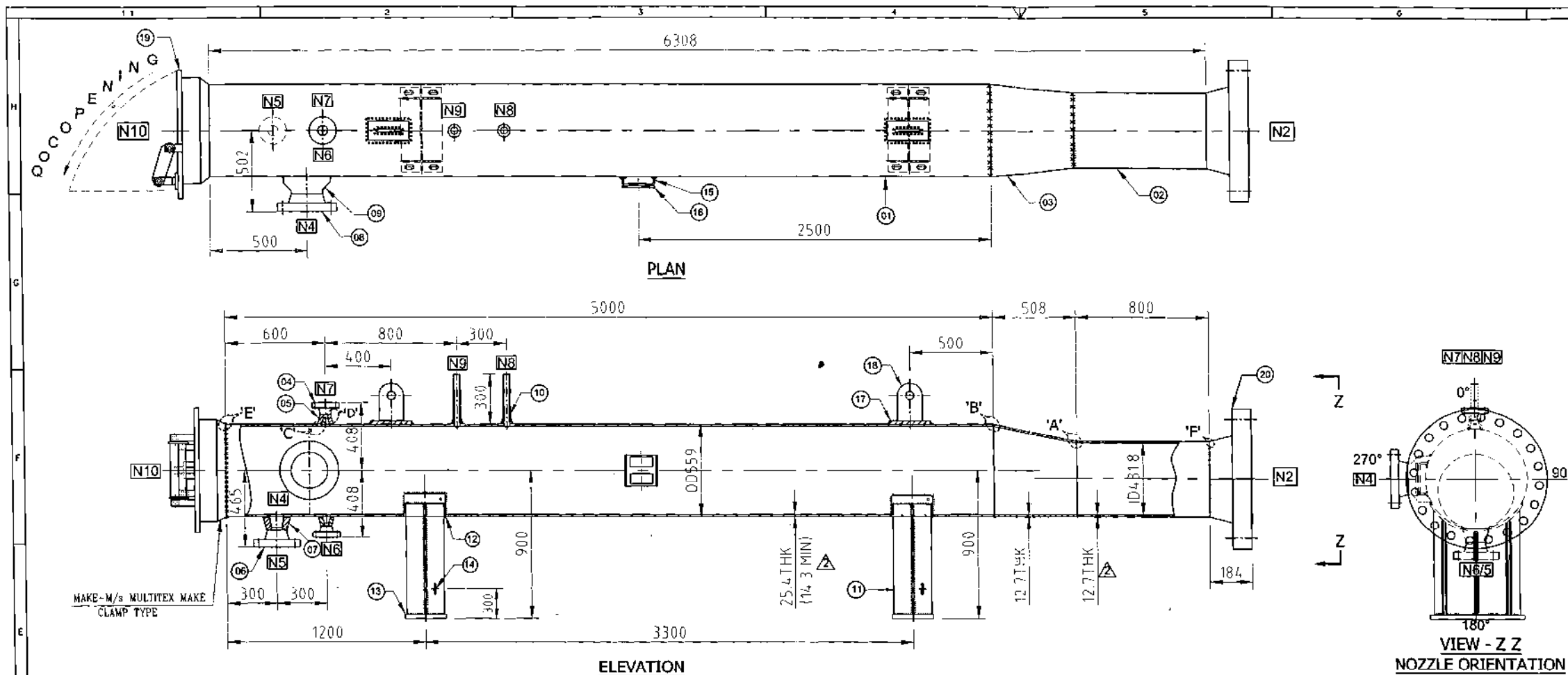




TECHNICAL INFORMATION		TAG NO. 013-ML-101	QTY. TWO
OPERATING CONDITIONS		DESIGN CONDITIONS	
FLUID HANDLED	RICH / LEAN GAS	DESIGN CODE	ASME B31.8 FOR BARREL, NECK & REDUCER
OPER. PRESS.	-	DESIGN PRESSURE	ASME SEC VIII DIV 1 FOR QUICK OPENING CLOSURE
OPER. TEMP.	-	ASME CODE STAMPING	NO
FLOW RATE	-	DESIGN FACTOR	1.5
DENSITY	-	DESIGN TEMP	65° C
WIND SPEED / LOAD	**	MDMT AT MAWP	-29° C
WIND DESIGN SPEC.	**	ANSI RATING	600#
SEISMIC DESIGN SPEC.	**	CORROSION ALLOWANCE	3.0 MM
SEISMIC ZONE	**	SERVICE	RICH / LEAN GAS
** DATA IS TO BE FURNISHED BY THE CUSTOMER			
CLEATS FOR		RADIOGRAPHY	100%
PLATFORM/LADDERS	NO	WELD JOINT EFF	1.0
PIPING	NO	IMPACT TESTING	YES
INSULATION	NO	PWHT	NO
INTERNAL	NO	HYDRO TEST PRESS.	115.5 Kg/Cm ² g
