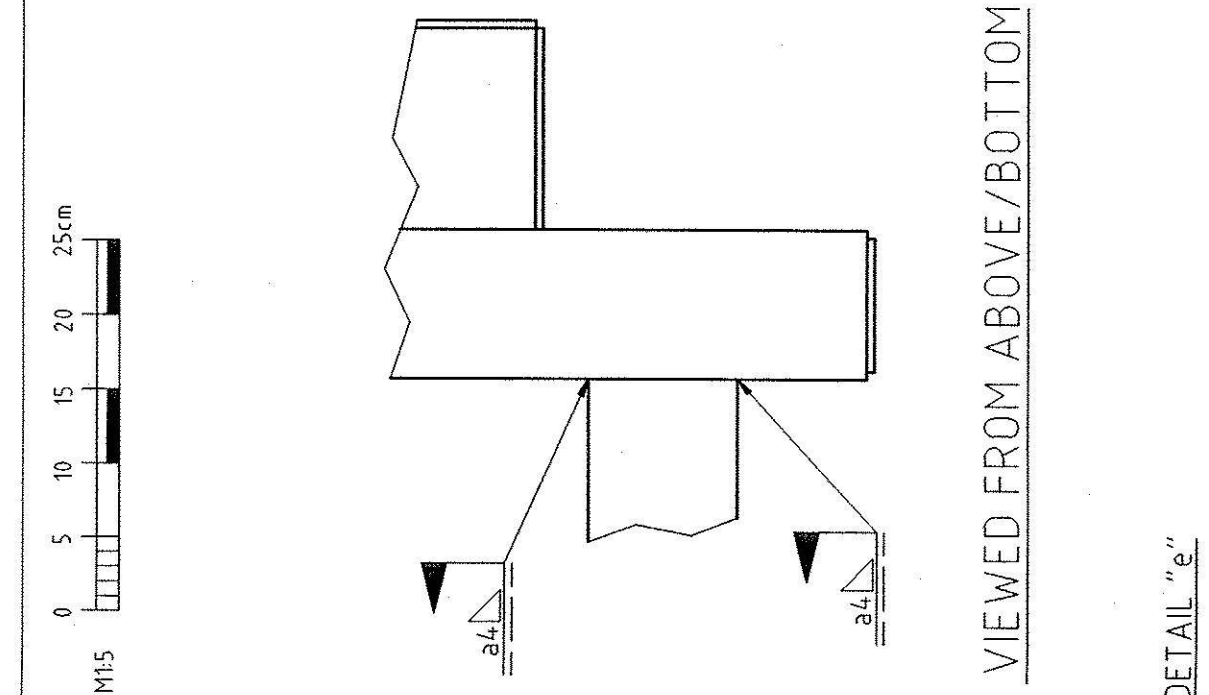
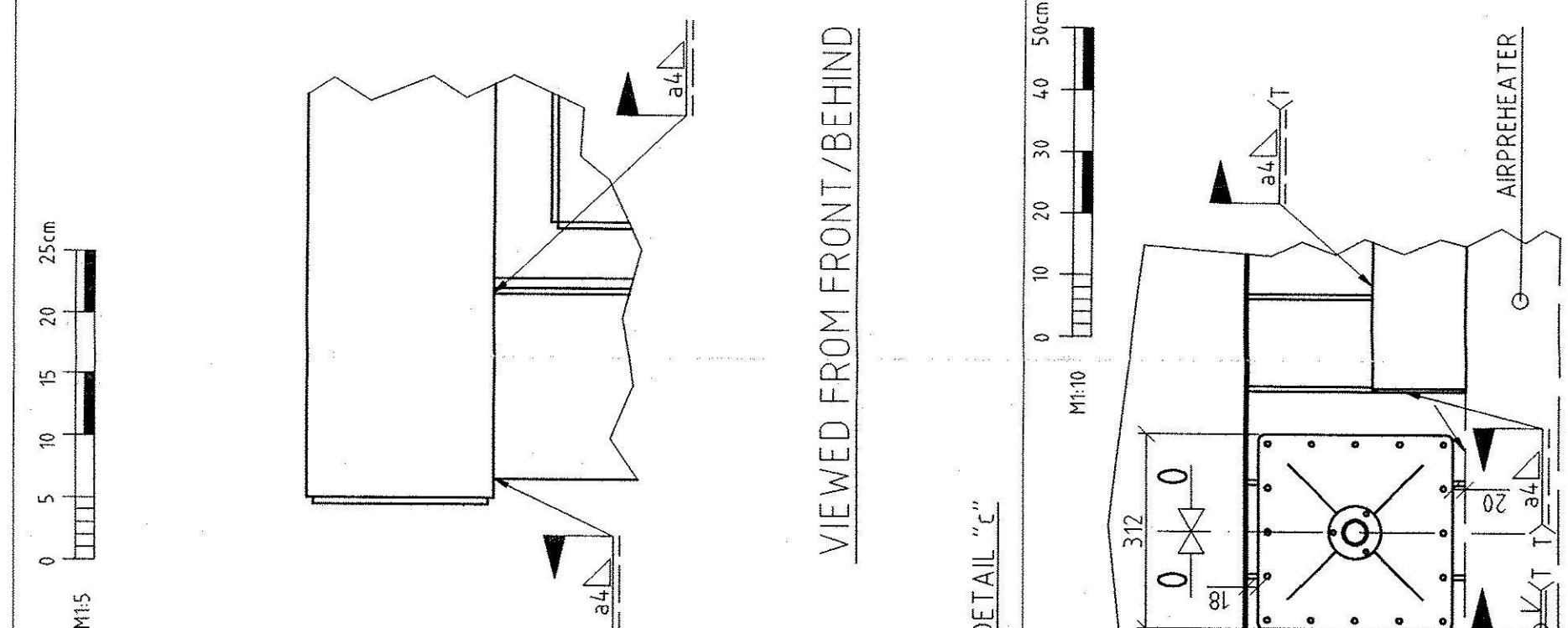
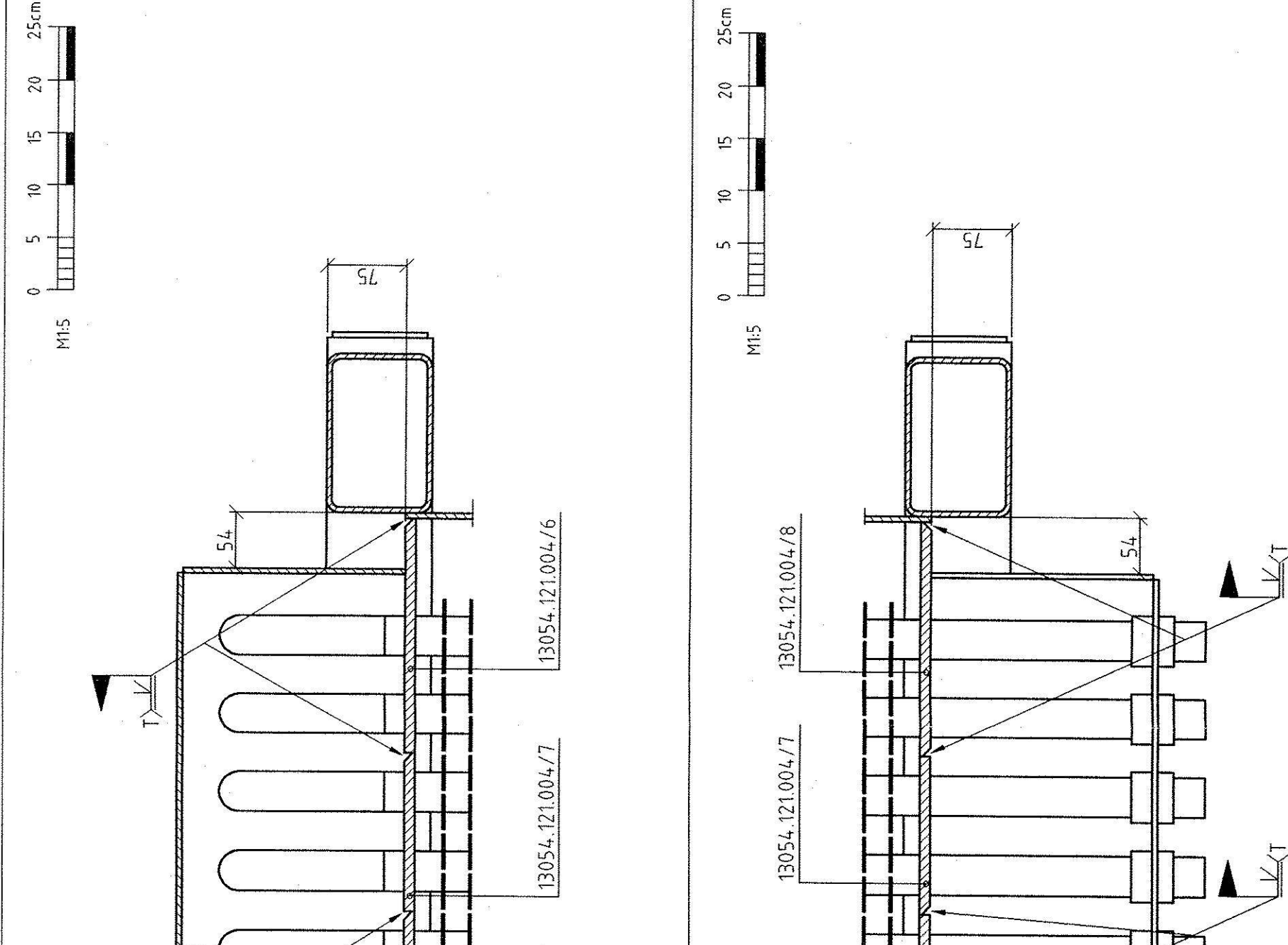
