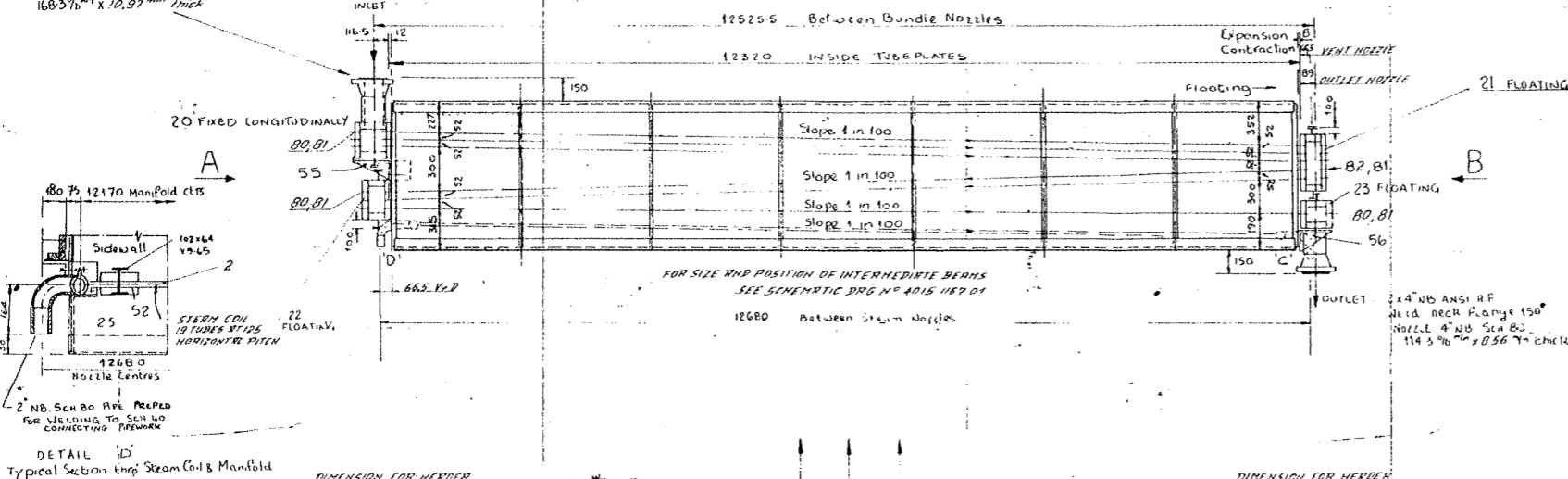
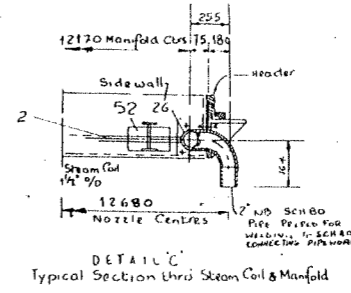


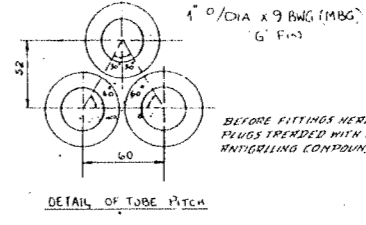
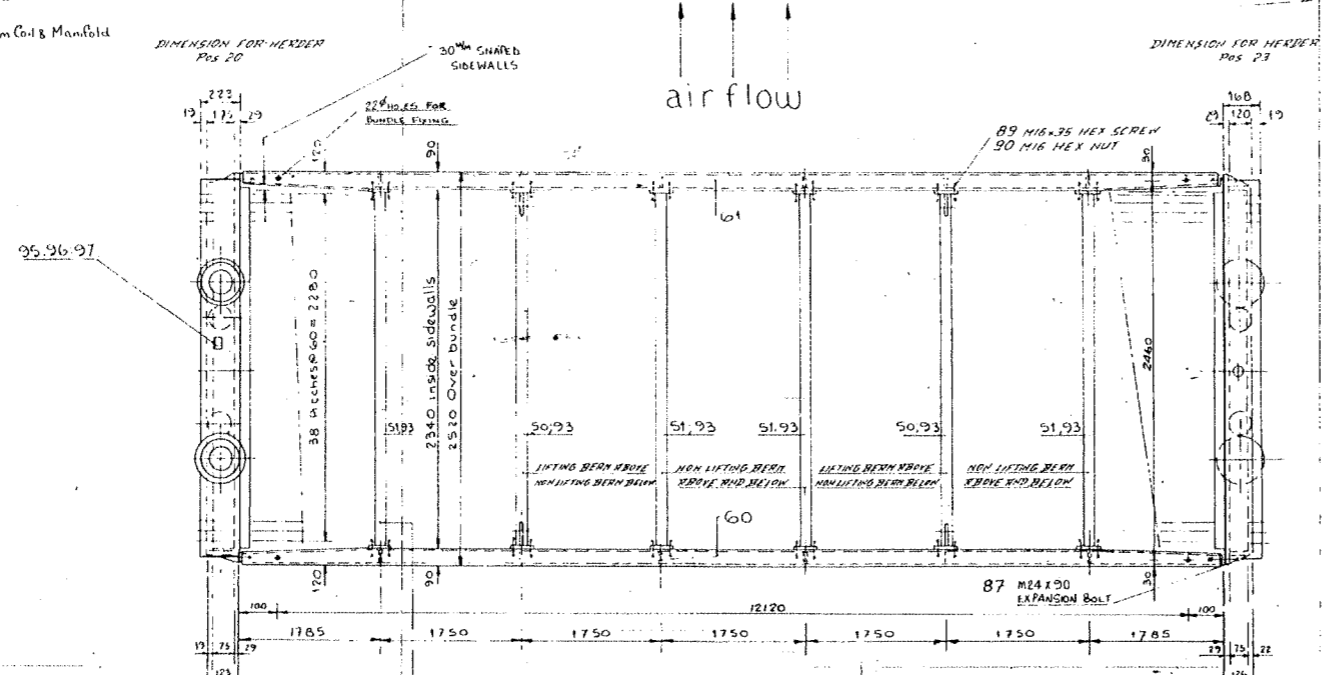
Inlet: 2-6" NB ANSI RF
Weld Neck Flange 150"
Nozzle 4" NB Sch 80
16837/8" x 10.97" thick



