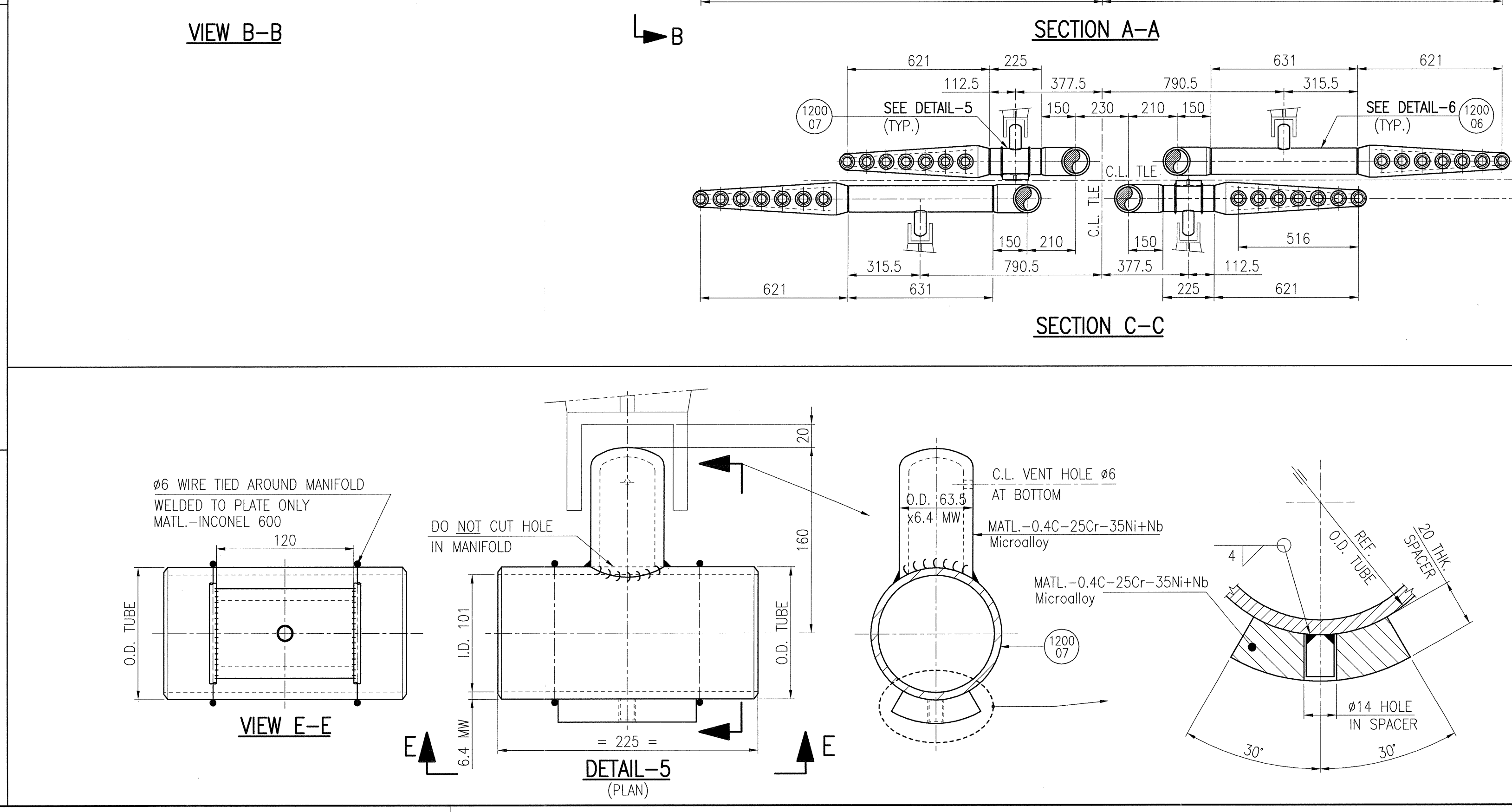
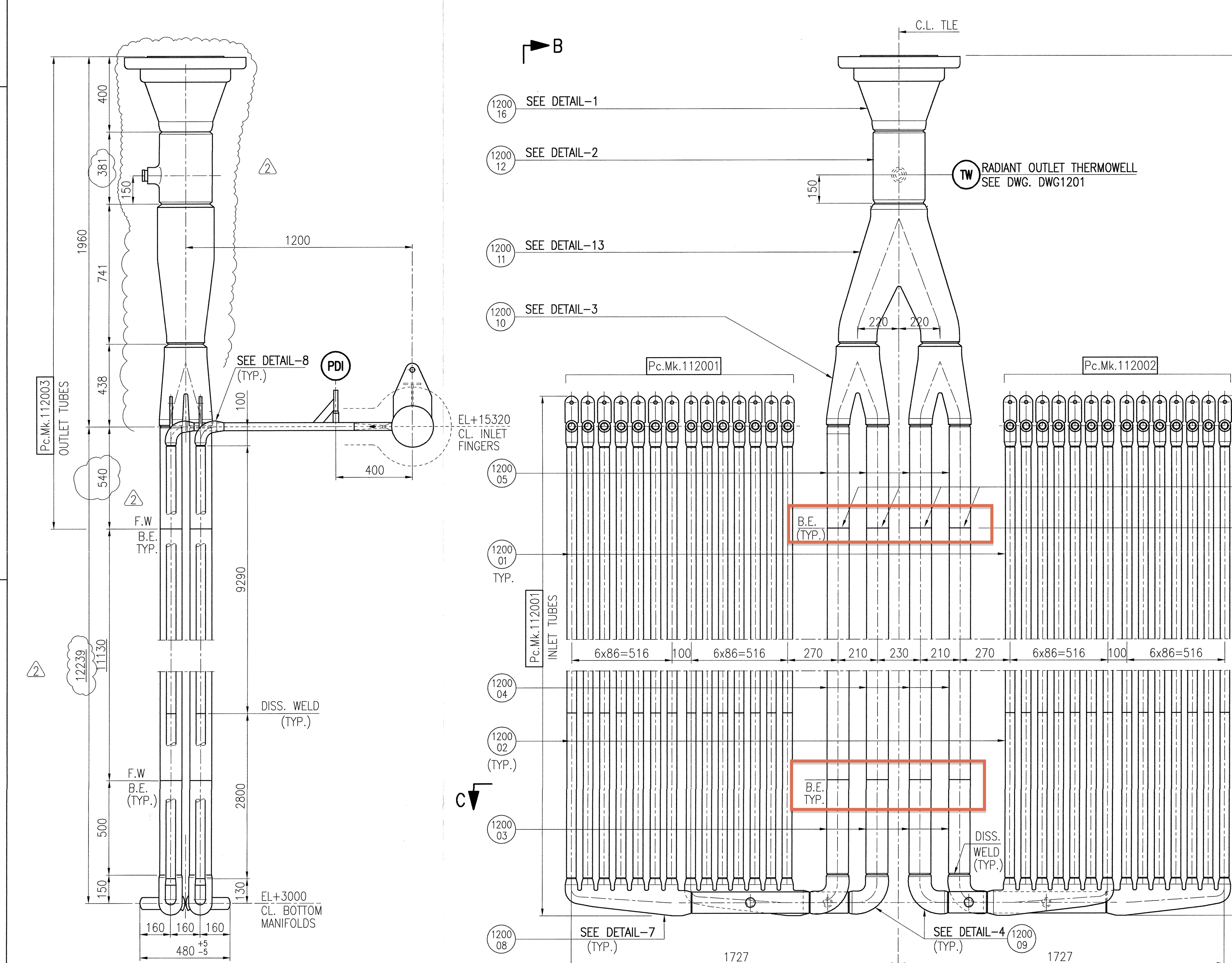
