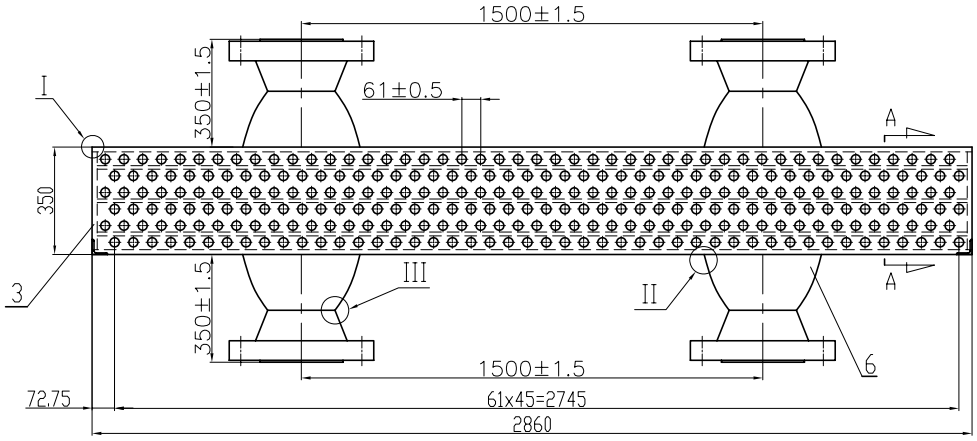
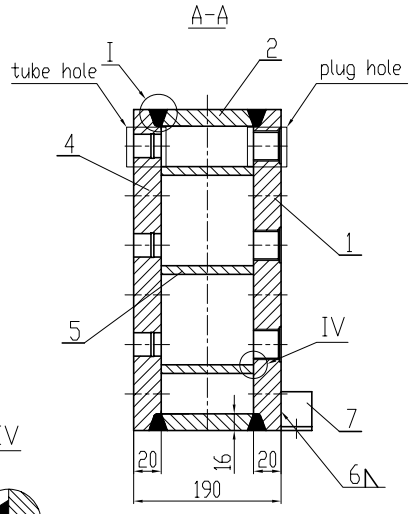
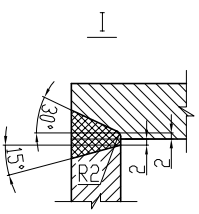
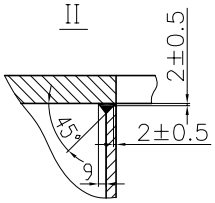
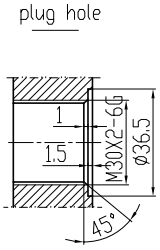
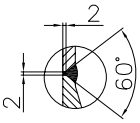


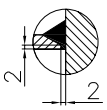












Technical Requirements

1.All materials for fabrication of channels shall be accompanied by material certificates and incorporated into quality certificates;

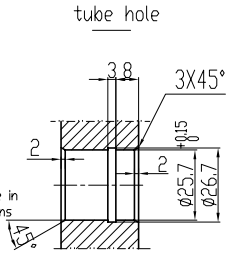
2.All pressure-bearing welds of channels shall be full penetration and full fusion ones;

3.Stress relieving treatment shall be performed to the welded channels and the heat treatment shall strictly follow relevant procedures.

4.For channels, a 100PT% inspection before welding and 100%UT+100%PT inspections after welding shall be conducted for grooves of all their main pressure-bearing welds respectively; a 100PT% inspection before welding and 100%PT after welding shall be conducted for grooves of welds between nozzles and flanges and those between nozzles and channels respectively; a 100%PT inspection shall be performed to the rest welds after welding; the acceptance for PT inspection shall be in accordance with Appendix 8 of ASME Sec. VIII-1 and that for UT shall be in accordance with Appendix 12 of ASME Sec. VIII-1; the records of all above inspections shall be retained.

5.The verticality between the seal surface of a pipe hole and the centerline of a pipe plug shall not be greater than 0.15mm.

6.After heat treatment, a thorough rust removal shall be done to channels.



REV.	CODE NO.	DENOMINATION	QUT.	MATERIAL	UNIT WEIGHT(kg)	TOTAL WEIGHT(kg)	REMARKS
7	JKL-CCS2.10-03-08	connected plate	2	SA516 Gr70	0.5	1	Borrow
6	JKL-OGDCL01-10-03-06	nozzle pipe	4	SA106 GrB	11.5	46	
5	JKL-OGDCL01-10-03-05	clapboard	3	SA516 Gr70	39	117	
4	JKL-OGDCL01-10-03-04	tube sheet	1	SA516 Gr70		157	
3	JKL-OGDCL01-10-03-03	end plate	2	SA516 Gr70	6	12	
2	JKL-OGDCL01-10-03-02	top/bottom plate	2	SA516 Gr70	53	106	
1	JKL-OGDCL01-10-03-01	plug sheet	1	SA516 Gr70		157	

MARK	ITEM	DESIGNATION	SIGNATURE	DATE
DESIGNED			STANDARDIZE	
CHECKED			EXAMINED	
REVIEWED			APPROVED	
PROCEDURE			DATE	

Regular header

Material: unit Qty.: 1/set

[redacted]

DRAWING	MARK	SHEET	WEIGHT	SCALE
S		A3	596	1:12

TOTAL SHEET SHEET OF

[redacted]