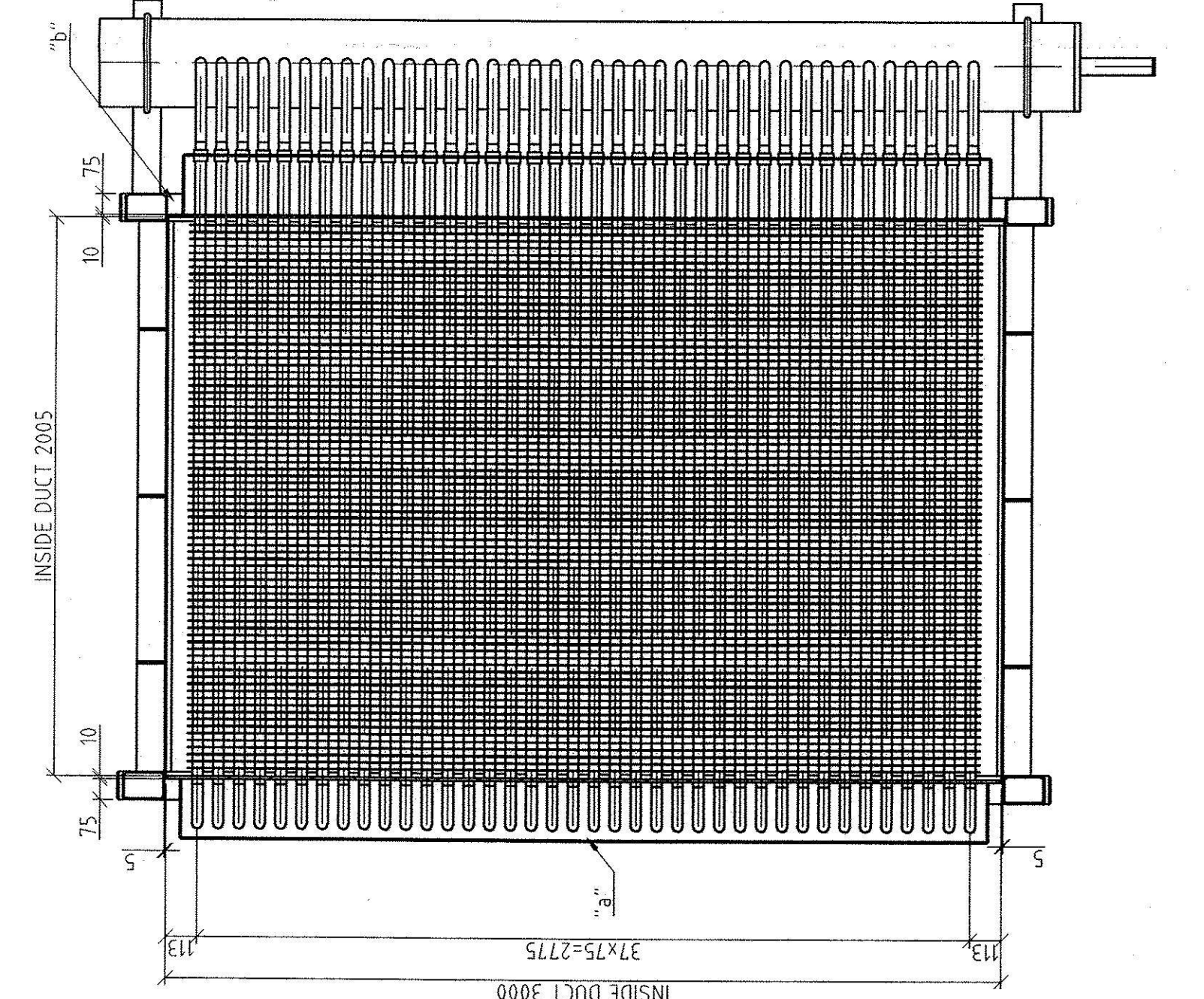
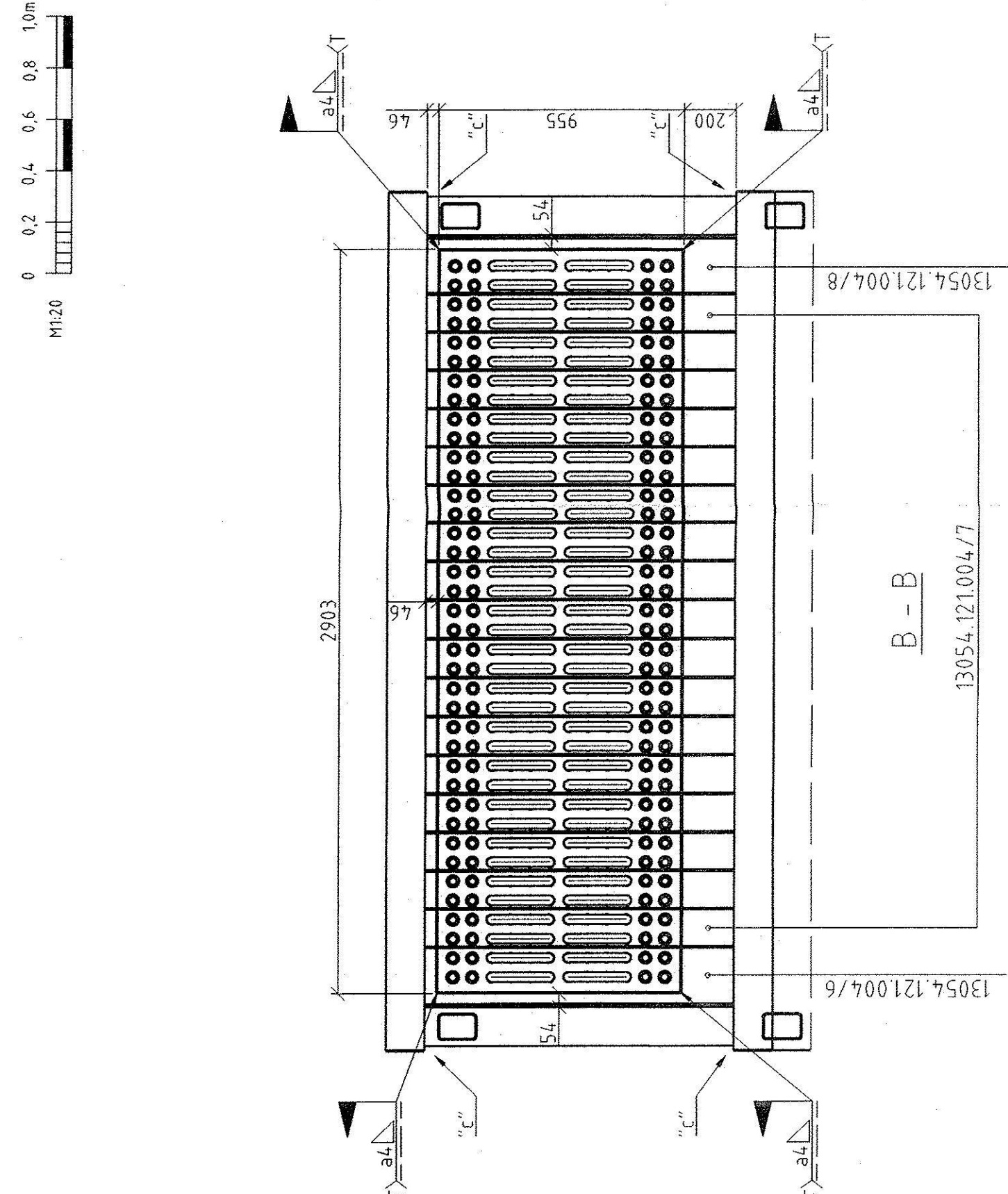