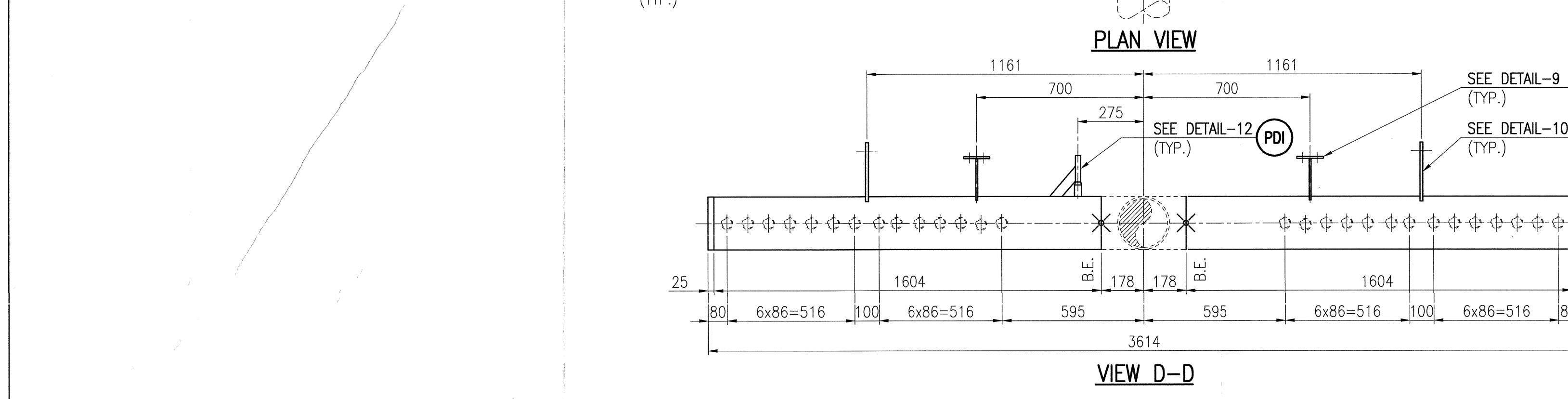
