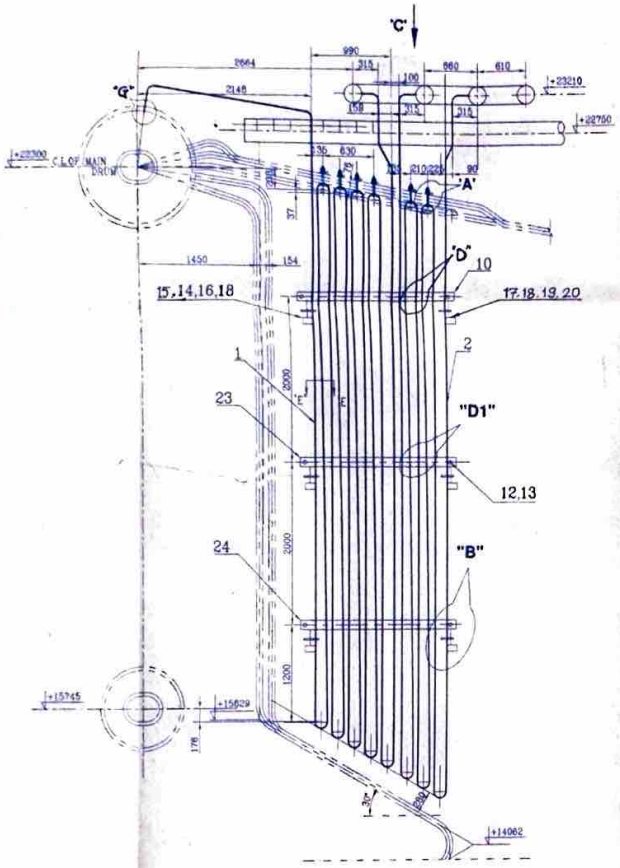
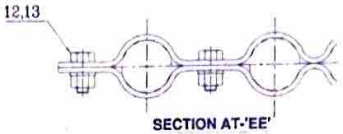
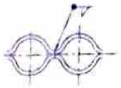
DRG NO

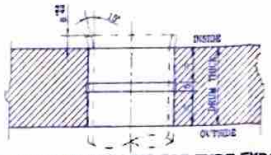




SECTION AT-'EE'



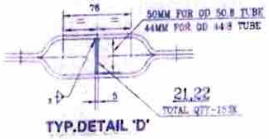
DETAIL 'D1'
SUPER HEATER COIL
CLAMPLING ARRANGEMENT
(TYP.)



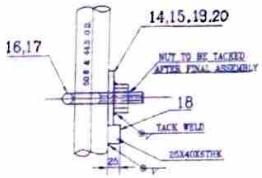
DETAIL OF DRUM DRILLING FOR TUBE EXPANDING

DETAIL AT "G"

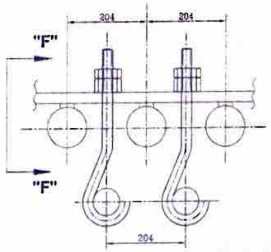
LOCATION	DRUM THICKNESS	TUBE SIZE
MAIN DRUM	65 m.m.	O.D 50.8

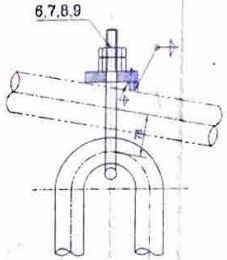


TYP.DETAIL 'D'

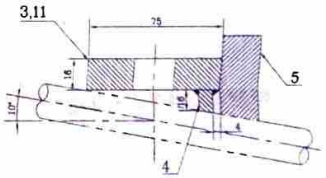


CLAMPING ARRANGMENT
DETAIL AT "B"

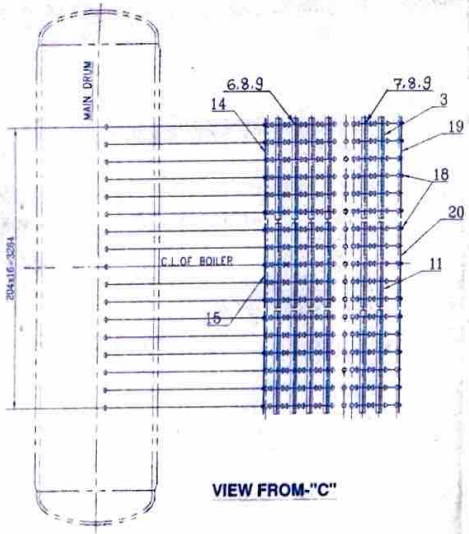




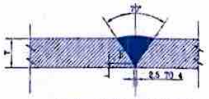
DETAIL AT 'A'



