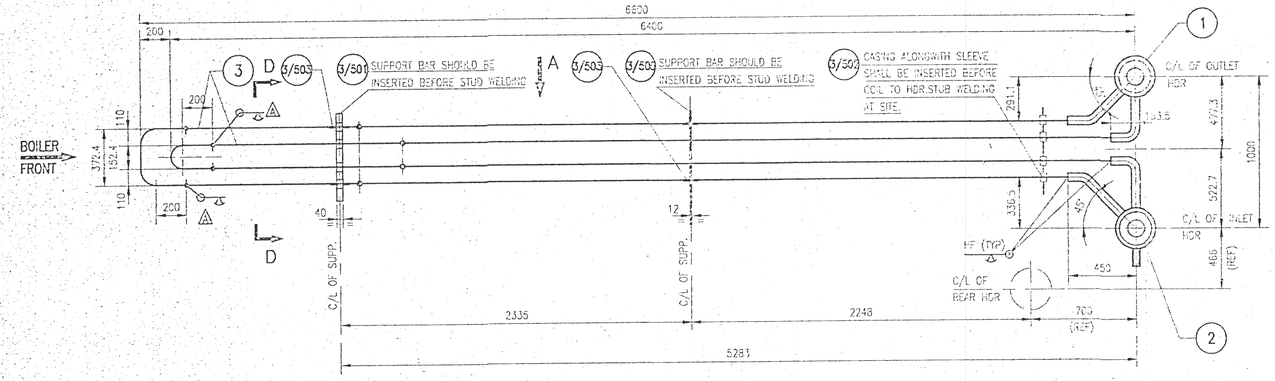
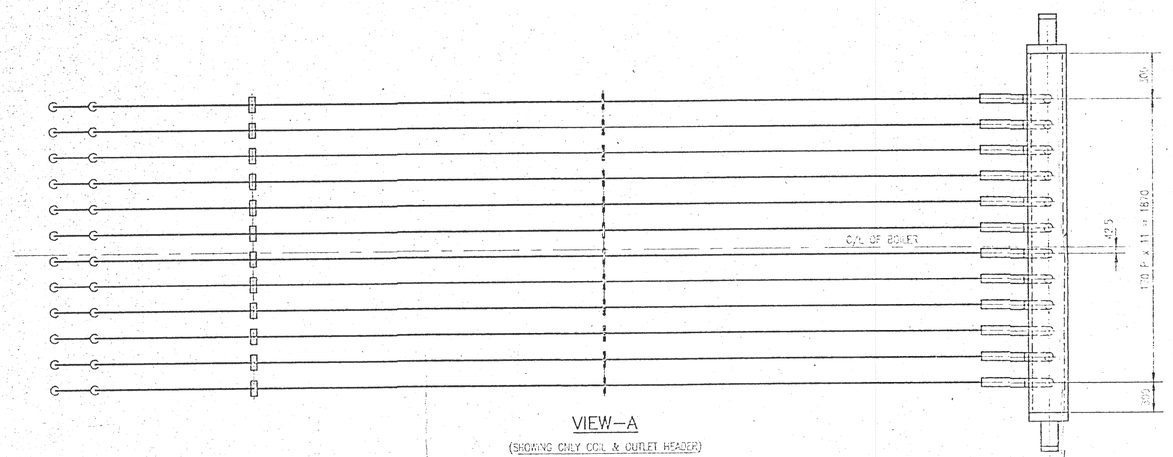
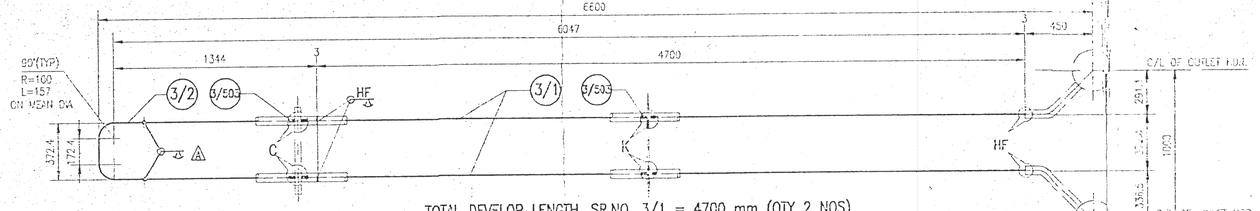
DO NOT SCALE
IF IN DOUBT, ASK