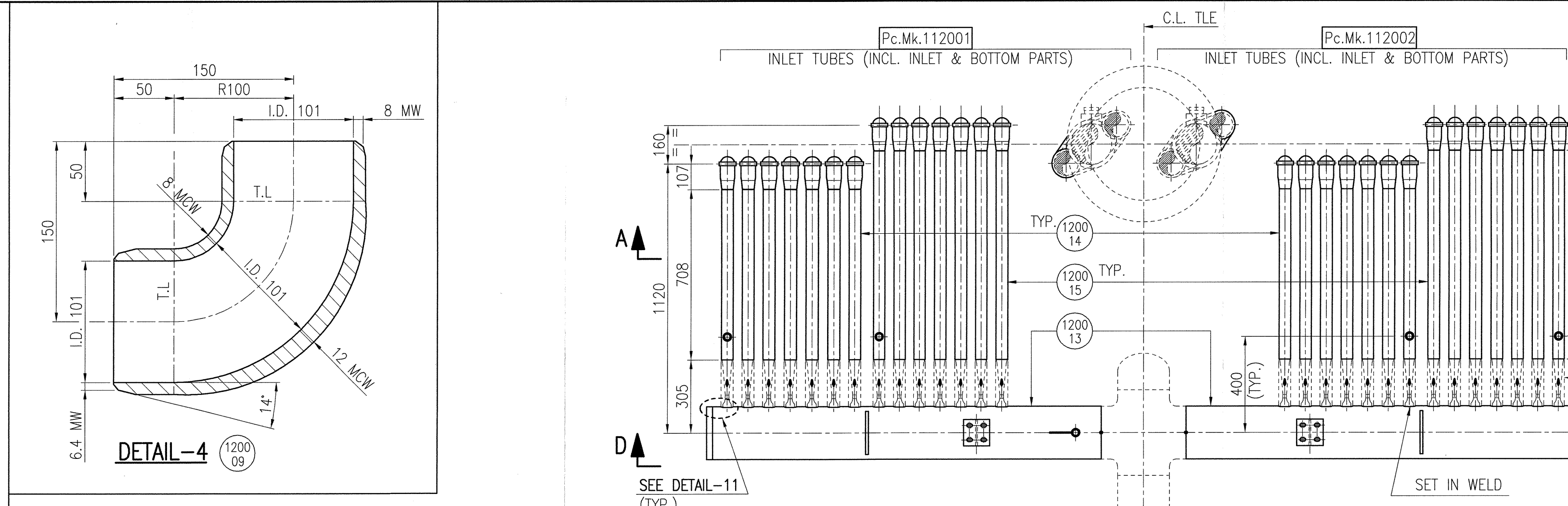
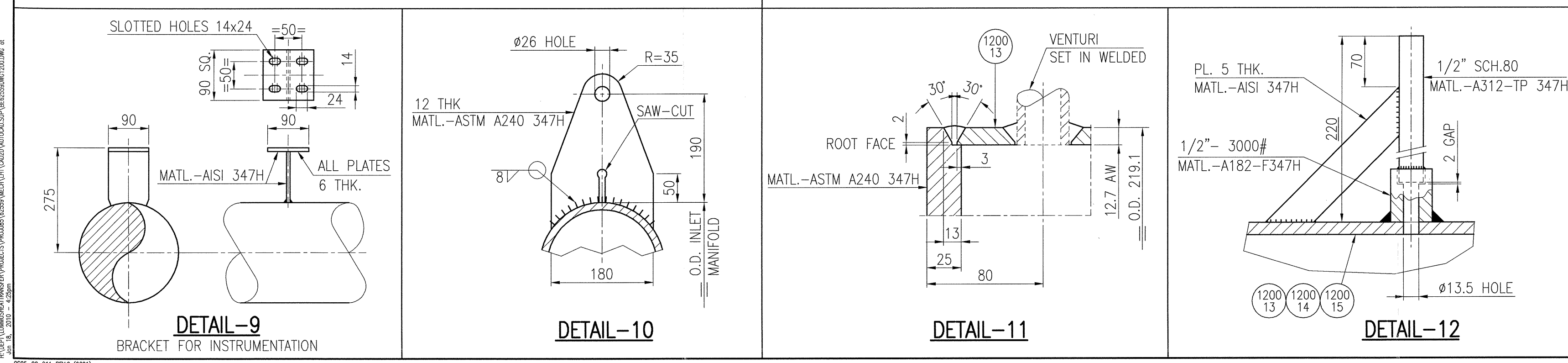