SECTION "FF"



VIEW FROM-"C"



TUBE WELDING DETAIL

AS PER I.B.R. FIG NO.28 IX (a)

MATERIAL SPECIFICATION :-

DESCRIPTION	O.D.	THICK	QUALITY	QTY.
PRIMARY S.H. COIL	50.8	9G	SA213Gr.T11 HFS	17X
SECONDARY S.H. COIL	44.5	9G	SA213Gr.T22 HFS	17X

DESIGN DATA :-

INTENDED WORKING PRESSURE -- 53.50 KG/CM.SQ.G
HYD. TEST PRESSURE (AT SITE) -- 80.25 KG./CM.SQ.G
S.H. OUTLET TEMPRATURE-- 450°c
MAX METAL TEMP. 1)PRIMARY COIL:- 400°c
2)SECONDARY COIL:- 500°c
HEATING SURFACE OF S.H. COIL--
1)FOR PRIMARY S.H. COIL--181 SQ.MTR
2)FOR SECONDARY S.H. COIL-- 100 SQ. MTR

NOTES

1) ALL PRESSURE PARTS ARE DESIGNED AND MANUFACTURED AS PER INDIAN BOILER REGULATION 1950 AS AMENDMENTED UP TO DATE
2) MEAN BENDING RADIS OF S.H. COIL 75 mm
3) —•— INDICATE SHOP WELDING & —/— INDICATE SITE WELDING. POSITION OF SHOP WELD MAY GET CHANGED ACCORDING TO MATERIAL AVAILABILITY
4) BUTT WELD JOINTS ARE TO BE RADIOGRAPHED AS PER IBR 360(d)
5) DESPATCH INSTRUCTIONS AND PAINTING INSTRUCTION SHOULD BE AS PER W.S.-BL-184&W.S. BL-185 RESPECTIVELY.
6) THINNING IN THICKNESS FOR RETURN BEND ALLOWED AFTER BENDING OF TUBE IS 20% OF THE THICKNESS.

THERE IS NO EXTRA MATERIAL/MARGIN FOR SITE/SHOP ADJUSTMENT

FOR P NO-3TD 24 - REF DRG NO 2BL-42386

MANUFACTURER

DEPUTY/JOINT DIRECTOR STEAM BOILERS MAHARASHTRA STATE,PUNE

DIRECTOR STEAM BOILERS MAHARASHTRA STATE,MUMBAI

ISSUE	REVISION	DATE	BY	CHD	APPD

DEVIATION FOR NON TOLERANCED DIMENSIONS

FINISH	RA micro	PERMISSIBLE ANGULAR DEVIATION				PERMISSIBLE LINEAR DEVIATION							
▽	6-25	LENGTH OF SHORTER SIDE OF ANGLE IN mm				DIM OVER	-	6	30	120	315	1000	2000	4000	8000
▽▽	1.6-6	ABOVE	-	10	50	120	IT 14 DEVIATION	0	30	120	315	1000	2000	4000	8000
▽▽▽	0.025-1.6	UP TO & INCLUDING	10	50	120	-	MACHINING	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0	±3.0
▽▽▽▽	< 0.025	DEVIATION	0°	±30'	±20'	±10'	FABRICATION	±0.5	±0.8	±1.2	±1.8	±2.5	±3.5	±5.0	±8.0

FILE NAME -ASSEMBLY OF SH COILS | FLOPPY NO --

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

CUSTOMER:- CSEB | BT NO:- 441

DESCRIPTION	MATERIAL SIZE	QUALITY	N.W.	R.W.

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DRN. B.P.KUMBHAR
CHD.
CHD.
APPD

WALCHANDNAGAR INDUSTRIES LTD. WALCHANDNAGAR INDIA 413114

SCALE 1.35:1.70
DATE 27/01/04

TITLE ASSEMBLY OF SUPER HEATER COIL

REF. DRG NO.
DRG NO. 1BL-43186
REV