OTHER	NO	HYDRO TEST TEMP	-48° C
		INSPECTION AGENCY	EIL
		INSULATION THK.	NO
		EMPTY WEIGHT	2300 Kg
		WATER FILLED WEIGHT	3550 Kg

NOZZLE SCHEDULE						
LOCATION	NOZZLE	SIZE NPS	SCH / BORE	QTY.	FLANGE TYPE CLASS (MM.)	SERVICE
MAJOR BARREL	N4	150	SCH XXS	01	WNRF 600#	502 JOCKER CONN.
	N5	100	SCH XXS	01	WNRF 600#	485 BRAIN CONN.
	N6	50	SCH XXS	01	WNRF 600#	408 UTILITY CONN.
	N7	50	SCH XXS	01	WNRF 600#	408 VENT CONN.
	N8	20	SCH XXS	01	PE -	PR GAUGE CONN.
MINOR BARREL	N9	40	SCH XXS	01	PE -	PSV CONN.

PAINTING

SURFACE PREPARATION

SURFACE PREPARATION :- BY SHOT BLASTING TO SP-6 IN ACCORDANCE WITH SSPC-VIS-1

ALL MACHINED PARTS SHALL BE COATED WITH ANTIRUST REMOVABLE PAINT & NON MACHINED PARTS SHALL BE APPLIED WITH TWO COATS OF PROTECTIVE PAINTS.