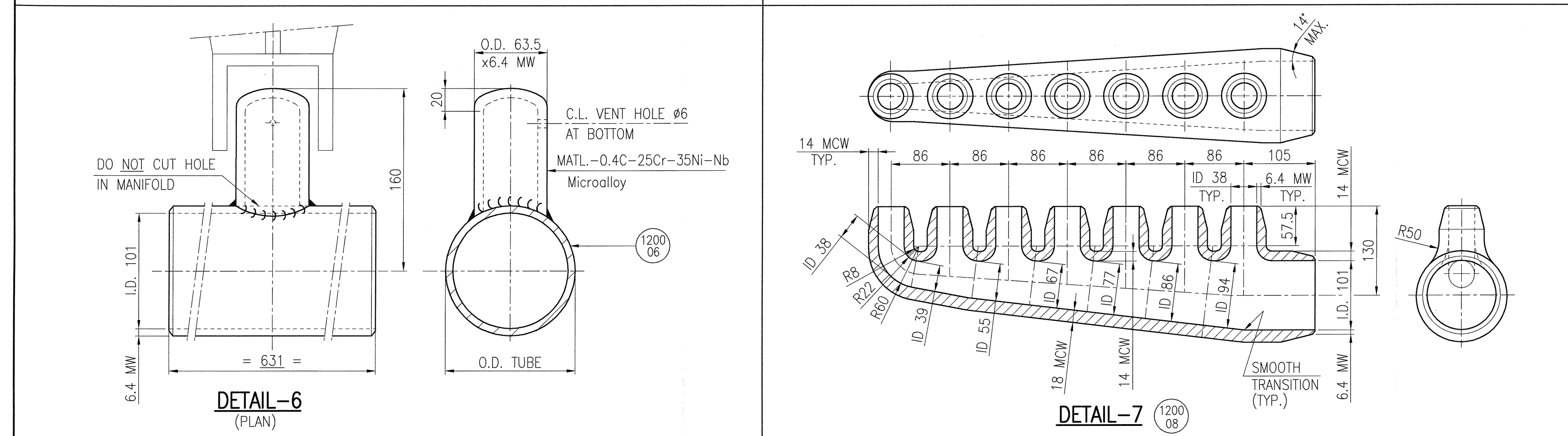
