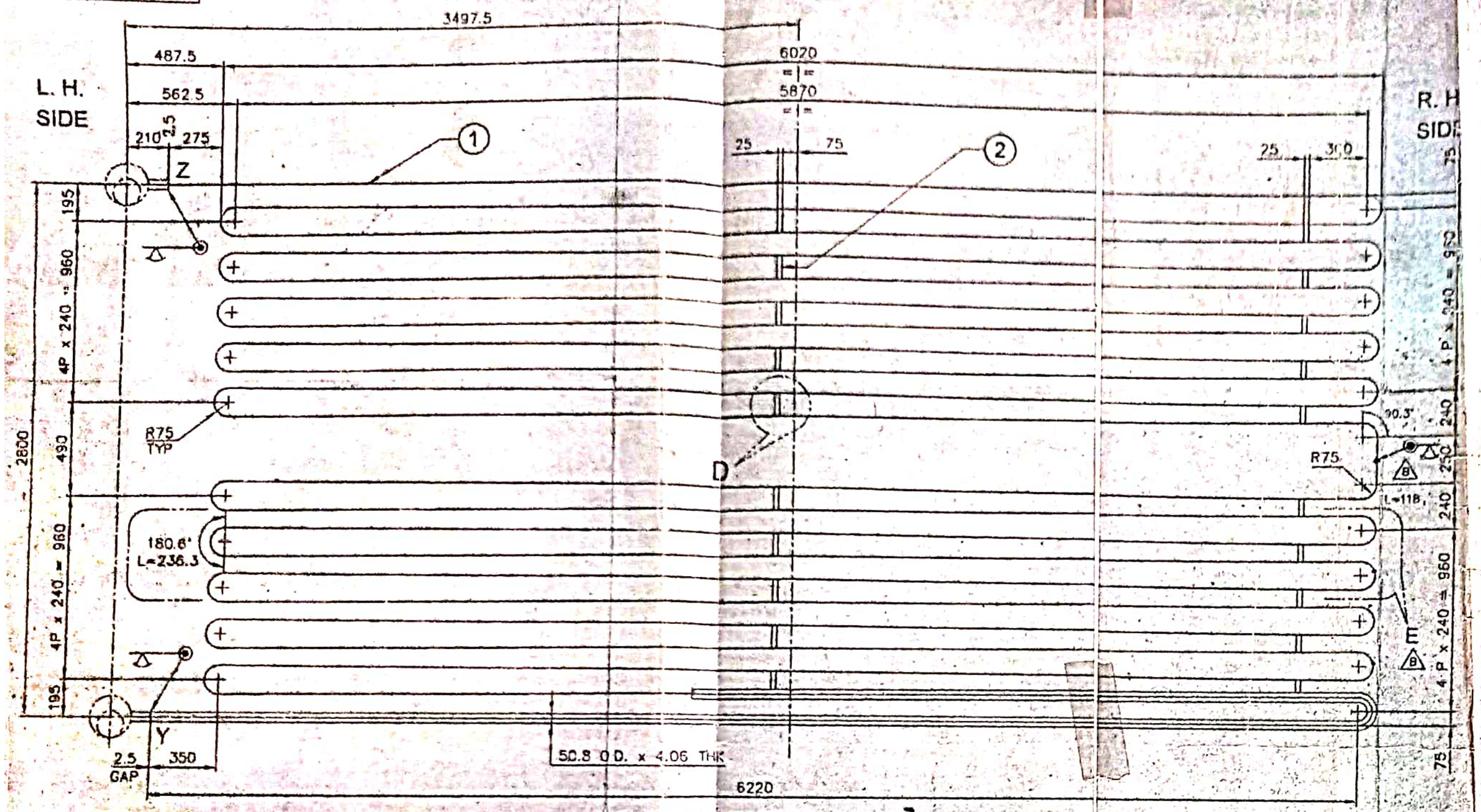
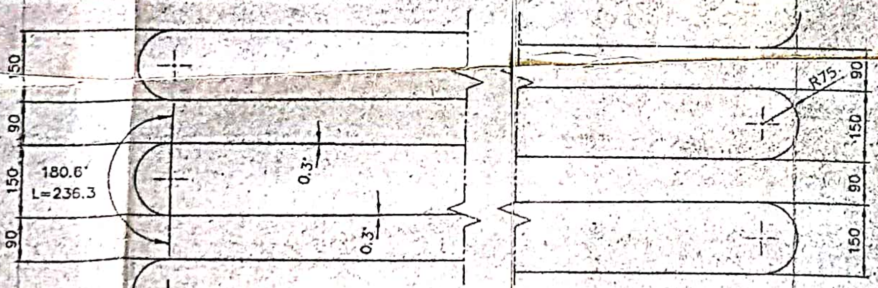
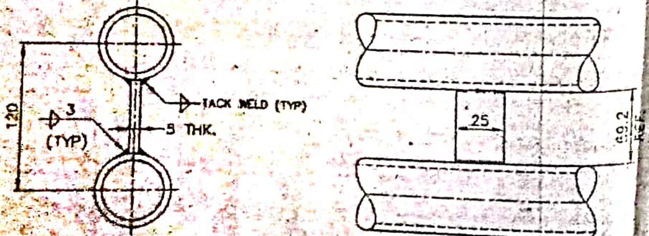
DO NOT SCALE



