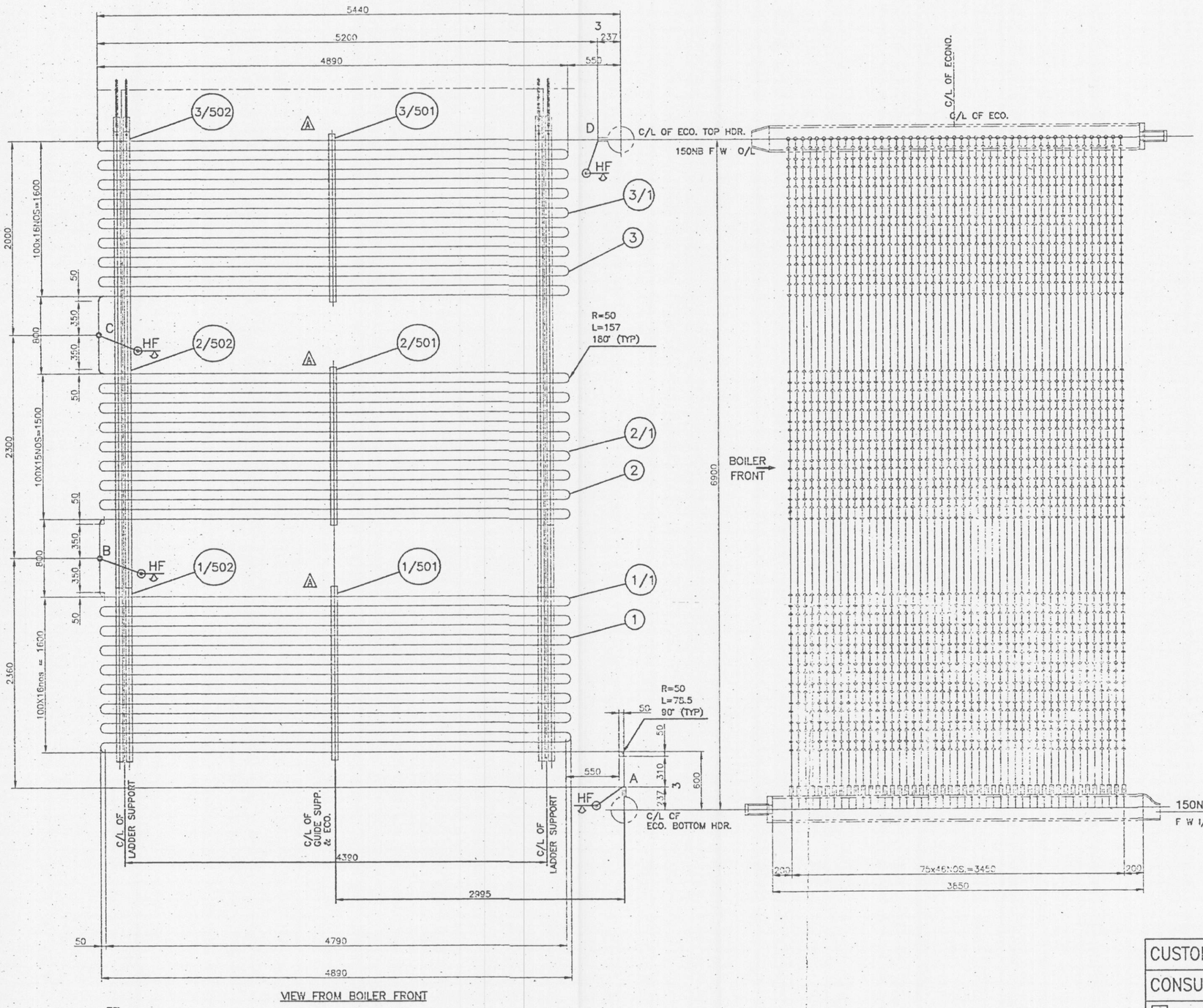
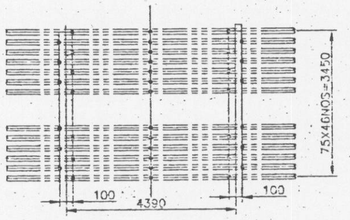
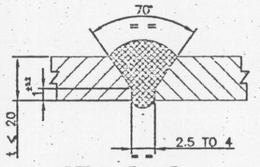
DO NOT SCALE
IF IN DOUBT, ASK