| SEE SUBASSEMBLY DRAWINGS AND DETAILS |                |                                   |
|--------------------------------------|----------------|-----------------------------------|
| PART NR.                             | DWG NR         | DWG TITLE                         |
| 1                                    | 1305/4.200.001 | ECONOMIZER 1 CASING PLATE PARTS   |
| 2                                    | 1305/4.221.004 | ECONOMIZER 1 TUBES AND TUBE PLATE |
| 3                                    | 1305/4.221.002 | ECONOMIZER 1 INLET HEADER         |
| 4                                    | 1305/4.221.003 | ECONOMIZER 1 OUTLET HEADER        |

| CODE                              | PED / EN 12952     |
|-----------------------------------|--------------------|
| SERIAL NUMBER                     | -                  |
| DESIGN PRESSURE                   | 1.6 MPa            |
| HYDROSTATIC TEST PRESSURE         | 2.4 MPa            |
| DESIGN TEMPERATURE <sup>(1)</sup> | 204 °C             |
| CORROSION ALLOWANCE               | 10 mm              |
| VOLUME                            | 127 m <sup>3</sup> |
| HAZARD CATEGORY                   | IV                 |
| CONFORMITY ASSESSMENT MODULE      | G                  |
| *WITHOUT ALLOWANCES               |                    |