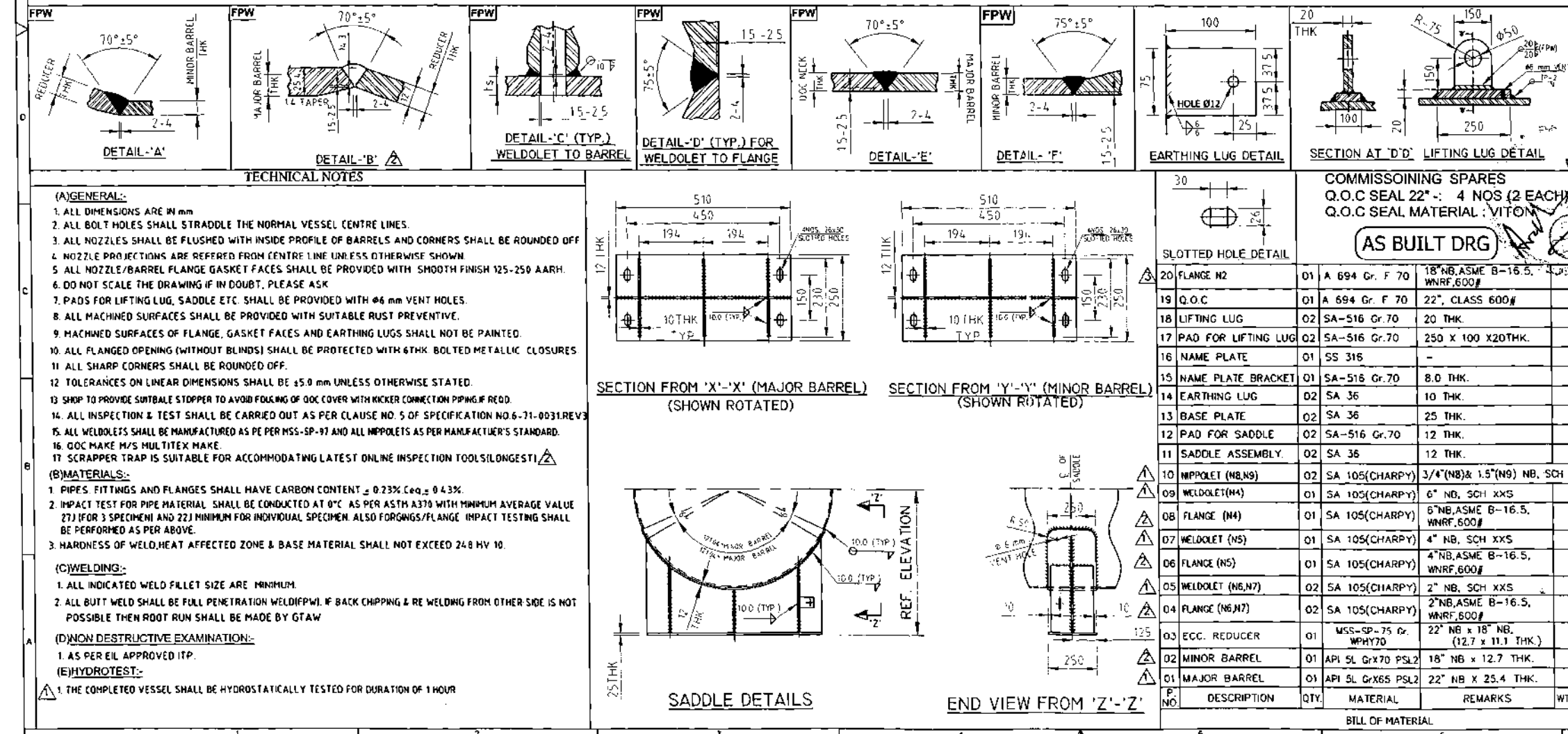
- ONE COAT OF EPOXY ZINC PHOSPHATE PRIMER WITH 50μ (MICRONS).
 - TWO COATS OF HIGH BUILD EPOXY FINISH COATING WITH 125μ (MICRONS) [EACH COAT / PER COAT] REFER ATTACHED PAINTING REPORT.
- INTERNAL : NIL

DATA SHEET NO : 1207-014-16-71-DS-01 REV.0
ADDENDUM NO : 1207-014-16-71-AD-03 REV.0
SPECIFICATION NO : 6-71-0031 REV.3

APPLICABLE DRG.			
S.NO	APPLICABLE DRG. Nos	DESCRIPTION	
1	WC348/SL01/K36L18/A3/02	NAME PLATE DETAIL PIG LAUNCHER	
2	WC348/SL01/K36L18/A3/03	PIG HANDLING DEVICE FOR PIG LAUNCHER	
3	WC348/QOC04/K36L18/A3/01	QOEC	
3	REVISED AS PER COMMENTS	MAAN	Y.L.M A.K.R.12.02.10
2	REVISED AS PER COMMENTS	MAAN	Y.L.M A.K.R.05.01.10
1	REVISED AS PER COMMENTS	MAAN	Y.L.M A.K.R.14.12.09
0	ISSUED FOR APPROVAL	MAAN	Y.L.M A.K.R.18.09.09
ISS.	REVISION	DRN	CHD APPD DATE

PROJECT BRAHMAPUTRA PETROCHEMICAL COMPLEX PROJECT.
CUSTOMER M/S BRAHMAPUTRA CRACKER AND POLYMER LTD.
CONSULTANT ENGINEERS INDIA LTD.
INSPECTION EIL
P.O. NO. 1207-014-QF-P0-9040/0503/002, DATED 16.09.09