PLAN FOR LADDER & GUIDE SUPPORT



DETAIL AT -HF
EQUAL THK TUBE TO TUBE & PIPE TO PIPE
EDGE PREPARATION & WELDING DETAIL
AS PER I.B.R. FIG.NO.26(X)(a)

DESIGN DATA

	DESIGN & CONSTRUCTION CODE	IBR
	MAX. WORKING PRESSURE = DESIGN PRESSURE	75.0 Kgf/cm^2 (g)
A	HYDRAULIC TEST PRESSURE(AT SITE)	112.5 Kgf/cm^2 (g)
	DESIGN METAL TEMPERATURE	318° C
	STRESS RELIEVING	AS PER IBR
	RADIOGRAPHY	AS PER IBR

MATERIAL DATA - (IBR PARTS)

SR NO.	DESCRIPTION	SIZE	MATERIAL	QTY
1/1	COIL	38.10D x 3.66 THKx 85309Lg	BS 3059 ERW PT I	47
2/1	COIL	38.10D x 3.66 THKx 79852Lg	BS 3059 ERW PT I	47
3/1	COIL	38.10D x 3.66 THKx 84731Lg	BS 3059 ERW PT I	47

SR NO. / 501 ONWARDS ARE NON IBR PARTS

NOTES -

1) ALL DIMENSIONS ARE IN mm.
2) COIL BENDING RADIUS 50mm ON MEAN DIA OF COIL.
3) EDGE PREPARATION OF COIL ENDS SHOULD BE DONE AT SHOP BEFORE DESPATCH.
4) PAINT TWO COATS OF RED OXIDE PRIMER BEFORE DESPATCH.
5) SR NO AND JOB NO TO BE PAINTED ON MATL.BEFORE DESPATCH.
6) MARK COIL END A,B,C & D AS SHOWN IN DRG.
7) FOR LADDER & GUIDE SUPP.REF.DRG.NO.PL1-2FB- 15461 (NON IBR)
8) ⌒ INDICATES SITE WELD.

REV. NO.	REVISION	MADE BY DATE	CAD CHK ※ DATE	APR.BY DATE
A	AS BUILT CHANGES HYDRAULIC TEST PRESSURE AT SITE. BOILER NO.CHANGED FROM WA0171 TO WA017100.SR.NO. 501 MODIFIED TO 1/501 & 1/502,2/501& 2/502 3/501 & 3/502 AS SHOWNLAT MARKED LOCATIONS (NON -IBR)	25/6/01	25/6/01	25/6

CUSTOMER :- OSWAL STEELS. ORISSA

CONSULTANT :- DESEIN PRIVATE LTD.

THIS SYMBOL IN THE BLOCK INDICATES THAT THIS BLOCK IS PICKED FROM BLOCK LIBRARY.

※ REVISION IN CAD DRAWING SHALL BE RELEASED ONLY AFTER ENSURING THAT IT IS INCORPORATED IN THE RELEVENT CAD FILE. REVISION IS INVALID IF CAD CHK. SIGN IN REV. IS ABSENT

BOILER NO-WA017100

Thermax Babcock & Wilcox Limited PUNE 411 034

REF.NO. I.B.R.

SCALE			
1:30	DRAWN	V.D.K.	8-4-2001
	CHECKED	SGS	27/4/2001
	APPROVED	SNP	27/4/2001

ECONOMISER COIL (INTEGRAL)

DRG.NO. PL1-2FB-15445

REV.NO. A

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TOLERANCES ARE NON CUMULATIVE

ACCEPTABLE DEVIATION FOR UNTOLERANCED DIMENSION

	ALLOWABLE LINEAR DEVIATION mm																	
UP TO	6	30	120	315	1000	2000	4000	8000	12000	16000	20000	V	8 - 25					
OVER	0	6	30	120	315	1000	2000	4000	8000	12000	16000	VV	1.6 - 8					
MACHINING	± 0.1	± 0.2	± 0.3	± 0.5	± 0.8	± 1.2	± 2.0	± 3.0	± 4.0	± 5.0	± 6.0	VVV	0.025 - 1.6					
FABRICATION	± 0.5	± 1.0	± 1.5	± 2.5	± 3.0	± 4.0	± 5.0	± 6.0	± 10.0	± 12.0	± 14.0	VVVV	< 0.025					

11(21)