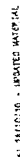


FIELD WELD



CUSTOMER: BCPL / "INDIA"

RADIANT COIL AND INLET ASSEMBLY

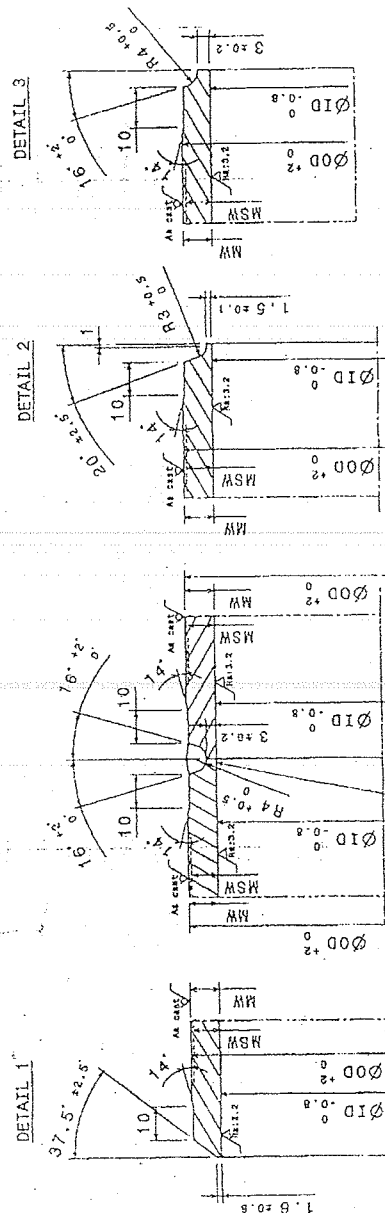
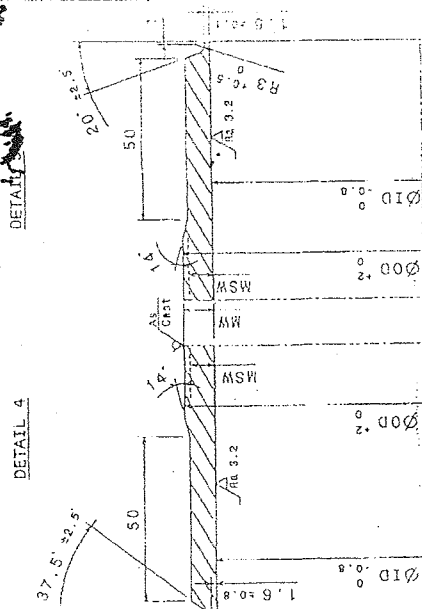
HEATER 113-FF-101 THRU 113-FF-104

DRAWING NO. BCPL/COIL/01

SEE DETAIL OF BEVEL IN TABLE



Ra:6.3/EVERYWHERE
EXCEPT INDICATION



FULL PENETRATION
WELD GRINDING

3) 26/10/10 - ADDED M¹ - UPDATED MATERIAL
A) 07/10/10 - UPDATED ITEMS N² AND ADDED DETAIL CA

CUSTOMER: BCPL / "INDIA"

CENTRIFUGALLY CAST TUBES

HEATER 113-FF-101 THRU 113-FF-104

DRAWING NO. BCPL/COIL/02

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ITEM	ID	OD	MW	MSW	LENGTH	MATERIAL	DETAILS	QTY	Nb SECT°	SECT° MINI	SHOP. HYDRO. TEST
120001	ø38	ø50.8	6.4	5.6	9290±8	M-1	1-A-3	672±56	5 MAXI	915	70 Kg/cm²
120002	ø38	ø50.8	6.4	5.6	2800±2	M-2	2-3	672±56	1 MAXI	/	

M-1

Alloy 25 Cr-35 Ni+Nb Micro alloyed Cast tubes																	
					Chemical Composition												
ID	OD	M W	MS W	Length	Cr	Ni	Nb	W	Si	C	Mn	S	P	Mo	Pb As Zn Sn	Cu	Al
ø38	ø50.8	6.4	5.6	9290±8	24 to 27	34 to 37	0.8 to 1.2	0.03 Max	**	0.37 to 0.5	1.5 Max	0.030 Max	0.030 Max	0.5 Max	(each) 100 ppm	0.25 Max	0.05 Max

M-2

Alloy 35 Cr-45 Ni+Nb Micro alloyed Cast tubes																	
					Chemical Composition												
ID	OD	M W	MS W	Length	Cr	Ni	Nb	W	Si	C	Mn	S	P	Mo	Pb As Zn Sn	Cu	Al
ø38	ø50.8	6.4	5.6	2800±2	30 to 37	40 to 47	0.5 to 1.5	0.3 Max	1.2 to 1.8	0.40 to 0.60	1.5 Max	0.030 Max	0.030 Max	0.5 Max	(each) 100 ppm	0.25 Max	0.05 Max

CUSTOMER: BCPL / "INDIA"

CENTRIFUGALLY CAST TUBES

HEATER 113-FF-101 THRU 113-FF-104

DRAWING NO. BCPL/COIL/02
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