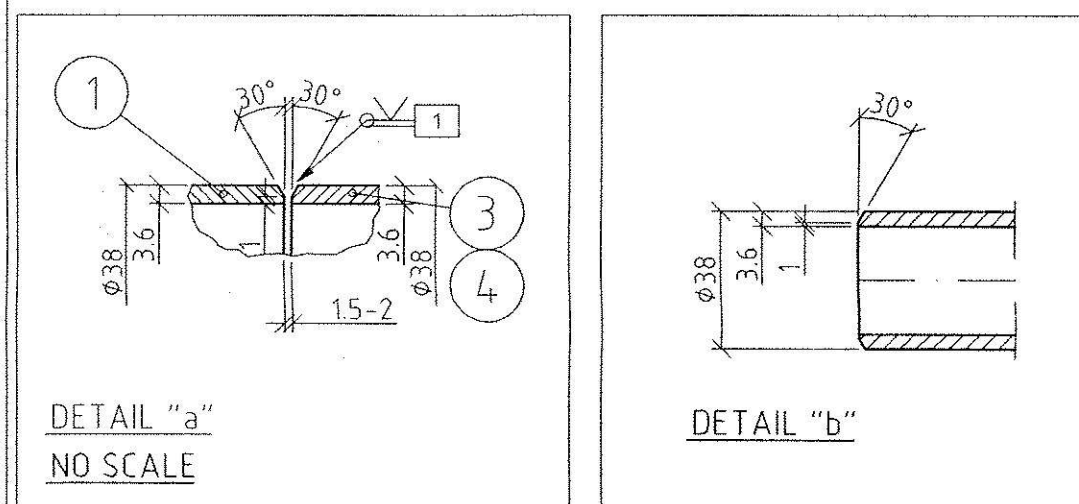
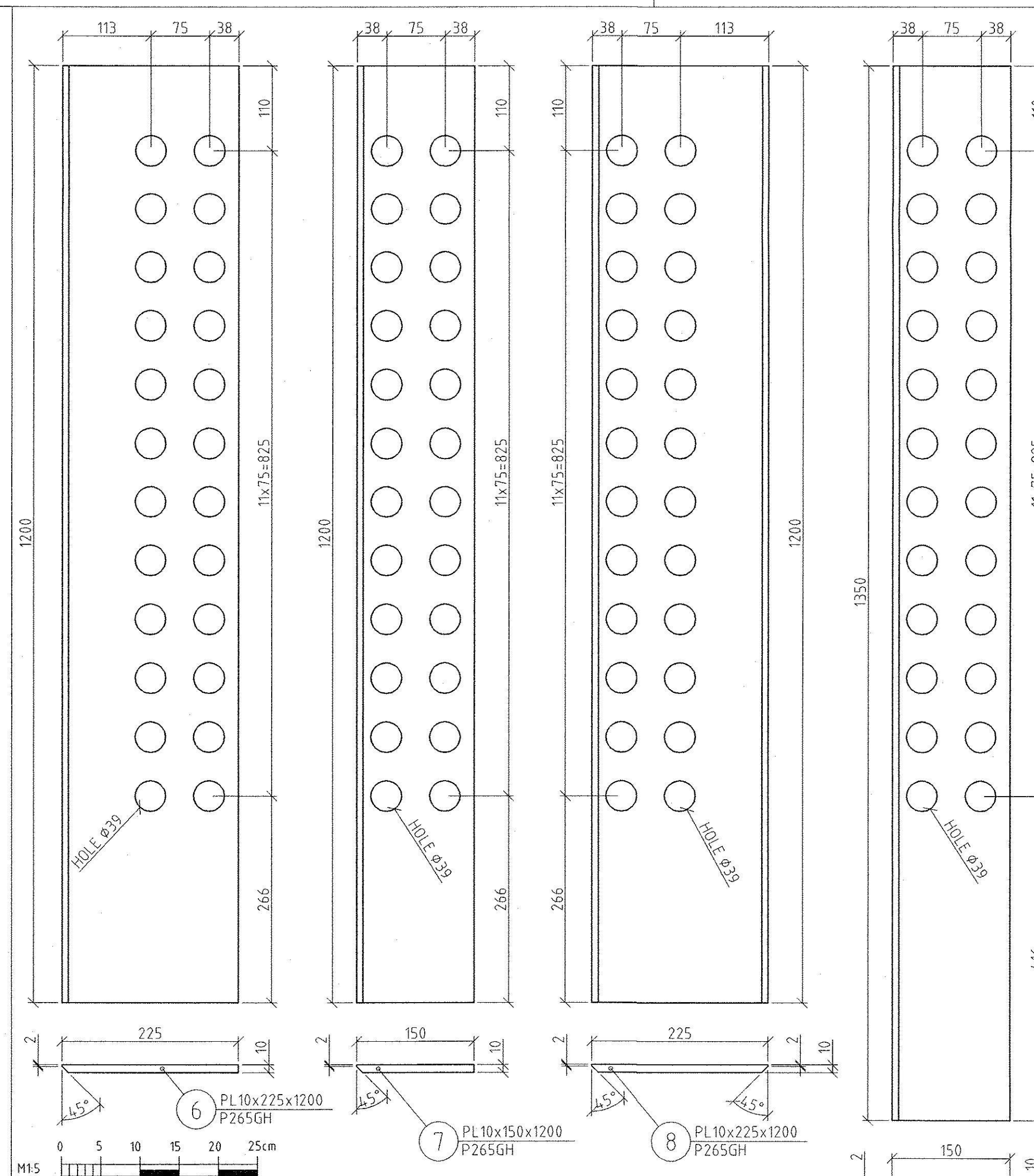
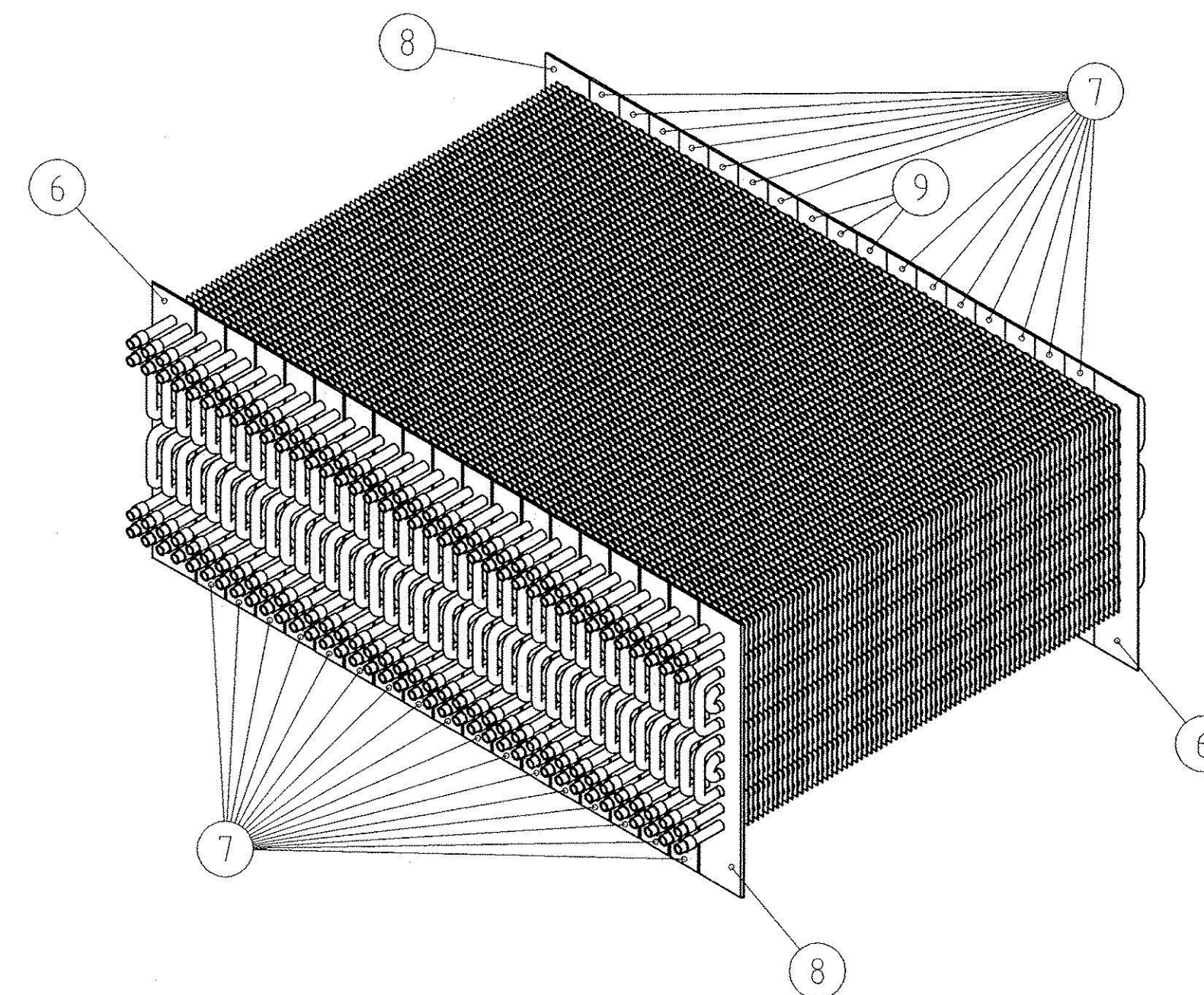
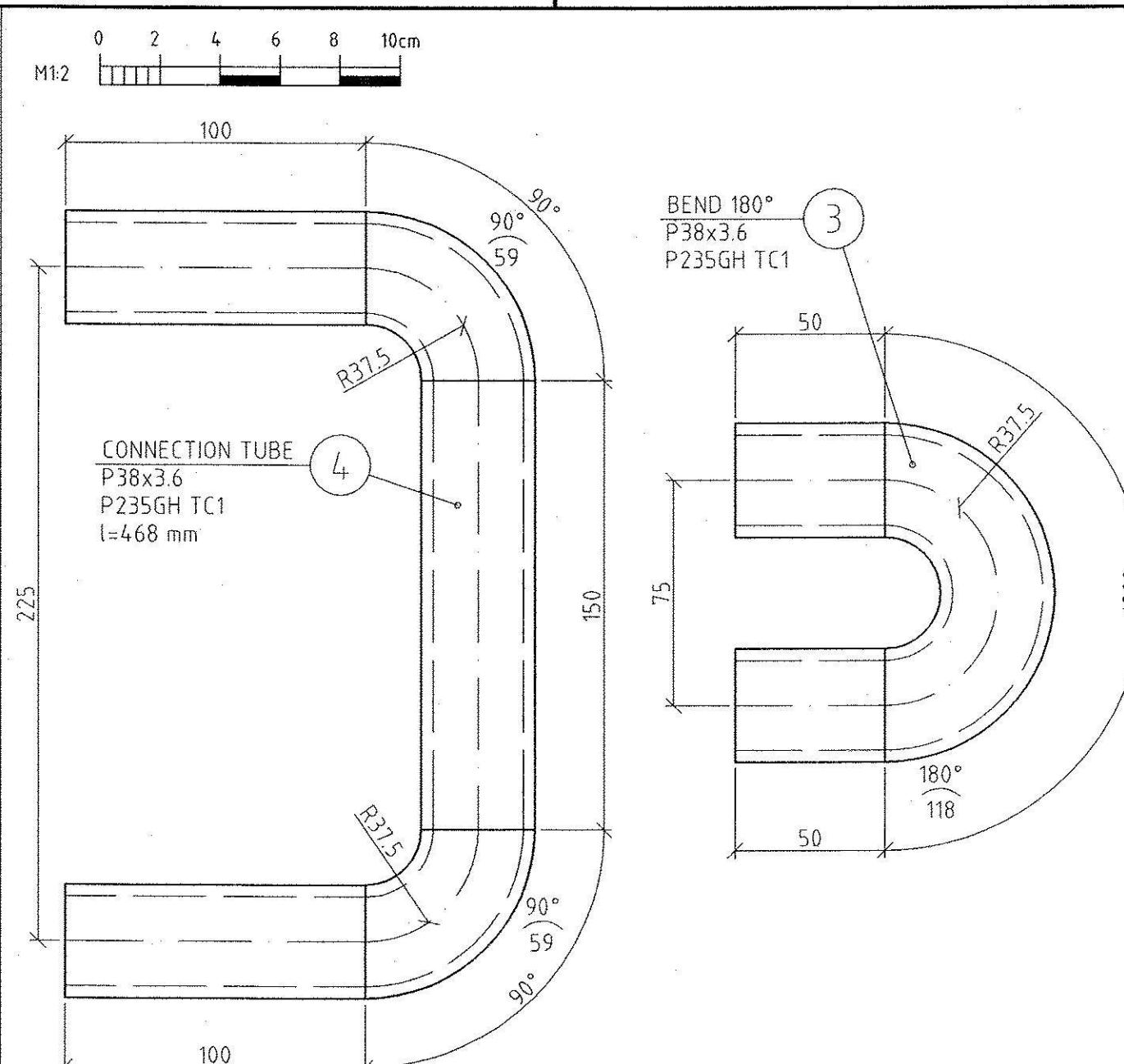
**<T = GASTIGHT WELD**

