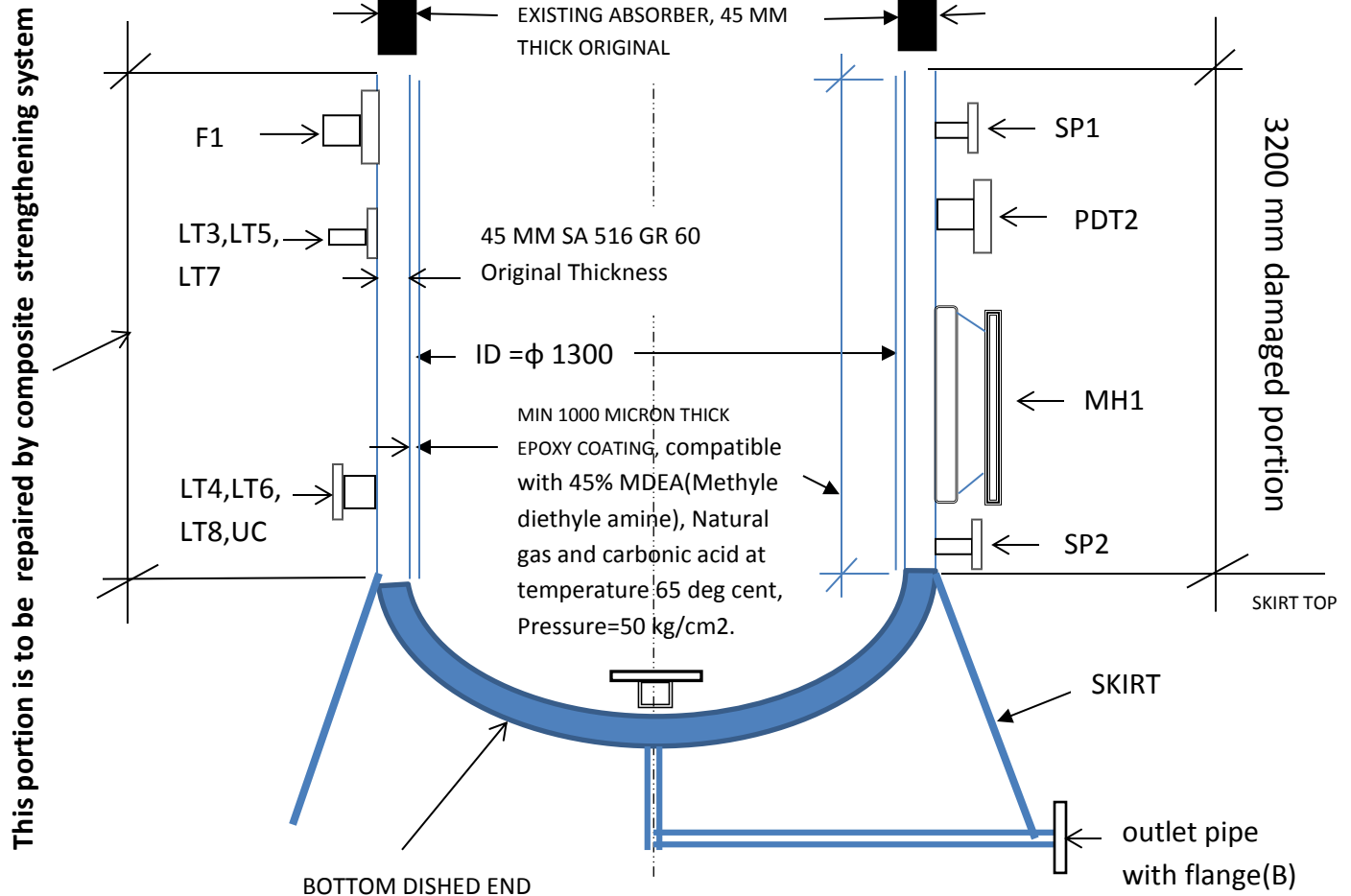




COMPOSITE REPAIR OF ABSORBER COLUMN UP TO 3200 MM ELEVATION FROM SKIRT TOP.

Internal repair system:-

- (1) Minimum possible surface finish as required for epoxy coating.
- (2) Inside surface(only column inside surface without nozzles opening) shall be coated by chemical resistance epoxy compatible with 45% MDEA(Methyle diethyle amine), Natural gas and carbonic acid at temperature 65 deg cent, Pressure=50 kg/cm2 up to minimum thickness 1000 micron including cold repaired plate bonding method(if required) and epoxy fill up up to nearest parent metal original thickness.
- (3) Necessary test for coating bonding inspection and coating thickness measurement to be carry out and report to be submitted.
- (4) All valid certificates related to materials as well test to be produced before start of job.

Outside repair system:-

- (1) Outside composite repair shall be complied with ASME PCC-2, Article 4.1 / ISO 24817.
- (2) Minimum possible surface finish as required for outside composite strengthening system.
- (3) Outside surface(only column outside surface without nozzles) strengthening shall be carried out by resin and fibre (carbon or glass or hybrid) up to minimum thickness 4 mm including final surface finish.
- (4) Necessary Shore D hardness measurement test for outside composite strengthening system, minimum 55 shore D required and outside coating thickness measurement to be carry out and report to be submitted.
- (5) All valid certificates related to materials as well test to be produced before start of job.
- (6) Complete composite repair system shall be guaranteed up to 3 years without any leakage till the guarantee period.

N.B:- (1) All sharp corners/edges are well finished. (2) Perfect flat surface
(3) Absolutely void free,(4) All dimensions are in mm, For other details
see Drg. No-TPE765-910-01,REV 4

DRAWING NO:-
BCPL/LAKWA/ABSORBER/02