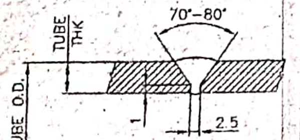
VIEW FROM BOILER FRONT
ECONOMISER COIL TOTAL LENGTH = 1,35,040 mm



DETAIL AT - E



WELDING DETAIL AT - 'D' (TYP.)



TUBE TO TUBE WELDING DETAIL

REV	DESCRIPTION	DATE	BY	CHD.	APPD

JOB NO. CHATTISGARH PROJECT | ITEM NO. | QTY. 22 Nos./BLR

NOTES :-

1. DESIGN AND CONSTRUCTION CODE AS PER IBR & ITS LATEST AMMENDMENTS.
2. RADIOGRPHY FOR WELD JOINTS 10 %.
3. STRESS RELIEVING IS NOT REQUIRED.
4. COIL TO BE TESTED HYDRAULICALY WITH PRESSURE PART ASSL'Y AT SITE.
5. COIL/TUBE BENDING RADII IS 75 mm ON MEAN DIA. OF COIL.
6. MARK COIL NO. & BOILER NO. WITH PAINT PRIOR TO DESPATCH.
7. MARK COIL ENDS 'Y' & 'Z' WITH PAINT AS SHOWN IN DRAWING.
8. TUBE ENDS 'Y' & 'Z' PREPARED AFTER SITE ADJUSTMENT AS SHOWN IN TUBE TO TUBE WELDING DETAIL.
9. ALL DIMENSIONS RELATED TO TUBE ARE BASED ON THE CENTER LINE OF THE TUBE.
10. INDICATE SITE WELD, INDICATE SHOP WELD. (AS REQUIRED)

MATERIAL DATA

P.NO.	DESCRIPTION	SIZE	MATERIAL	MIN UTS kgf/cm²	QTY	WEIGHT IN KG
1	COIL	50.8 OD x 4.06 THK x 135.040 MTR. LG	BS-3059, PART 1 (1987) ERW-320	3264	1	632.0
2	FLAT	25x5THKx70mm LG	---	---	20	1.4

DESIGN DATA

MAXIMUM WORKING PRESSURE = DESIGN PRESURE ---------- 52 KGF / CM^2(g)
HYDRAULIC TEST PRESSURE AT SITE ---------- 78 KGF / CM^2(g)
FEED WATER TEMP. AT ECO. INLET ---------- 105°C
FEED WATER TEMP. AT ECO. OUTLET ---------- 155°C
DESIGN METAL TEMPRATURE OF COIL ---------- 180°C
CAPACITY AT M. C. R. ---------- 40000 KG / HR.
PEAK CAPACITY FOR 1/2 hrs. ---------- 44000 KG / HR.
EFFECTIVE HEATING SURFACE AREA OF ONE COIL ---------- 19.74 Mtr^2

Centr - 5870mm

Provisionally approved
[signature]
I/c Director of Steam Boilers
Maharashtra State - Mumbai.

BOILER NO.- NHB-030 Economizer Coil Bond. No. 484

PART NO	DESCRIPTION	MATERIAL	BLANK SIZE	PATTERN NO	NET WT.
					833.4 KG.

NATIONAL HEAVY ENGINEERING CO-OPERATIVE LTD.
PUNE
27 SEP 2008

DRAWN BY	Amil	24.09.2008
CHECKED BY	[signature]	24.09.08
CHECKED BY		
APPROVED BY	[signature]	25/9/08

UNIT : MM

REF. DRAWING NO. ecoilent.dwg | SCALE 1:20, NTS

ECONOMISER COIL (NON-INTEGRAL)

DRG. NO. A2 - BLR - 47813 | REV