DETAIL "q"

DETAIL "b"

|      |         |           |           |
|------|---------|-----------|-----------|
| DATA | PARABAS | PARABOLIC | PARABOLIC |
|      |         |           |           |
|      |         |           |           |
|      |         |           |           |





REFERENCE DRAWINGS:  
13054.121.001; ECONOMIZER 1 ASSEMBLY

| CODE                             | PED / EN 12952      |
|----------------------------------|---------------------|
| SERIAL NUMBER                    | -                   |
| DESIGN PRESSURE                  | 1.6 MPa             |
| HYDROSTATIC TEST PRESSURE        | 2.4 MPa             |
| DESIGN TEMPERATURE <sup>1)</sup> | 204 °C              |
| CORROSION ALLOWANCE              | 1.0 mm              |
| VOLUME                           | 0,79 m <sup>3</sup> |
| HAZARD CATEGORY                  | IV                  |
| CONFORMITY ASSESSMENT MODULE     | G                   |

<sup>1)</sup> WITHOUT ALLOWANCES

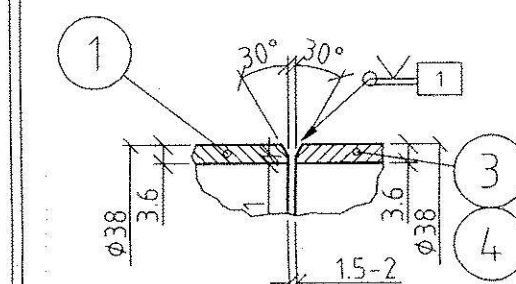
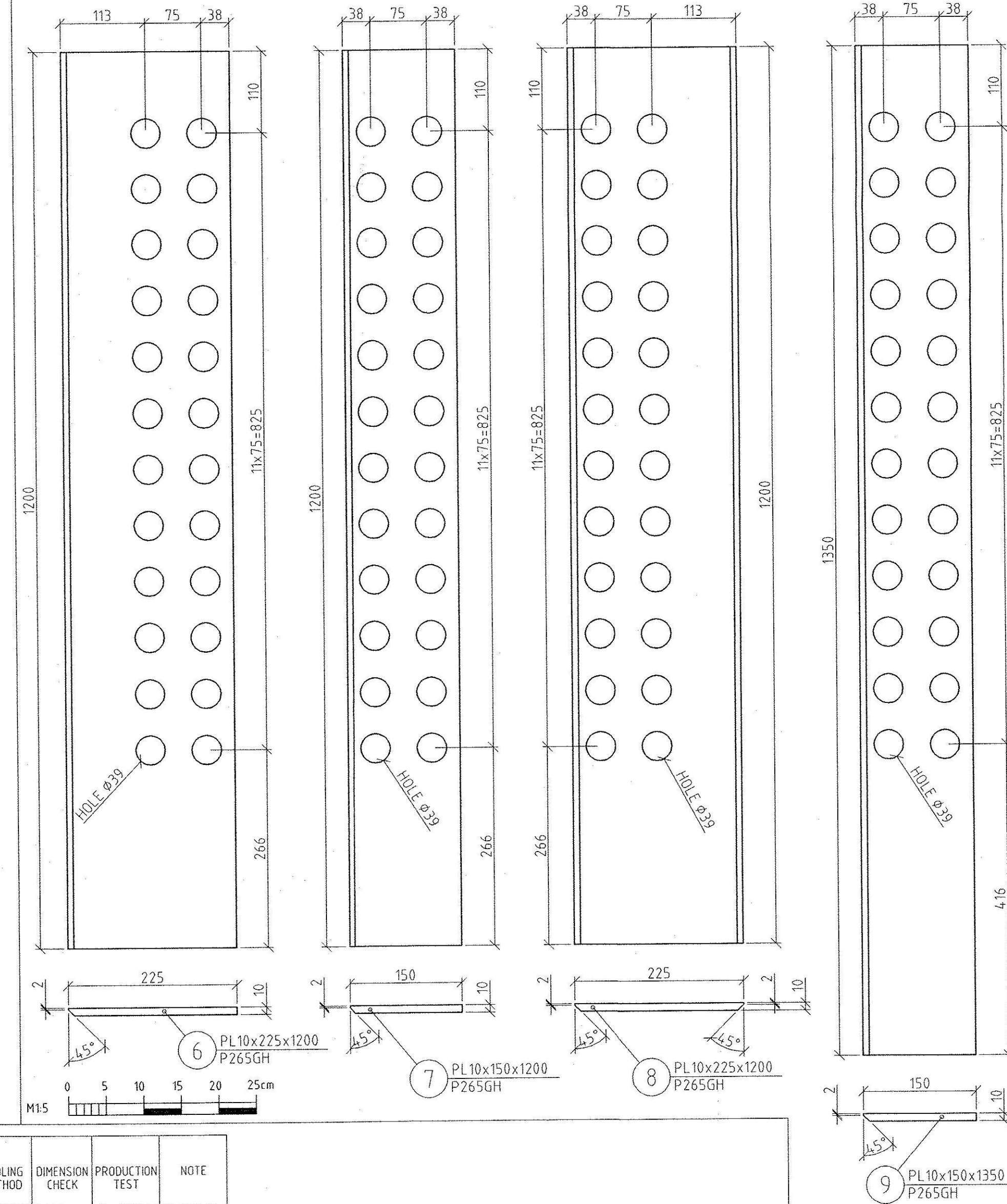