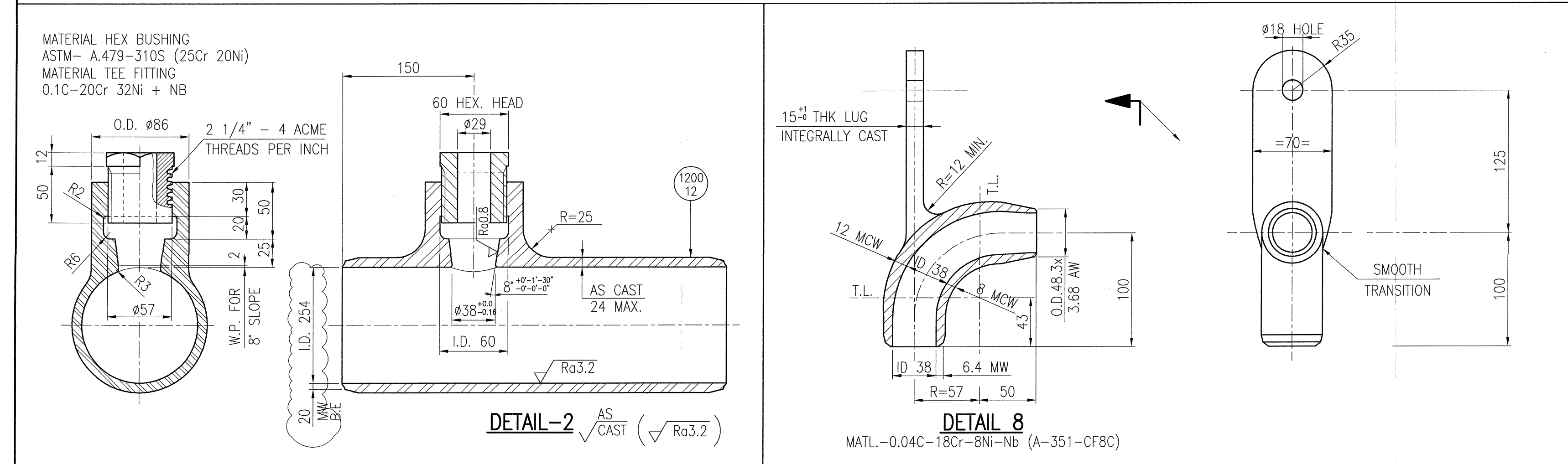
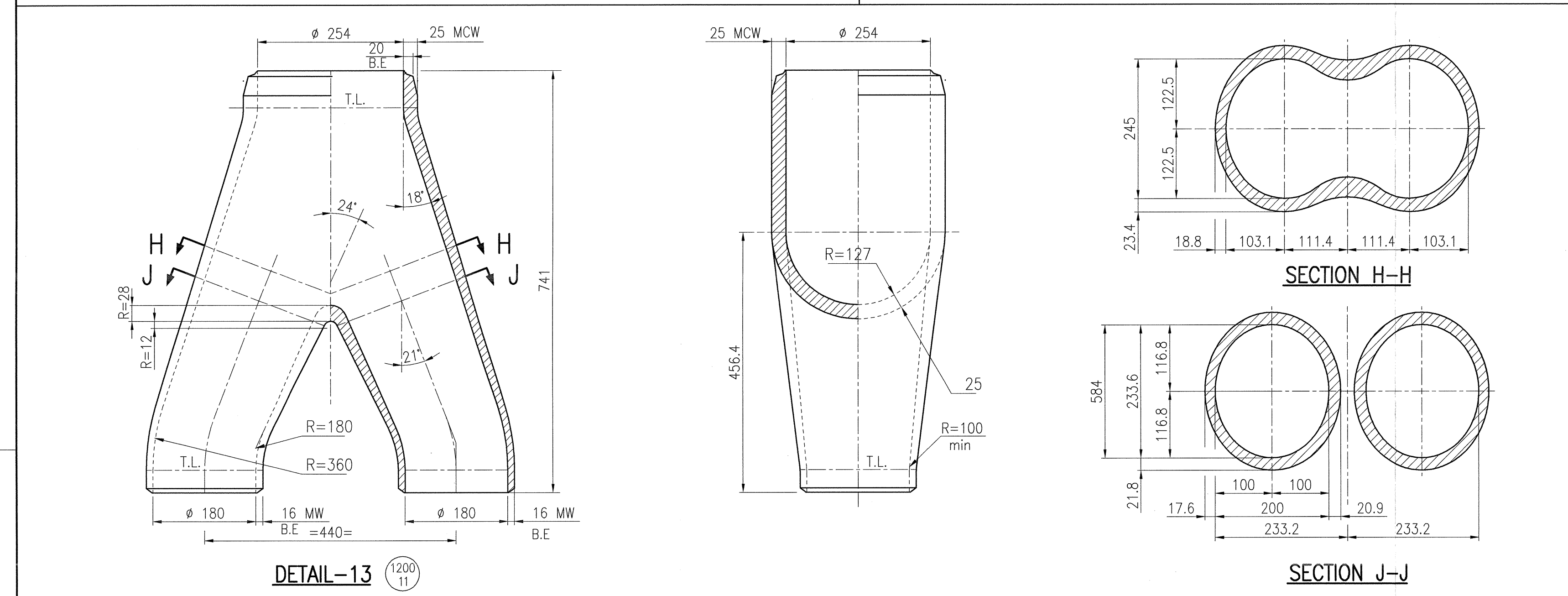
