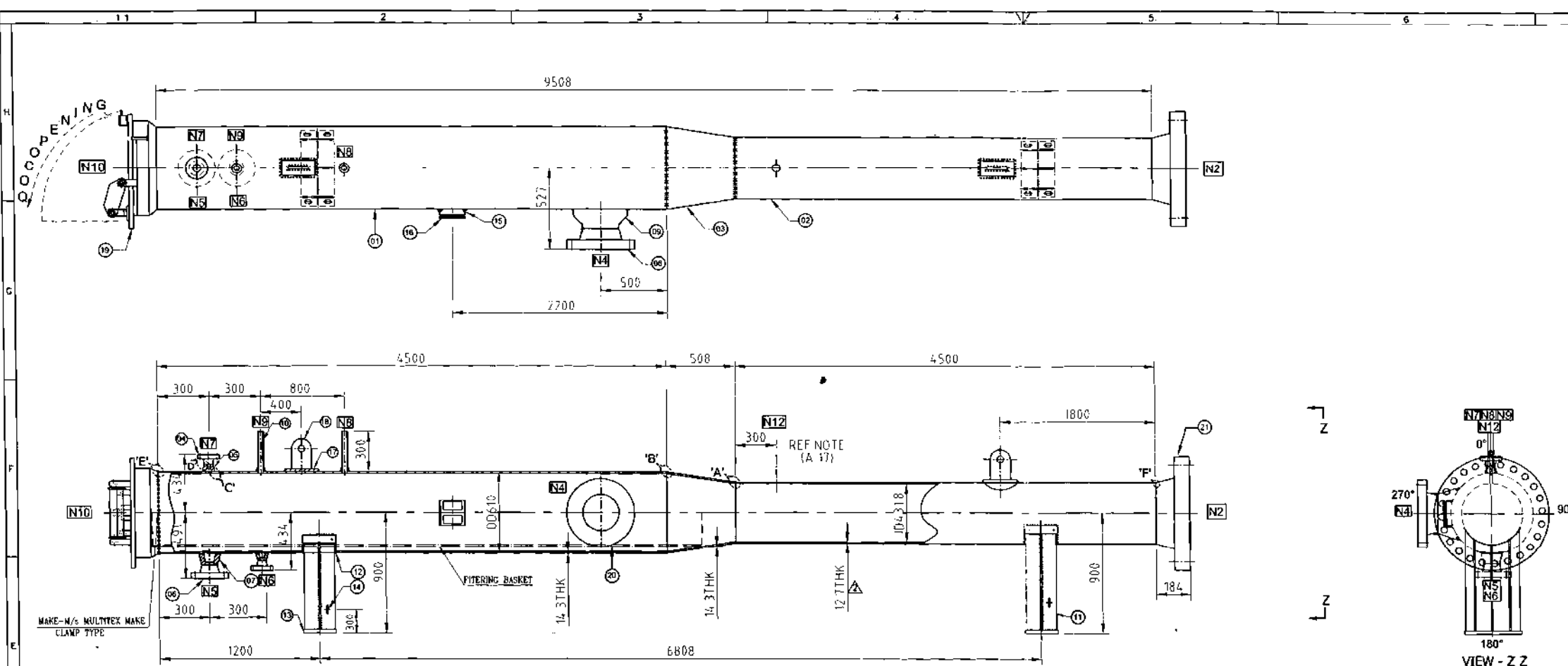




TECHNICAL INFORMATION		TAG NO. 101-MR-101	QTY. TWO
OPERATING CONDITIONS		DESIGN CONDITIONS	
FLUID HANDLED	RICH/LEAN GAS	DESIGN CODE	ASME B31.3 FOR BARREL, NECK & REDUCER
OPER. PRESS.	-	ASME CODE STAMPING	NO
OPER. TEMP.	-	DESIGN PRESSURE	82.5 Kg. Cm ² g
FLOW RATE	-	DESIGN FACTOR	1.5
DENSITY	-	DESIGN TEMP	65° C
WIND SPEED / LOAD	-	MDMT AT HAWP	-29° C
WIND DESIGN SPEC.	-	ANSI RATING	600R
SEISMIC DESIGN SPEC	-	CORROSION ALLOWANCE	3.0 MM
SEISMIC ZONE	-	SERVICE	RICH/LEAN GAS
** DATA IS TO BE FURNISHED BY THE CUSTOMER.		NACE	NO
CLEATS FOR		RADIOGRAPHY	100%
PLATFORM/LADDERS	NO	WELD JOINT EFF.	1.0
PIPING	NO	IMPACT TESTING	NO
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	2900 Kg (APPROX)
		WATER FILLED WEIGHT	5000 Kg (APPROX)

