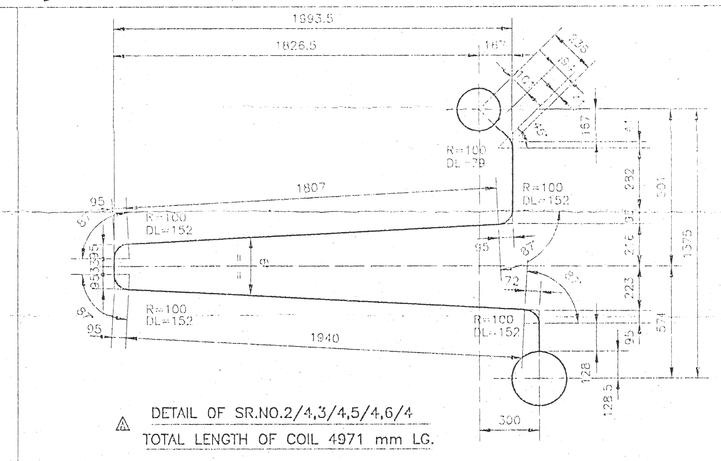
REF.IBR DRG.NOS.

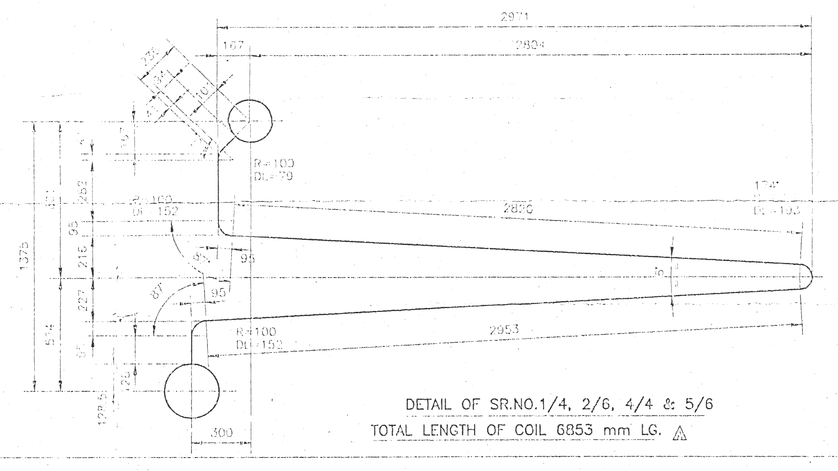
FOR INBED EVAP. L.H. & R.H. SIDE INLET HDRS. ——— PD1-1FB-12233
FOR INBED EVAP. L.H. & R.H. SIDE OUTLET HDRS. ——— PD1-1FB-12234

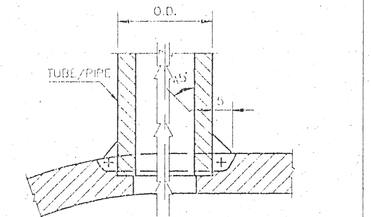
REF.NON–IBR DRG.NOS.

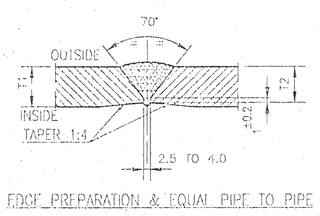
FOR ROUND STUD. ——— 40E-08162

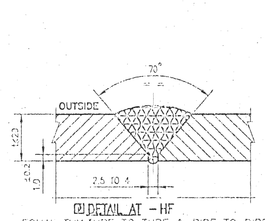


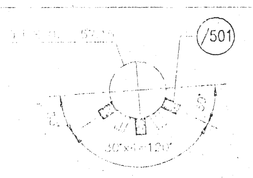


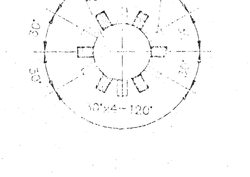


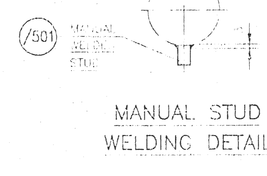


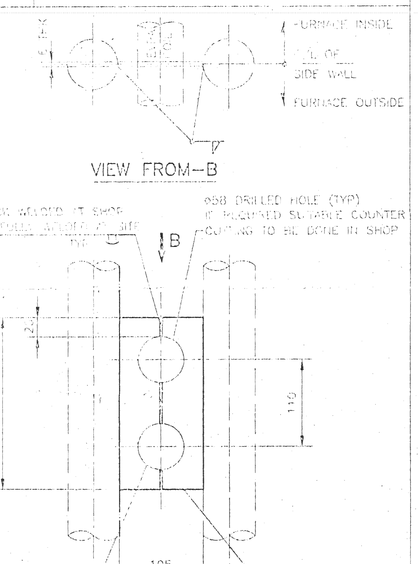












ISSUE NO.	REVISION	MADE BY DATE	CKD CHK'D DATE	APPD BY DATE
⚠	AS BUILT CHANGES DETAIL OF SR.NO.1/3, 2/5, 4/3 & 5/5 TOTAL LG.6910 CHANGED TO 6880. DETAIL OF SR.NO.1/4, 2/6, 4/4 & 5/6 TOTAL LG.6872 CHANGED TO 6853. DETAIL OF COIL NO.2/3,3/3,3/5,3/6,3 TOTAL LG.5054 CHANGED TO 5026. DETAIL OF SR.NO.2/4,3/4,5/4,6/4 TOTAL LG.5008 CHANGED TO 4971. R=76.2 CHANGED TO 100. CORRESPONDING DIMENSIONS CHANGED.				

CLIENT.:– M/S OSWAL CHEMICALS AND FERTILIZERS LIMITED.

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Thermax Babcock & Wilcox Limited PUNE 411 034

BOILER NO. WA017100
I. D. R.
SCALE 1:30 | DRAWN DM/VK 2/5/03 | CHECKED SDM | APPROVED SDM 6/5/03
DRG.NO. PD1-0FB-04380 REVNO A

INBED EVAPORATOR COIL AND HEADER ASSEMBLY

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11 (16)