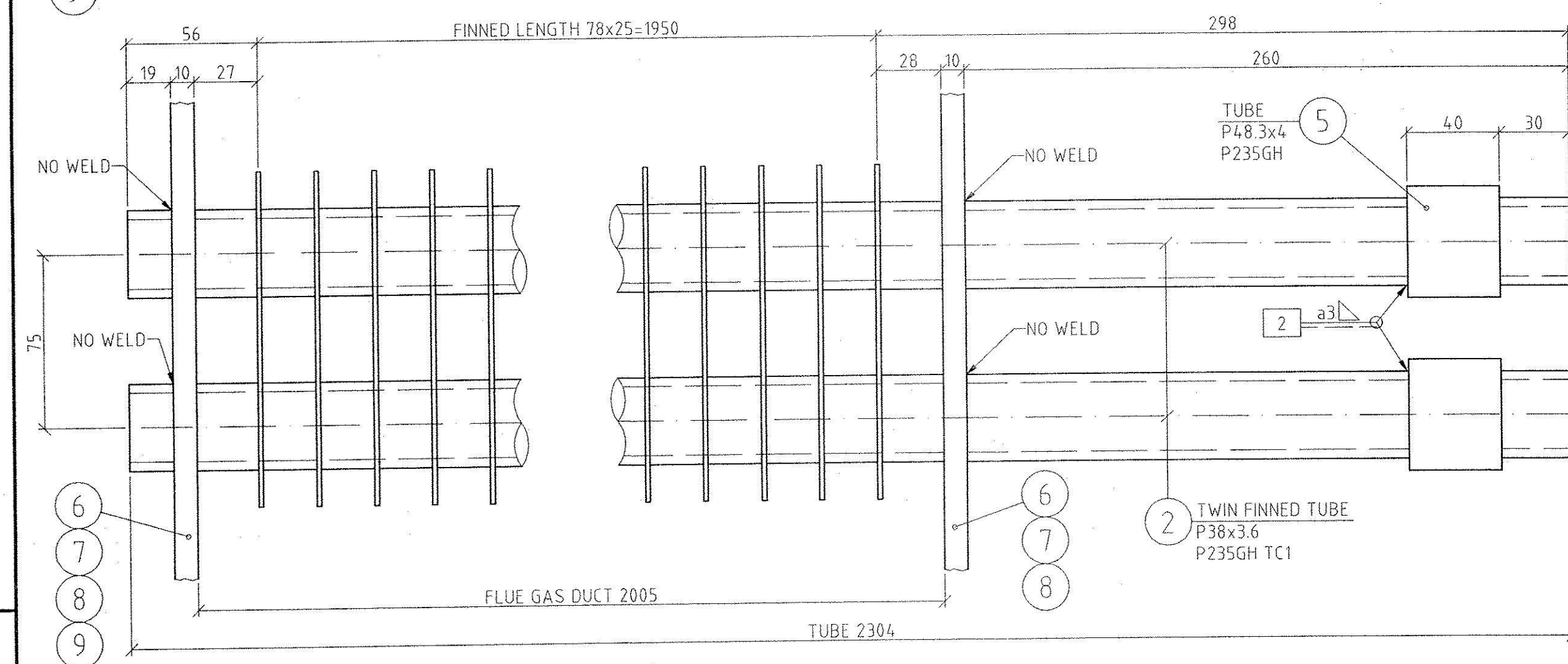
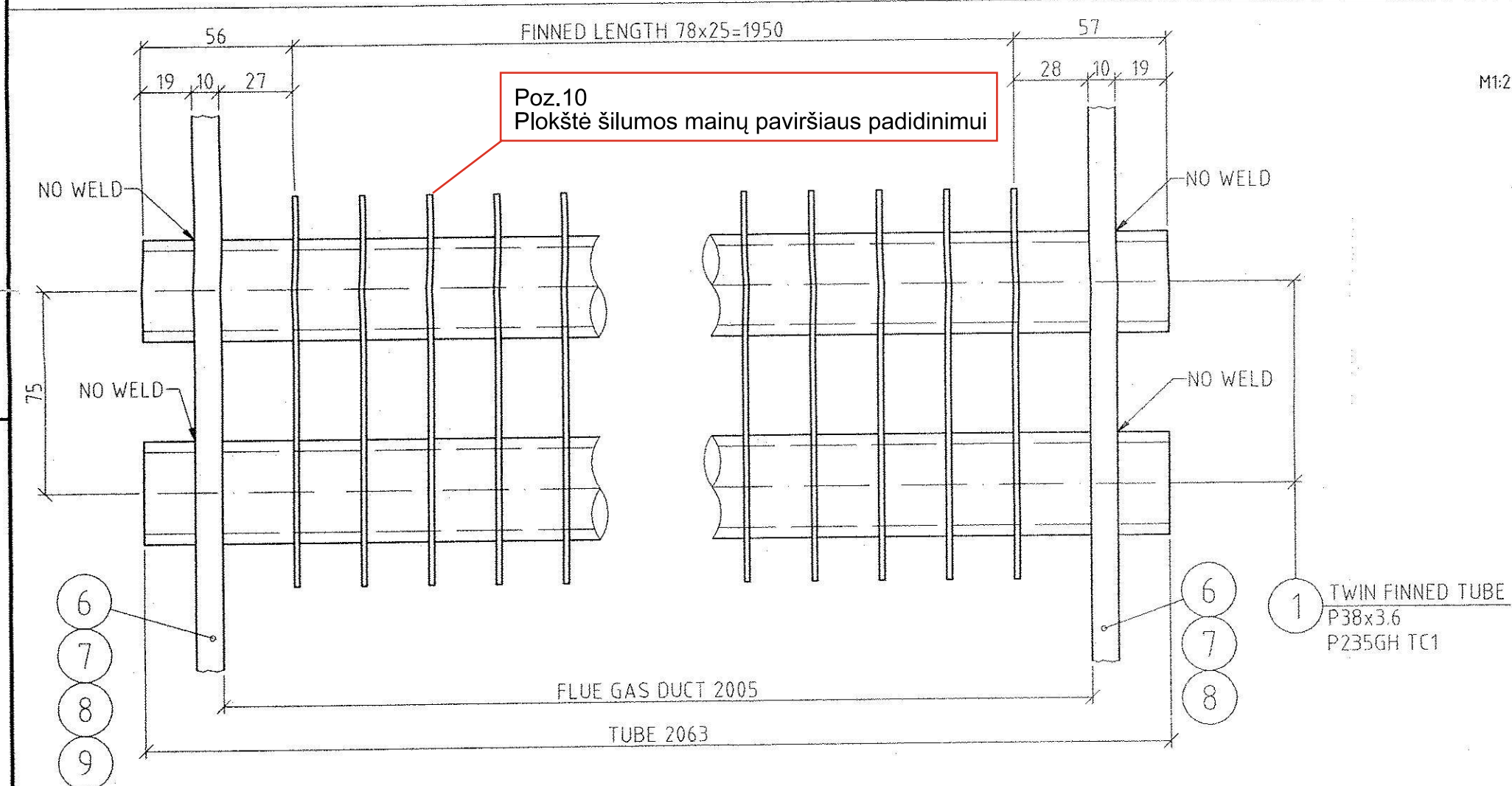
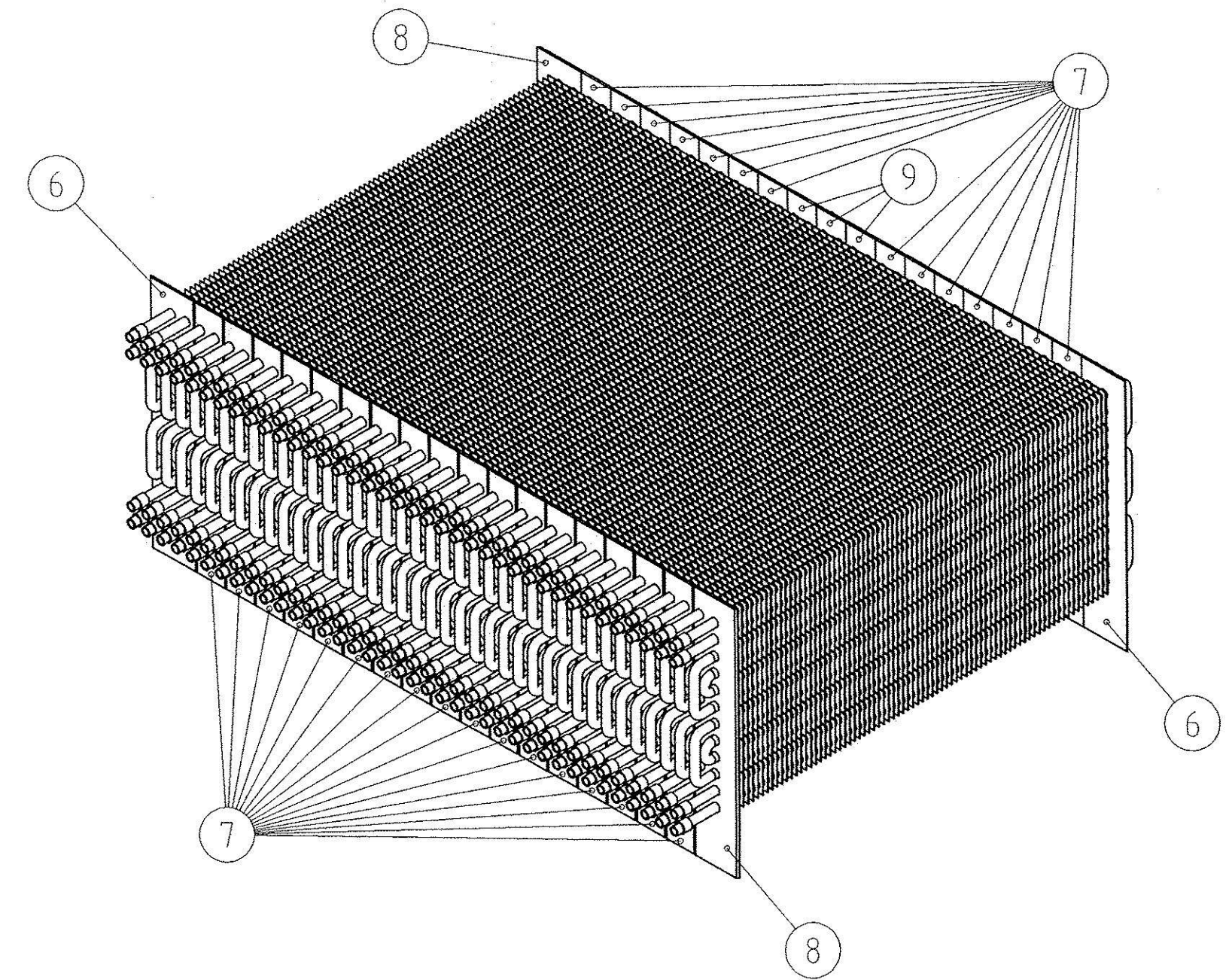
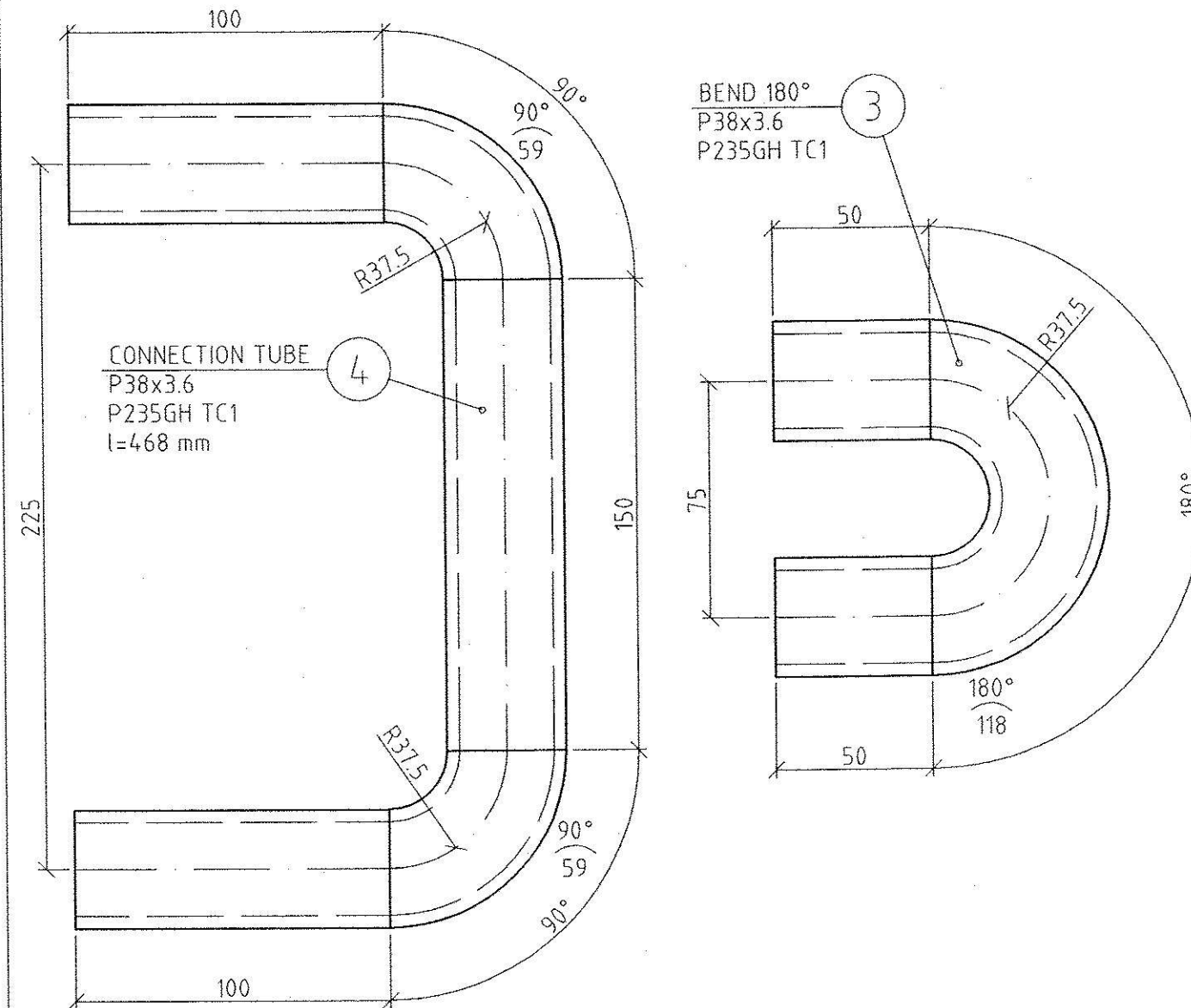
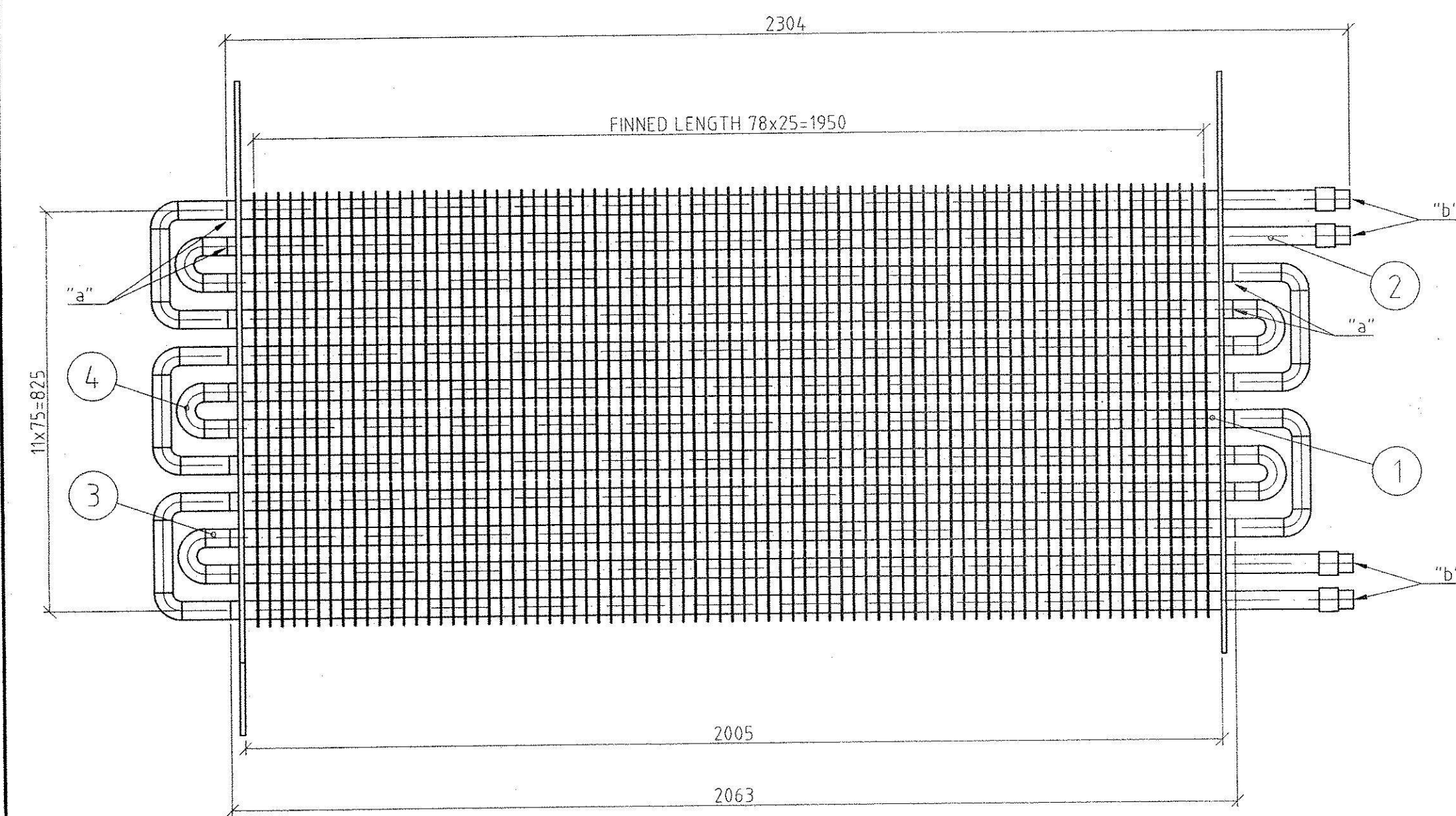
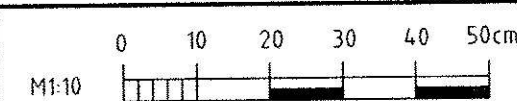
| PART NUMBER | MATERIAL | OUTSIDE DIAMETER | WALL THICKNESS | BENDING RADIUS | MINIMAL ALLOWED WALL THICKNESS IN |            | ALLOWED UNCIRCULARITY IN BENDS | r/d   | TFR<br>d <sup>2</sup><br>8 x F | HOT FORMING TEMP. | HEAT TREATMENT TEMPERATURE AFTER COLD OR HOT FORMING | HEATING RATE | HOLDING TIME | COOLING RATE | COOLING METHOD | DIMENSION CHECK | PRODUCTION TEST | NOTE |
|-------------|----------|------------------|----------------|----------------|-----------------------------------|------------|--------------------------------|-------|--------------------------------|-------------------|------------------------------------------------------|--------------|--------------|--------------|----------------|-----------------|-----------------|------|
|             |          |                  |                |                | OUTER BEND                        | INNER BEND |                                |       |                                |                   |                                                      |              |              |              |                |                 |                 |      |
| 34          | P235GH   | 38.0 mm          | 3.6 mm         | 37.5 mm        | 124 mm                            | 143 mm     | 12 %                           | 9.987 | 10.7                           | 880-940°C         | 1) 880-940 °C                                        | - °C/h       | - h/min      | - °C/h       | -              | 2 %             | Yes             | -    |
| 34          | P235GH   | 38.0 mm          | 3.6 mm         | 37.5 mm        | 124 mm                            | 143 mm     | 12 %                           | 9.987 | 10.7                           | 550-600 °C        | 220 °C/h                                             | 0.15 h/min   | 220 °C/h     | -            | 2 %            | Yes             | -               |      |