NOZZLE SCHEDULE							
LOCATION	NOZZLE	SIZE NPS	SCH/BOR	QTY.	FLANGE TYPE	CLASS	(NM) PROL. SERVICE
MAJOR BARREL	N4	150	SCH XXS	01	WNRF	600#	527 BY PASS CONN.
	N5	100	SCH XXS	01	WNRF	600#	401 DRAIN CONN.
	N6	50	SCH XXS	01	WNRF	600#	434 UTILITY CONN.
	N7	50	SCH XXS	01	WNRF	600#	434 VENT CONN.
	N8	20	SCH XXS	01	PE	-	PR GAUGE CONN.
MINOR BARREL	N9	40	SCH XXS	01	PE	-	PSV CONN.
	N12	REF. NOTE-17	-	01	-	-	HOLE FOR PIG SIGNALLER

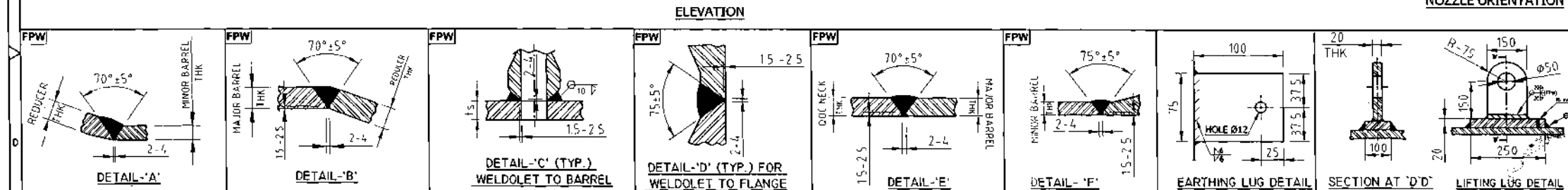
PAINTING

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



(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 Ø6 mm 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 ±5.0 mm UNLESS OTHERWISE STATED.
- SHOP TO PROVIDE SUITABLE STOPPER TO AVOID FOULING OF OGC COVER WITH KKKER 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 WELDMENTS SHALL BE MANUFACTURED AS PER MSS-SP-97 AND ALL NIPPLES AS PER MANUFACTURER'S STANDARD.
- OGC MAKE M/S MULTITEX MAKE
- Ø38 mm HOLE TO BE DRILLED IN MINOR BARREL TO MATCH INSIDE DIA. OF WELD BASE OF PIG SIGNALLER.
- PIG SIGNALLER MAKE M/S IMPRE PRODUCTS, UK.
- SCRAPER 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 FORGINGS/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:-

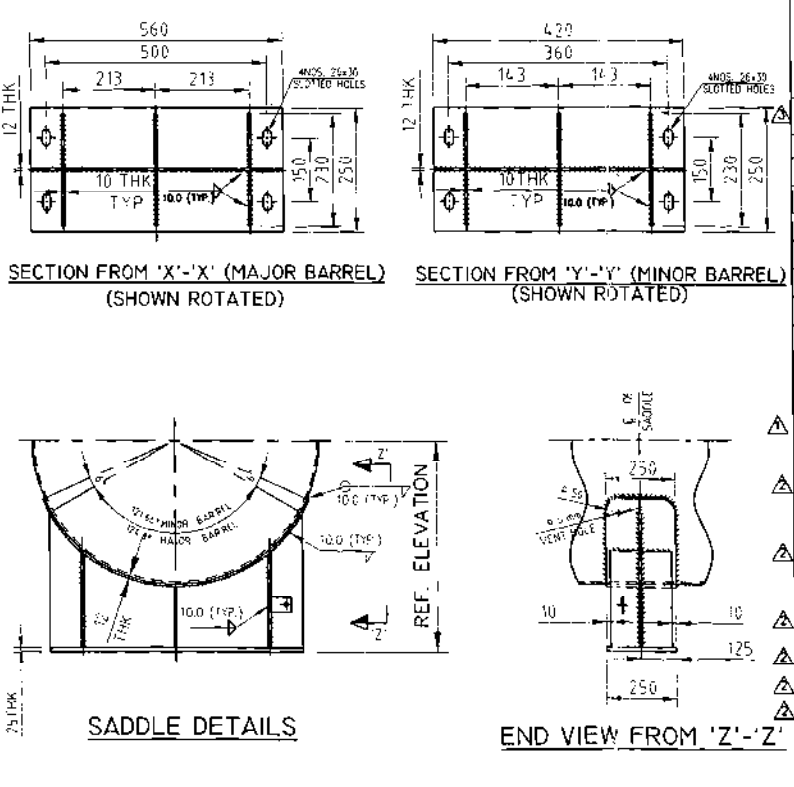
- ALL INDICATED WELD FILLET SIZE ARE MINIMUM.
- ALL BUTT WELD SHALL BE FULL PENETRATION WELD (FPW). IF BACK CHIPPING & RE WELDING FROM OTHER SIDE IS NOT POSSIBLE THEN ROOT RUN SHALL BE MADE BY GTAW.