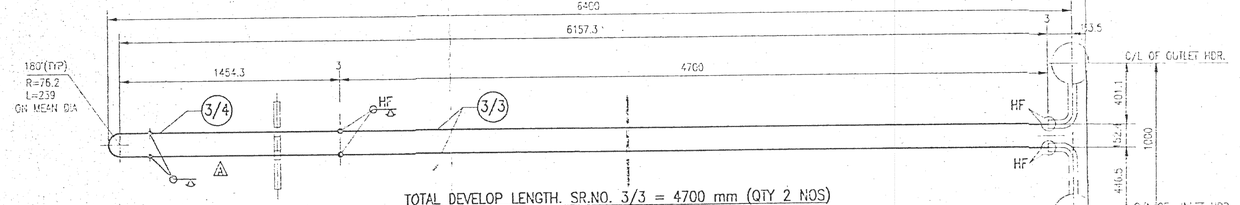


VIEW–A
(SHOWING ONLY COIL & OUTLET HEADER)



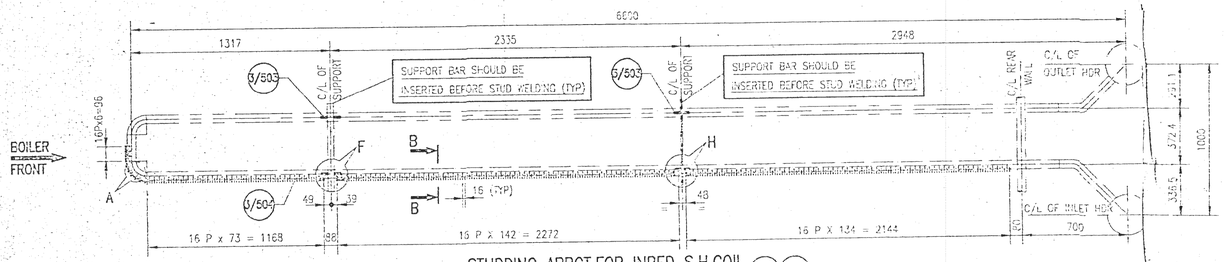
TOTAL DEVELOP LENGTH. SR.NO. 3/1 = 4700 mm (QTY 2 NOS)

TOTAL DEVELOP LENGTH. SR.NO. 3/2 = 3175 mm (QTY 1 NO)



TOTAL DEVELOP LENGTH. SR.NO. 3/3 = 4700 mm (QTY 2 NOS)

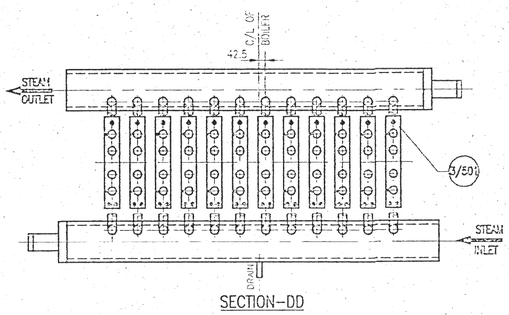
TOTAL DEVELOP LENGTH. SR.NO. 3/4 = 3148 mm (QTY 1 NO)



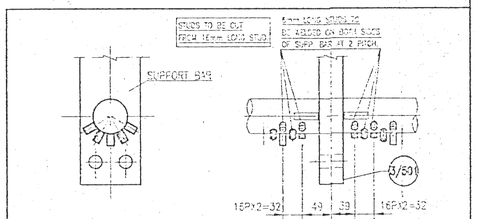
STUDDING ARRGT.FOR INBED S.H.COIL (3/1)(3/2)

QTY.OF COIL.–12 NOS

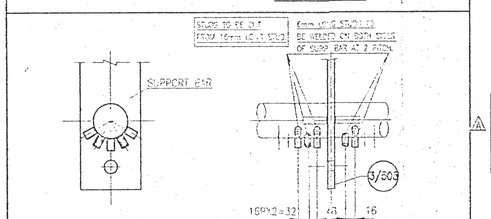
QTY OF STUDS PER COIL–928 NOS.



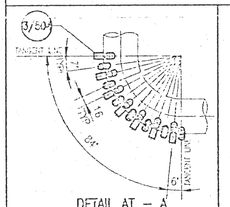
SECTION–DD



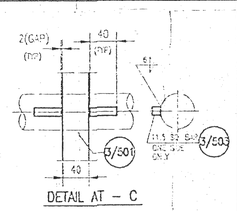
DETAIL AT – F



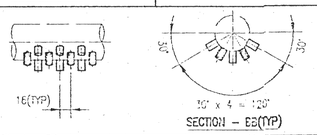
DETAIL AT – H



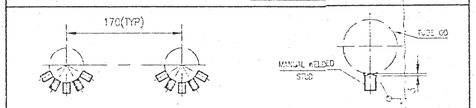
DETAIL AT – A



DETAIL AT – C

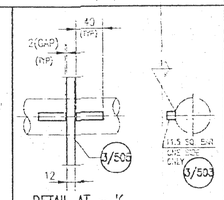


SECTION – EE(TYP)

