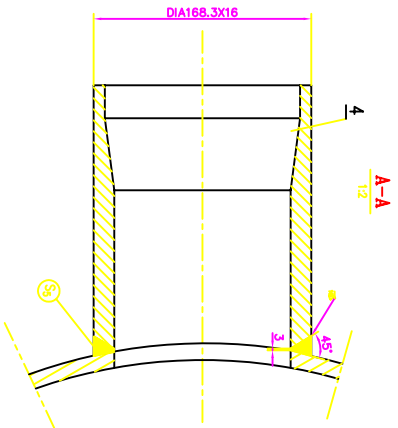
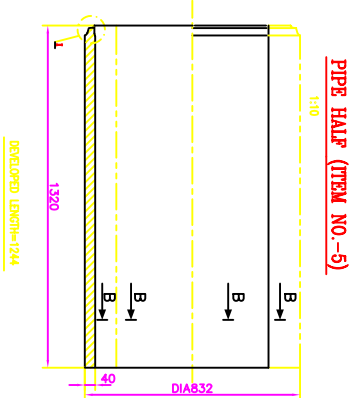
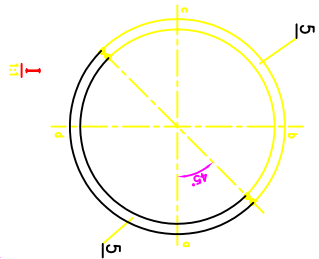
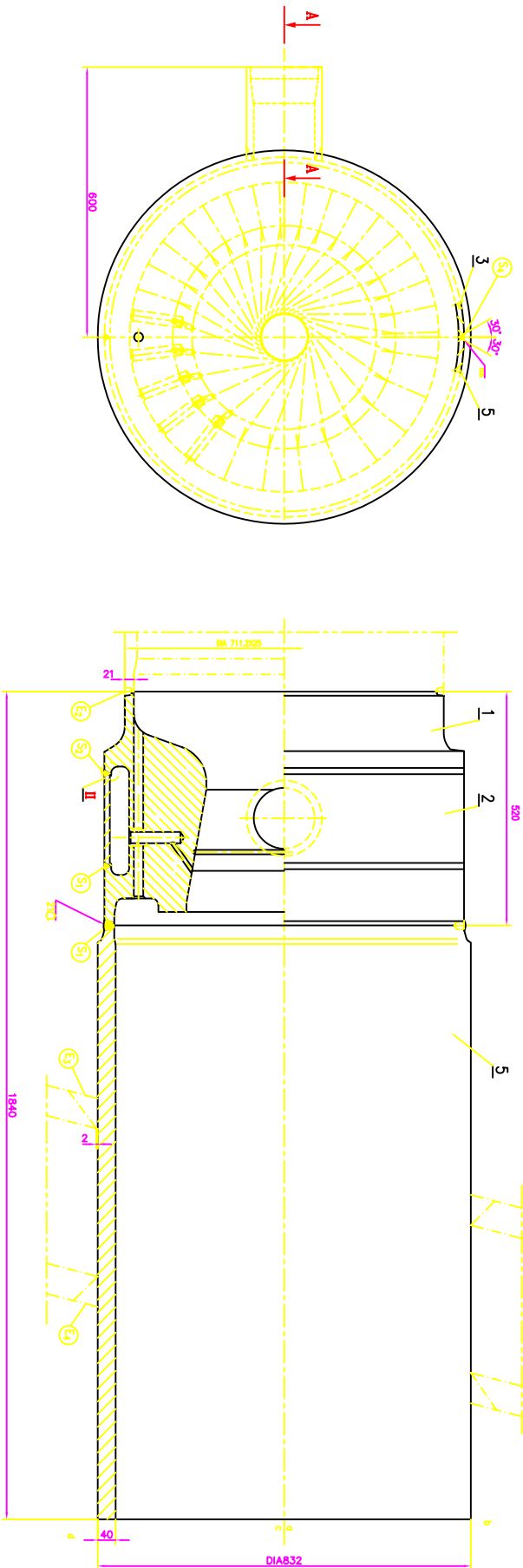
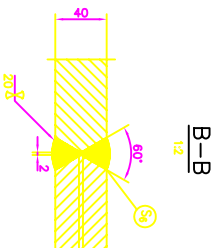
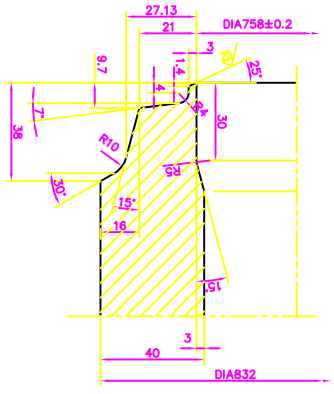


TECH REQUIREMENTS:-

1. STRESS RELIEFING IS TO BE DONE AS PER IS 8000, HR-44-1 (REGIME FOR STEAM THROW DEVICE).
2. QUALITY NOTE FOR WELDING:-
- 2.1 WELDING CLASSIFICATION GROUP AS PER AWS D10.9:2008
- 2.2 TEST SCOPE AS PER AWS D10.9:2008, CATEGORY OF SERVICE REQUIREMENT AS INDICATED BELOW:-
- FOR S122 : CLASS-1
- FOR S233, S455, S6 : CLASS-2
- FOR E324 : CLASS-3
3. PAINTING SHOULD BE DONE AS PER IS 7701.

NOTE:- S = SHOP WELDING, E = SITE WELDING
DESIGNER'S NOTE:-
EDGE PREPARATIONS ON OVERHEAD AND CONDENSATE PIPES REQUIRED FOR SITE WELDING TO BE PROPERLY PROTECTED DURING DESPATCH AS PER Dwg. NO. 11706970018. ALL OPENINGS SHOULD BE BLANKED BY WOODEN PLUGS OR OTHER SUITABLE MATERIAL BEFORE DESPATCH.



SIZE & SYMBOL OF SEAL	WELD LENGTH (M)	WT. OF WELD METAL (KG)	TYPE OF ELECTRODE
12.5	12.5	160	12.5
2.64	4.55	2.5	0.5
7.0	3.94	3.5	0.9
E7018	E8018	B31	E-7018

WELDING SYMBOL	WELDING POSITION	WELDING METHOD	WELDING MATERIAL	WELDING PROCESS	WELDING EQUIPMENT	WELDING PARAMETERS	WELDING INSPECTION	WELDING RECORD
12.5	12.5	160	12.5	12.5	12.5	12.5	12.5	12.5
2.64	4.55	2.5	0.5	0.4	0.4	0.4	0.4	0.4
7.0	3.94	3.5	0.9	0.2	0.2	0.2	0.2	0.2
E7018	E8018	B31	E-7018					

ITEM NO.	DESCRIPTION	QTY	UNIT	REMARKS
1	STEAM THROW DEVICE	1	NO.	
2	PIPE HALF (ITEM NO. 6)	1	NO.	
3	PIPE HALF (ITEM NO. 6)	1	NO.	
4	PIPE HALF (ITEM NO. 6)	1	NO.	
5	PIPE HALF (ITEM NO. 6)	1	NO.	
6	PIPE HALF (ITEM NO. 6)	1	NO.	
7	PIPE HALF (ITEM NO. 6)	1	NO.	
8	PIPE HALF (ITEM NO. 6)	1	NO.	
9	PIPE HALF (ITEM NO. 6)	1	NO.	
10	PIPE HALF (ITEM NO. 6)	1	NO.	
11	PIPE HALF (ITEM NO. 6)	1	NO.	
12	PIPE HALF (ITEM NO. 6)	1	NO.	