(D) NON DESTRUCTIVE EXAMINATION:-

- AS PER EIL APPROVED ITP.

(E) HYDROTEST:-

- THE COMPLETED VESSEL SHALL BE HYDROSTATICALLY TESTED FOR DURATION OF 1 HOUR.



Q.O.C SEAL 24" : 4 NOS (2 EACH)
Q.O.C SEAL MATERIAL : VITON

Handwritten signature and initials.

AS BUILT DRG

SLOTTED HOLE DETAIL

21	FLANGE N2	01	A 694 Gr. F 70	18"NB,ASME B-16.5, WNRF,600#	
20	FILTERING BASKET ASSY.	01	REF. DRG. No. WC348/SR01/K36L18/A3/04		
19	O.Q.C.	01	A 694 Gr. F 70	24", CLASS 600#	
18	LIFTING LUG	02	SA-516 Gr.70	20 THK.	
17	PAD FOR LIFTING LUG	02	SA-516 Gr.70	250 X 100 X20THK.	
16	NAME PLATE	01	SS 316	-	
15	NAME PLATE BRACKET	01	SA-516 Gr.70	8.0 THK.	
14	EARTHING LUG	02	SA-36.	10 THK.	
13	BASE PLATE	02	SA-36.	25 THK.	
12	PAD FOR SADDLE	02	SA-516 Gr.70	12 THK.	
11	SADDLE ASSEMBLY.	02	SA-36	12 THK.	
10	NIPPOLET (N8,N9)	02	SA 105(CHARPY)	3/4"(N8)& 1.5"(N9) NB, SCH XXS	
09	WELDOLET (N4)	01	SA 105(CHARPY)	6" NB, SCH XXS	
08	FLANGE (N4)	01	SA 105(CHARPY)	6"NB,ASME B-16.5, WNRF,600#	
07	WELDOLET (N5)	01	SA 105(CHARPY)	4" NB, SCH XXS	
06	FLANGE (N5)	01	SA 105(CHARPY)	4"NB,ASME B-16.5, WNRF,600#	
05	WELDOLET (N6,N7)	02	SA 105(CHARPY)	2" NB, SCH XXS	
04	FLANGE (N6,N7)	02	SA 105(CHARPY)	2"NB,ASME B-16.5, WNRF,600#	
03	CON. REDUCER	01	MSS-SP-75 Gr. WPHY70	24" NB x 18" NB, (14.3 x 11.1 THK.)	
02	MINOR BARREL	01	API 5L GRX70 PSL2	18" NB x 12.7 THK.	
01	MAJOR BARREL	01	API 5L GRX70 PSL2	24" NB x 14.3 THK.	
P NO	DESCRIPTION	QTY.	MATERIAL	REMARKS	

BILL OF MATERIAL

DATA SHEET NO : 1207-014-16-71-DS-02 REV 0 A			
ADDERDUM NO : 1207-014-16-71-AD-03 REV.1			
SPECIFICATION NO : 6-71-0031 REV.3			
RECEIVER		PIG SIGNALER MOUNTED ON RECEIVER	
101-MR-101		101-XXS-3102	
013-MR-101		013-XXS-3402	
APPLICABLE DRG.			
S.NO.	APPLICABLE DRG. Nos.		DESCRIPTION
1.	WC348/SR01/K36L18/A3/02		NAME PLATE DETAIL PIG RECEIVER
2.	WC348/SR01/K36L18/A3/03		PIG HANDLING DEVICE FOR PIG RECEIVER
3.	WC348/SR01/K36L18/A3/04		FILTERING BASKET ASSY. DETAIL
4.	WC348/QOC05/K36L18/A3/01		FILTERING BASKET ASSY. DETAIL
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 10.12.09
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-QP-PO-8040/0500/002, DATED 18.09.09	
		MULTITEX	
		217,HANS BHAWAN,B.S.Z.MARG,NEW DELHI-110002	
TITLE :-		G.A. DRG. AND FABRICATION DETAILS OF PIG RECEIVER [18"x 24"-600#]	
DRN	DESIGN	CHD	DRAWING NO. WC348/SR01/K36L18/A2/01
MAAN	AKR	Y.L.M	
APPD	DATE	SCALE	
AKR	18.09.09	NTS	
			
ISS			0 1 2 3 4 5 6 7 8 9 10 11 12