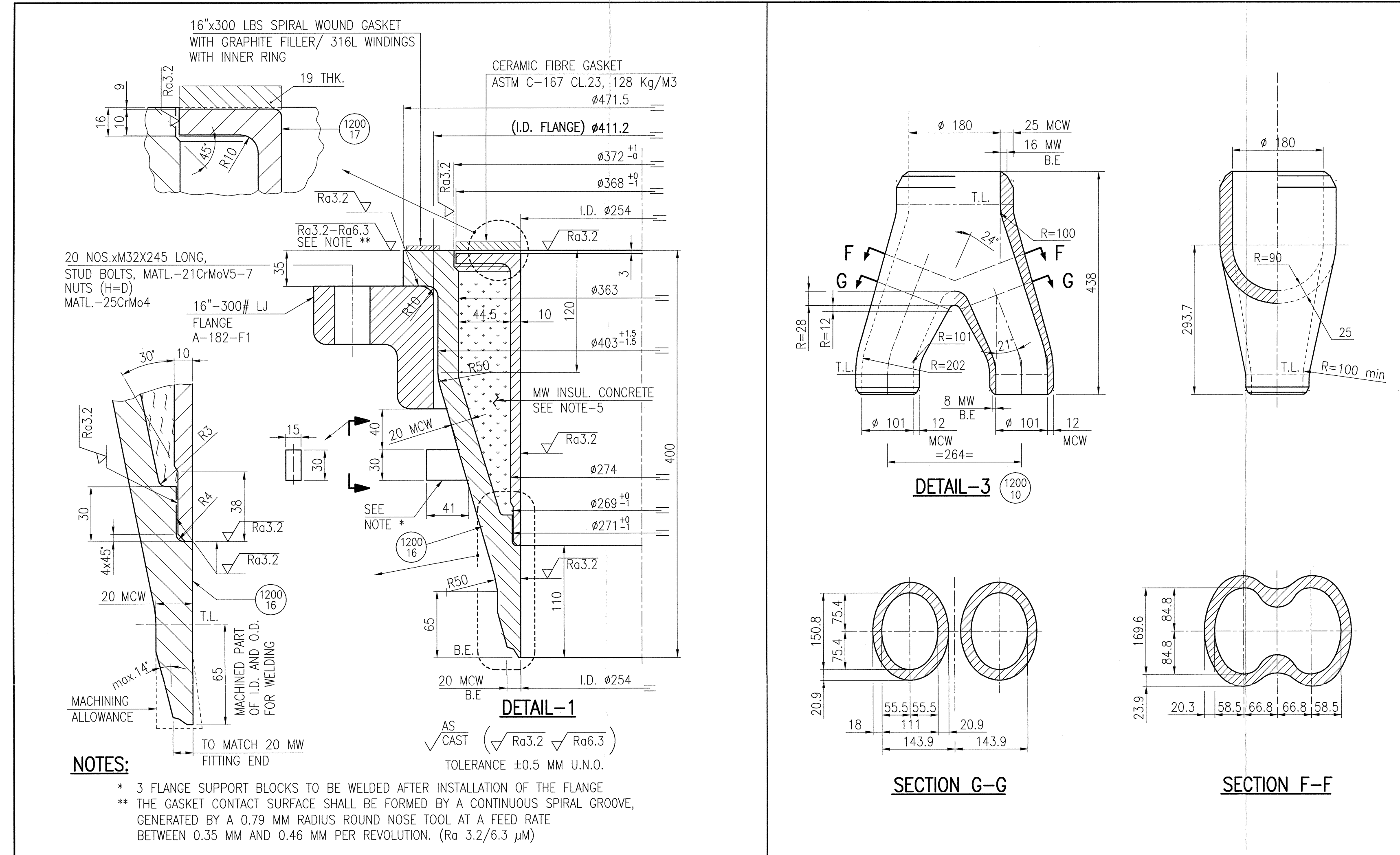