MULTITEX		217, HANS BHAWAN, B.S.Z. MARG, NEW DELHI-110002	
G.A. DRG. AND FABRICATION DETAILS OF PIG LAUNCHER (18" X 22" 600#)			
DRN	DESIGN	CHD	DRAWING NO.
MAAN	AKR	Y.L.M	WC348/SL01/K36L18/A2/01
APPD	DATE	SCALE	ISS.
AKR	18.09.09	NTS	1



- (A) GENERAL:**
- ALL DIMENSIONS ARE IN mm
 - ALL BOLT HOLES SHALL STRADDLE THE NORMAL VESSEL CENTRE LINES.
 - ALL NOZZLES SHALL BE FLUSHED WITH INSIDE PROFILE OF BARRELS AND CORNERS SHALL BE ROUNDED OFF
 - NOZZLE PROJECTIONS ARE REFERRED FROM CENTRE LINE UNLESS OTHERWISE SHOWN
 - ALL NOZZLE/BARREL FLANGE GASKET FACES SHALL BE PROVIDED WITH SMOOTH FINISH 125-250 AARH.
 - DO NOT SCALE THE DRAWING IF IN DOUBT, PLEASE ASK
 - PADS FOR LIFTING LUG, SADDLE ETC. SHALL BE PROVIDED WITH 6mm VENT HOLES.
 - ALL MACHINED SURFACES SHALL BE PROVIDED WITH SUITABLE RUST PREVENTIVE.
 - MACHINED SURFACES OF FLANGE, GASKET FACES AND EARTHING LUGS SHALL NOT BE PAINTED.
 - ALL FLANGED OPENING (WITHOUT BLINDS) SHALL BE PROTECTED WITH 6THK BOLTED METALLIC CLOSURES
 - ALL SHARP CORNERS SHALL BE ROUNDED OFF.
 - TOLERANCES ON LINEAR DIMENSIONS SHALL BE ±0.5 mm UNLESS OTHERWISE STATED.
 - SHOP TO PROVIDE SUITABLE STOPPER TO AVOID FOLKING OF QOC COVER WITH NICKER CONNECTION PIPING IF REQD.
 - ALL INSPECTION & TEST SHALL BE CARRIED OUT AS PER CLAUSE NO. 5 OF SPECIFICATION NO. 6-71-0031 REV.3
 - ALL WELDOLETS SHALL BE MANUFACTURED AS PER MSS-SP-97 AND ALL WELDOLETS AS PER MANUFACTURER'S STANDARD.
 - QOC MAKE M/S MULTITEX MAKE
 - SCRAPPER TRAP IS SUITABLE FOR ACCOMMODATING LATEST ONLINE INSPECTION TOOLS (LONGEST)
- (B) MATERIALS:**
- PIPES, FITTINGS AND FLANGES SHALL HAVE CARBON CONTENT ≤ 0.23% Ceq ≤ 0.43%
 - IMPACT TEST FOR PIPE MATERIAL SHALL BE CONDUCTED AT 0°C AS PER ASTM A370 WITH MINIMUM AVERAGE VALUE 27J FOR 3 SPECIMEN AND 22J MINIMUM FOR INDIVIDUAL SPECIMEN. ALSO FOR GWS/FLANGE IMPACT TESTING SHALL BE PERFORMED AS PER ABOVE.
 - HARDNESS OF WELD, HEAT AFFECTED ZONE & BASE MATERIAL SHALL NOT EXCEED 248 HV 10
- (C) WELDING:**
- ALL INDICATED WELD FILLET SIZE ARE MINIMUM.
 - ALL BUTT WELD SHALL BE FULL PENETRATION WELD (FPW). IF BACK CHIPPING & RE WELDING FROM OTHER SIDE IS NOT POSSIBLE THEN ROOT RUN SHALL BE MADE BY GTAW
- (D) NON DESTRUCTIVE EXAMINATION:**
- AS PER EIL APPROVED ITP.
- (E) HYDROTEST:**
- THE COMPLETED VESSEL SHALL BE HYDROSTATICALLY TESTED FOR DURATION OF 1 HOUR