DETAIL D
Typical Section thro Steam Coil & Manifold

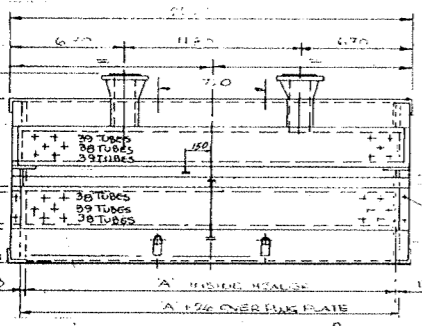


WELDING PROCEDURE
STEEL COILS WIP 4017-0

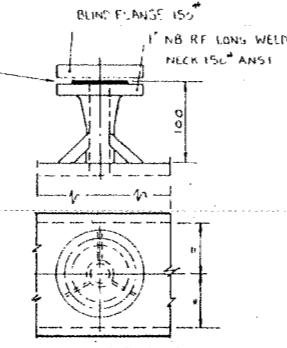


BEFORE FITTING HEADER
PLUGS TRENDED WITH AN
ANTI-GILLING COMPOUND

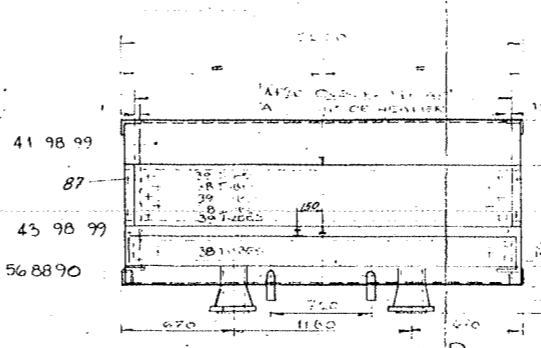
BEARING IS	12
20 x 25	2070
2 x 4 1/2	2340



view on arrow A



DETAIL OF TYPICAL
VENT & DRAIN BRANCHES



view on arrow B

IMPACT TEST REQUIREMENTS
PRESSURE PARTS & STRUCTURAL
SEE D.P.G. SPEC 1500-5 1600-X1
1560-5-0000 X15

Pos. N°	REFERENCE DRAWINGS	DRAWING N°
1	Fin Tube & Fin II/FI. EMBEDDED Fin	4011 0303 21
20	Header FIXED - LONGITUDINAL	4014 2054 21
21	FLOATING	4014 2055 21
22	FLOATING	4014 2056 21
23	FLOATING	4014 2057 21
25-26	INLET & OUTLET S/COIL MANIFOLDS	SHEETS 1-2 4014 1438 21
60/61	Side wall	4013 0714 21
50/51/52	Support Beams	4015 1130 21
40/41	Sealing Plate TOP	4015 1131 21
42/43	Sealing Plate INTERMEDIATE	4015 1137 21
44	Sealing Plate BOTTOM	4015 1133 21
55/56	HEADER SUPPORT & SIDEWALL MEMBER	4019 1434 21
93	SPACER Mark A	STD 2016
	WELD DETAILS (STEAM COIL)	4014 2112 21
	WELD DETAILS (HEADER BOXES)	4014 2042 21
80/82	Header Plug MARK B	STD 2014
81	Header Gasket MARK A	STD 2016
95	Nameplate	4019 1419 21
96	Nameplate baseplate	4019 1416 21
	SCALE MATIC - SUPPORT BEAMS	4015 1167 21
87	EXPANSION BOLT M24 X 90	STD 2016
	DETAILS OF PTFE PADS	4019153821