1) NOT NEEDED IF HOT FORMING HAS PROVED TO MADE AT REQUIRED TEMPERATURE RANGE

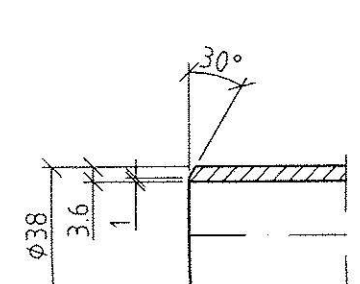








DETAIL "a"  
NO SCALE



DETAIL "b"

|                                      |
|--------------------------------------|
| REFERENCE DRAWINGS:                  |
| 13054.121.005; ECONOMIZER 2 ASSEMBLY |

| CODE                             | PED / EN 12952      |
|----------------------------------|---------------------|
| SERIAL NUMBER                    | -                   |
| DESIGN PRESSURE                  | 1.6 MPa             |
| HYDROSTATIC TEST PRESSURE        | 2.4 MPa             |
| DESIGN TEMPERATURE <sup>1)</sup> | 204 °C              |
| CORROSION ALLOWANCE              | 1.0 mm              |
| VOLUME                           | 0,79 m <sup>3</sup> |
| HAZARD CATEGORY                  | IV                  |
| CONFORMITY ASSESSMENT MODULE     | G                   |

<sup>1)</sup> WITHOUT ALLOWANCES

| PART NUMBER | MATERIAL | OUTSIDE DIAMETER | WALL THICKNESS | BENDING RADIUS | MINIMAL ALLOWED WALL THICKNESS IN |            | UNCORRUPTED IN BENDS | r/d   | TFR<br>EXT | HOT FORMING TEMP. | HEAT TREATMENT TEMPERATURE AFTER COLD OR HOT FORMING | HEATING RATE | HOLDING TIME | COOLING RATE | COOLING METHOD | DIMENSION CHECK | PRODUCTION TEST | NOTE |
|-------------|----------|------------------|----------------|----------------|-----------------------------------|------------|----------------------|-------|------------|-------------------|------------------------------------------------------|--------------|--------------|--------------|----------------|-----------------|-----------------|------|
|             |          |                  |                |                | OUTER BEND                        | INNER BEND |                      |       |            |                   |                                                      |              |              |              |                |                 |                 |      |
| 34          | P235GH   | 38.0 mm          | 3.6 mm         | 37.5 mm        | 1.24 mm                           | 1.43 mm    | 12 %                 | 0.987 | 10.7       | 880-940°C         | 1180-940 °C                                          | - °C/h       | - h:mm       | - °C/h       | -              | 2 %             | Yes             | -    |
| 34          | P235GH   | 38.0 mm          | 3.6 mm         | 37.5 mm        | 1.24 mm                           | 1.43 mm    | 12 %                 | 0.987 | 10.7       | - °C              | 550-600 °C                                           | 220 °C/h     | 0.15 h:mm    | 220 °C/h     | -              | 2 %             | YES             | -    |