REFERENCE DRAWINGS:

BE62559DWG1100
BAG2559DWG1204
B062559DWG1235

GENERAL ARRANGEMENT
DETAILS VENTURI
CROSS-OVERS

GENERAL NOTES:

- ONE (1) RADIANT COIL ASSEMBLY IS DRAWN AS SHOWN IN PLAN VIEW.
- SIX (6) RADIANT COIL ASSEMBLIES REQUIRED PER HEATER. FOUR (4) HEATERS REQUIRED.
- ALL COIL PARTS SHALL HAVE A PIECE MARK IDENTIFICATION NUMBER AS PER THIS DRAWING.
- WELD BEVEL PREPARATION AS PER MANUFACTURERS STANDARD (SUBJECT TO LHT APPROVAL).
- LENGTH FOR ITEM NO. 120013 SHALL BE PROVIDED WITH 100 mm MAKE-UP LENGTH TO ALLOW SHOP HYDROTESTING. AFTER HYDROTEST PIPE SHALL BE CUT TO THE PROPER LENGTH BEFORE SHIPMENT.
- FOR 1200° C, DENSITY 1200kg/M³ (100° C DRIED), CONDUCTIVITY 0.27 W/M.K AT 400° C AND 0.35 W/M.K AT 800° C.
- ALL HEATER COIL PIECEMARKS SHALL BE IDENTIFIED (LABELLED) WITH AN UNIQUE NUMBER AS FOLLOWS:-

ABBREVIATIONS:

