



Specification No : RAH - 544

Rev. No : 00

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01. **Item** Set of Cold end Basketed Enameled heating elements of 12" depth for 22 VIR 50" size APH.
02. **Application :**
Enamelled heating element baskets are the heat transfer surfaces located at cold end of Rotary Regenerative air preheater used in oil fired applications. Flue gas and air will contact the enamelled surface alternately.
03. **Basket Arrangement, Dimensions & Set detail** Please refer page 02 of 02. Number of baskets per module is indicated in the sketch. 12 Modules are required for one Air Preheater and it is equal to one set.
04. **Element depth** 305 mm (12") Tolerance +0.0, -1.5
05. **Basket height** 358 mm Tolerance +0.0, -2.0
06. **Element configuration** Notched Flat (NF6) profile as shown in page 02 of 02. Configuration dimensions are indicative only minor variations are allowed.
07. **Element Base metal thickness & tolerance** 22/20 Gauge (0.75mm for Notched sheet and 0.85mm for Flat Sheet) Tolerance +0.07mm, -0.0
08. **Base metal** Enamelling iron as per EN10209 DCO4ED or ASTM A424 or Equivalent
09. **Enamel coating material:**
Enamel coating material shall be suitable for operating temperature range of 30 deg C to 250 deg C. Shall be suitable for corrosive environment of Sulphuric acid. Shall be wear resistant to withstand the erosion due to dust particles in the flowing gas. Shall be shock resistant to withstand superheated steam cleaning at 14 Bar & 310 deg C.
10. **Enamel coating** Porcelain Enamel thickness shall be 150 microns (+50, -0 as tolerance) on each side of the sheet including edges.
11. **Basket material & type** Low alloy corrosion resistance steel as per EN 10025-5 or ASTM A 588 Gr A. Basket design shall be Full Wrapper and suitable for side removal by pulling.
12. **General :**
- a) The Vendor must provide data sheet with sheet thickness, enamel thickness & material standard with grade, drawing with dimensions including basket details, weight of each type of basket, total weight, expected life of enamel coating and other pertinent information along with offer.
 - b) Vendor shall submit the Quality plan along with offer.
 - c) QP shall include Sulphuric acid test, Adherence test, High voltage porosity test and Thermal shock test.
13. **Inspection**
- a) By BHEL inspector at vendor's works.
 - b) Necessary test & Guarantee certificate shall be submitted.

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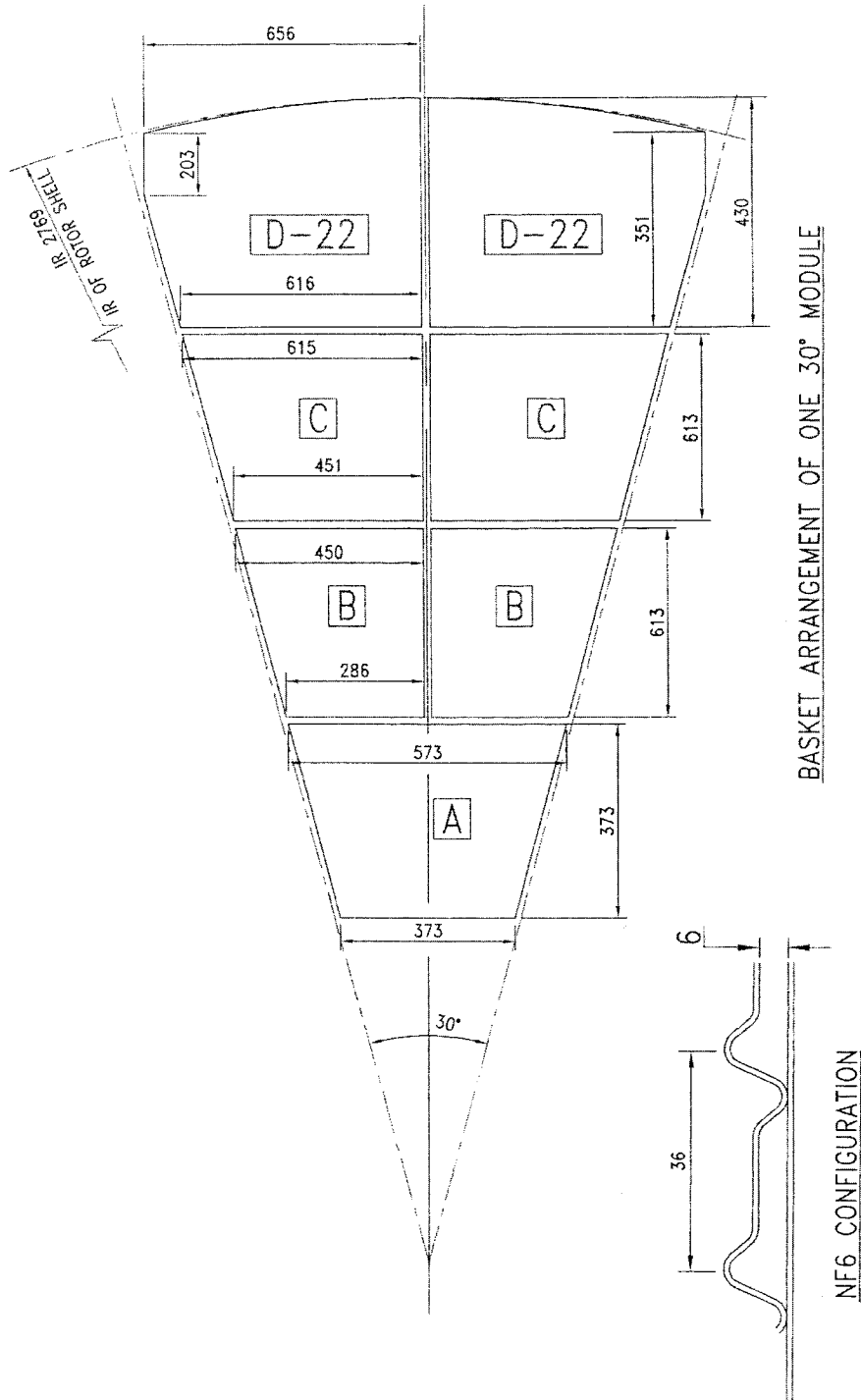
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FRESH ISSUE

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NOTES:

1. 3 mm CLEARANCE ON ALL SIDES OF ALL BASKETS.
2. ALL DIMENSIONS ARE IN mm.