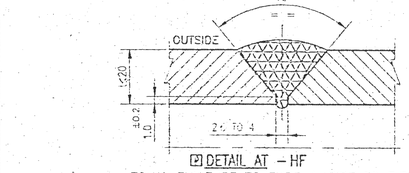


VEW BETWEEN TWO COILS STUDDING DETAILS(TYP)

MANUAL STUD WELDING DETAIL (TYP)



DETAIL AT – K



DETAIL AT – HF
EQUAL THICKTURE TO TUBE & PIPE TO PIPE EDGE PREPARATION & WELDING DETAIL AS PER I.B.R.FIG.NO.28 (IX) (a)

DESIGN DATA

- MAX. WORKING PRESSURE=DESIGN PRESSURE ——— 75 Kgf/cm²(g)
- H.D. TEST PRESSURE (AT SITE) ——— 112.5 Kgf/cm²(g)
- DESIGN METAL TEMP. (FOR INLET HEADER) ——— 452°C
  (FOR OUTLET HEADER) ——— 420°C
  (FOR COIL) ——— 540°C
- DESIGN & CONSTRUCTION CODE ——— I.B.R.
- STRESS RELIEVING (FOR HEADER) ——— AS PER I.B.R.
  ⚠
- RADIOGRAPHY (FOR HEADER 100%) ——— AS PER I.B.R.
  (FOR COIL 5%) ——— AS PER I.B.R.

MATERIAL DATA

SR. NO.	DESCRIPTION	SIZE	MATERIAL	QTY.	ALLOWABLE STRESS
1	OUTLET HEADER	250 NB x 160 SCH	SA 335 Gr P11	1 NO.	REF.HDR.DRG.
2	INLET HEADER	250 NB x 120 SCH	SA 335 Gr P11	1 NO.	REF.HDR.DRG.
3/1	COIL	57.15 OD x 7.1 THK	SA 213 TP 304	24 NOS	726.42 Kgf/cm²
3/2	COIL	57.15 OD x 7.1 THK	SA 213 TP 304	12 NOS	726.42 Kgf/cm²
3/3	COIL	57.15 OD x 7.1 THK	SA 213 TP 304	24 NOS	726.42 Kgf/cm²
3/4	COIL	57.15 OD x 7.1 THK	SA 213 TP 304	12 NOS	726.42 Kgf/cm²

⚠ SR. NO. 3/501 CHMARDS ARE NON IBR PARTS.

REF. IBR.DRGS.

- INLET HEADER ——— PC1–2FB–15402
- OUTLET HEADER ——— PC1–2FB–15403

REF. NON IBR.DRGS.

- ROUND STUD ——— 4CE–03162
- FOR SLEEVE & CASING PLATE ASSLY SR.NO 3/502 ——— PC1–2FB–15404
- FOR SUPPORT BAR SR.NO. 3/501 ——— PC1–4FB–09107
- FOR SUPPORT BAR SR.NO. 3/503 ——— PC1–4FB–09103

NOTES.

- ALL DIMENSIONS ARE IN mm. UNLESS OTHERWISE SPECIFIED.
- PAINTING TWO COATS OF RED OXIDE FOR HEADER ONLY BEFORE DESPATCH.
- PAINT JOB NO. ON COILS & HEADERS BEFORE DESPATCH.
- EDGE PREPARATION OF COIL STUB TO BE DONE BEFORE DESPATCH.
- STUD PATTERNS SHOWN ARE SUGGESTED PATTERN. SHOP TO PACK STUDS AS TIGHT AS POSSIBLE ON 16mm MAXIMUM STAGGERED CENTERS.
- STUD MATERIAL AISI SS 304
- FOR SEMI AUTOMATIC MACHINE STUD WELDING – PREHEATING AND POST WELD HEAT TREATMENT NOT REQUIRED.
- INDICATES SITE WELD
- SOLUTION ANNEALING HEAT TREATMENT FOR P.NO.3/2,3/4. ⚠

REV. NO.	REVISION	MADE BY DATE	CAD CHK DATE	APP.BY DATE
⚠	AS BUILT CHANGES SR.NO.3/2,3/4 SHOP JOINT TAKEN AS SHOWN. SR.NO.3/1 TO 3/4 MATL.SPEC. CHANGED FROM SA 213 TP 304H TO SA 213 TP 304.NOTE ADDED IN DESIGN DATA STRESS RELIEVING NOTE FOR COILS DELETED.	28/11/01		

CLIENT:– OSWAL CHEMICALS AND FERTILIZERS LIMITED.

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

ANY 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	DRAWN	AMN	27/4/2001
1:20	CHECKED	ASC	4/5/2001
	APPROVED	SMP	6/5/2001

ASSEMBLY OF INBED S.H.COIL AND COIL DETAILS.

DRG.NO. PC1–1FB–15122

REV.NO. ⚠A

THIS IS A CAD DRAWING , DO NOT TAKE REPRODUCIBLE

11/12