- MCW INDICATES: MINIMUM WALL THICKNESS AS CAST (WITHOUT MACHINING)
- MW INDICATES: MINIMUM WALL THICKNESS AFTER MACHINING (FOR TUBES IT INCLUDES 0.8 MM OUTSIDE SURFACE ROUGHNESS)
- AW INDICATES: AVERAGE WALL THICKNESS
- I.D. INDICATES: INSIDE DIAMETER
- O.D. INDICATES: OUTSIDE DIAMETER
- F.W. INDICATES: FIELD WELD
- B.E. INDICATES: BEVELLED END
- T.L. INDICATES: TANGENT LINE
- Pc.Mk. INDICATES: PIECE MARK NUMBER
- EL+ INDICATES: ELEVATION
- C.L. INDICATES: CENTER LINE
- PL. INDICATES: PLATE
- U.S. INDICATES: UNDERSIDE
- T.O. INDICATES: TOP OF
- TYP. INDICATES: TYPICAL

DESIGN CONDITIONS COIL:

DESCRIPTION	DESIGN PRESSURE Kg/cm ² (g)	DESIGN TEMPERATURE °C	MATERIAL	TEST PRESSURE Kg/cm ² (g)	SHOP HYDROST.	FIELD AIR
INLET FINGERS ITEM 120014/15 O.D. 48.3 x 3.68 AW	5.3	770 (3)	A312-TP347H	70	1.5	
INLET MANIFOLD ITEM 120013 O.D. 219.1 x 12.7 AW	5.3	770 (3)	A312-TP347H	70	1.5	
INLET TUBES ITEM 120001 I.D. 38 x 6.4 MW	2.0	1115 (2) 1065 (1)(2)	0.4C-25Cr-35Ni-Nb Microalloy	70	1.5	
INLET TUBES ITEM 120002 I.D. 38 x 6.4 MW	2.0	1115 (2) 1065 (1)(2)	0.4C-35Cr-45Ni-Nb Microalloy	70	1.5	
BOTTOM PARTS ITEM 120006/07/08 & 09 I.D. 101 x 6.4 MW	2.0	1115 (2) 1065 (1)(2)	0.4C-25Cr-35Ni-Nb Microalloy	70	1.5	
OUTLET TUBES ITEM 120003/04 I.D. 101 x 8.0 MW	1.7	1125 (2) 1065 (1)(2)	0.4C-35Cr-45Ni-Nb Microalloy	70	1.5	
OUTLET TUBES ITEM 120005 I.D. 101 x 8.0 MW	3.56	900 (2) 950 (1)(2)	0.1C-20Cr-32Ni-Nb	70	1.5	
WYE PIECE ITEM 120010 I.D. 101 x I.D. 180	3.56	900 (2) 950 (1)(2)	0.1C-20Cr-32Ni-Nb	70	1.5	
WYE PIECE AND TEE PIECE, RESP. ITEM 120011 & 12 I.D. 180 x I.D. 254 & I.D. 254	3.56	900 (2) 950 (1)(2)	0.1C-20Cr-32Ni-Nb	70	1.5	
OUTLET CONE ITEM 120016 & 17	3.56	900 (2) 950 (1)(2)	0.1C-20Cr-32Ni-Nb	70	1.5	

(1) SHORT TERM DESIGN CONDITIONS (1000 HOURS).

(2) DESIGN CODE: LUMMUS STD.

(3) DESIGN CODE: ASME B31.3

Pc.Mk. No.	TOTAL NR. REQ'D	REMARKS
Pc.Mk.112001	24	AS DRAWN
Pc.Mk.112002	24	AS DRAWN
Pc.Mk.112003	24	AS DRAWN

PLANT NORTH

KEY-PLAN

PROJECT TITLE: BRAHMAPURA PETROCHEMICAL COMPLEX PROJECT

LOCATION: LEPEKATA, DIBRUGARH, ASSAM

OWNER: BRAHMAPURA CRACKER & POLYMER LTD.

HEATER: 13-F-101 THRU 113-F-104

LHT REF. NO.: 62559

Lummus Technology Heat Transfer
Bloomfield, N.J.

RADIANT COIL

SCALE: 1:15 BE62559DWG1200

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