MATERIALS OF PRESSURE PARTS		
1	Tube 1" dia x 3/16" wall SA387G1	with MTC
20-23	Headers	SABIG GR 60
20, 21	Flanges	SA387 LF1
22, 23	Nozzles	SA387 LF1
20, 22	Nozzles Branch	SA387 LF1
81	Header Plug Gaskets	SA387 LF1
80	Plug	SA387 LF1 (Cadmium)
	Steam Coils	Tube 1/2" dia x 14 BWS (0.085)
2		A178 GRADE A (TUBES)
25, 26		ELBOW 2" NB A178 GRADE B
25, 26		Weldolet 3" NB To 2" NB A178 WPA
25, 26		manifold 3" NB A178 GRADE B

WELDING (HEADER BOXES)	
Welding Method	Shielded Metal Arc Welding (SMAW) E6010
Welding Filler	SA387 LF1
Non-Destructive	SEE WELD PROCEDURE PWP/SA387LF1
Heat Treatment	
Weld Preparation	WELD DETAILS 40142042 21
OPERATING DATA: BUNDLE STEAM COIL	
Operating Pressure	0.6 Kg/cm ²
Design Pressure	5.5 Kg/cm ² 5.5 Kg/cm ²
Test Pressure	8.25 Kg/cm ² 8.25 Kg/cm ²
Inlet Temperature	Product 113 °C Air 204 °C
Outlet Temperature	Product 40 °C Air 812 °C
Design Temperature	161 °C 450 °C
Element Contents	890 Litres
Element Weight	14200 Kg steam; 15000 kg full of water
Corrosion Allowance	3 mm
Type of Product	Process Condensate

- GENERAL NOTES**
- ALL BOLT HOLES ON NOZZLES TO STRADDLE THE CENTRE LINE, I.E. OFF CENTRE.
 - TOLERANCES ON THE DIMENSIONS OF TUBE HOLES, GROOVING AND FINISH SHALL CONFORM TO THE REQUIREMENTS OF Y.M.A. CLASS 'R'. EXPANDED IN TUBES SHALL EXTEND BEYOND THE TUBES PLATE FACE 20 mm.
 - PLUG FILE TUBES TO BE IN ACC. WITH CLASS 2 B. ALL THREADS TO BE IN ACC. WITH CLASS 2A IN ACC. WITH BS1580.
 - FINISH SIDEWALLS: SUPPORT BEAMS & SEALING PLATES NOT DIPPED GALVANISED.
 - HEADERS: CLEANED AND PAINTED IN ACC. WITH D.P.G. SPEC 1500/0000/13.
 - ONE BUNDLE ONLY TO HAVE A NAMEPLATE ATTACHED AND THE NUMBER OF THE BUNDLES TO HAVE THE ITEM N° SHOWN ON THE EDGE OF THE TUBE PLATE.
 - TUBE BUNDLES MUST DURING ERECTION, STORAGE AND TRANSPORTATION BE SUPPORTED ON AT LEAST 3 POINTS UNDER SIDEWALLS.
 - UNLESS OTHERWISE SPECIFIED, MANUFACTURE AND DOCUMENTATION OF TUBE BUNDLES TO COMPLY WITH D.P.G. SPEC 1500-5.
 - 1600-X1 REV 1 AND OTHER RELATED D.P.G. SPECS. AND CODES SPECIFIED ON THIS DRAWING.
 - STEEL: CARBON EQUIVALENT = 0.47%
 - ALIGNMENT AND TOLERANCES FOR FINISHED BUNDLES TO BE IN ACCORDANCE WITH API 661.

INSPECTION	
Dwg Examination by	Davy Powergas
Construction Control	Client or appointed agent
Pressure test by	Manufacturer
Inspection/Acc. to	ASME VIII, API 661, TEMA 'R'
Design Acc. to	ASME VIII, API 661, TEMA 'R'

FINAL APPROVAL	
FOR FABRICATION & ERECTION TO BE SUBJECT TO VERIFICATION	
Davy Powergas	TECHMASHIMFORT USR METHANOL TESHIMHNDPT
Davy Drawing No. 1000110013409	REV. RECEIVED 30/10/78

CERTIFIED FINAL

4 OFF AS DRAWN
231 TUBES PER BUNDLE 6 ROWS 3 PASSES

CUSTOMER ORDER N° 1500 1600/EI/PO10	
ITEM N° 4010 0732 21 C	GEA
TUBE BUNDLE ASSEMBLY	
ITEM N° 4010 0732 21 C	
TYPE 1220 (2340) D.P.G. SPEC 1500-5	