



DESIGN DATA:-

- INTENDED WORKING PRESSURE--55.5Kg/cm²G.
- HYD.TEST PRESSURE [AT SITE]--83.25Kg/cm²G.
- MAX.METAL TEMP.-----233°C.

NOTES

- ALL PRESSURE PARTS ARE DESIGNED AND MANUFACTURED AS PER INDIAN BOILER REGULATION, 1950 AS AMENDED UP TO DATE.
- MEAN BENDING RADIUS OF COILS 75MM.
- INDICATE WELD AT SITE INDICATE WELD AT SHOP.
- END PREPARATION TO BE DONE AT SHOP.
- WELD JOINTS ARE TO BE RADIOGRAPHED AS PER I.B.R.
- MATERIAL QUALITY--BS-3059-360 PT.II HFS.
- MATERIAL SIZE--O.D.50.8X4.06 MM THICK X B500
- THERE IS NO EXTRA MATERIAL/ MARGIN FOR SITE OR SHOP ADJUSTMENT.
- THINNING IN THICKNESS FOR BEND ALLOWED AFTER BENDING OF TUBE IS 22% OF THE THICKNESS.
- COILS FABRICATED AT WIL/ VEE BEE INDUSTRIES PUNE/ SHARP ENGINEERING SERVICES, PUNE.

MANUFACTURER	
DEPUTY /JOINT DIRECTOR STEAM BOILERS MAHARASHTRA STATE PUNE	DIRECTOR STEAM BOILERS MAHARASHTRA STATE MUMBAI.

C- THREAD TOLERANCE AS PER IS:4218,PART - IV.
STD. B- REMOVE SHARP EDGES AND BURRS.
NOTE. A- ALL DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED.

BT- 441

CUSTOMER		TUBE		O.D.50.8X4.06THKX		BS.3059-360 PT-II HFS	
		DESCRIPTION		MATERIAL SIZE		QUALITY	
				N.W.		R.W.	
DRN. SV DESHMARE		CHD. <i>Rajesh</i>		CHD. <i>Rajesh</i>		APPD. <i>Rajesh</i>	

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SCALE 1:35
DATE 8/12/03

ECONOMISER COIL

REF. DRG. NO.
DRG. NO. 3BL- 41723
REV.

/B	FLAT POSITION CHANGED	12/3/04	SAGAR	RVK			
/A	COILS REVISED DUE TO LAYOUT CHANGED.	18/1/04	SAGAR	RVK			
ISSUE	ZONE	REVISION	DATE	BY	CHE APPD.		
DEVIATION FOR NON TOLERANCED DIMENSIONS							
FINISH	RA um	PERMISSIBLE ANGULAR DEVIATION			PERMISSIBLE LINEAR DEVIATION		
▽	8-25	LENGTH OF SHORTER SIDE OF ANGLE IN mm			DIM OVER	2000	4000
▽▽	1.6-8	ABOVE	10	50	120	315	1000
▽▽▽	0.025-1.6	UP TO & INCLUDING	10	50	120	315	1000
▽▽▽▽	< 0.025	DEVIATION	±1'	±30'	±20'	±10'	
		FABRICATION	±0.5	±0.8	±1.2	±1.8	±2.5
			±0.5	±0.8	±1.2	±1.8	±2.5
			±0.5	±0.8	±1.2	±1.8	±2.5

FILE NAME:- 441_economisercoil(sagar)

FLOPPY NO.:-