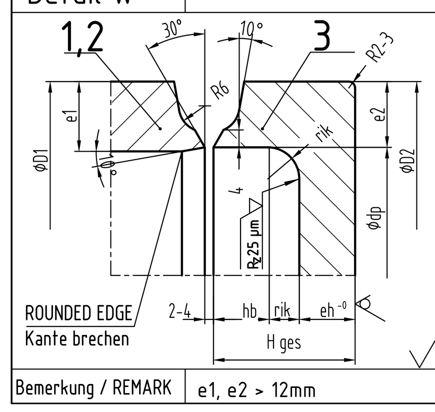
Berechnungsdruck Design pressure	83 bar	Auslegung nach Designed to	EN 12952; PED. Modul H1
Berechnungstemperatur Design temperature	459 °C	Entwurfsprüfung durch Design review by	TUEV SUED
		Bauüberwachung durch Inspection of manuf. by	SBENG
Wasserdruckprobe in der Werkstatt Hydrostatic test pressure in the workshop	310 bar	Überwachung der Abnahme durch Supervision of Inspection by	TUEV SUED CE0036
Wasserdruckprobe auf der Baustelle siehe Zeichnung Hydrostatic test pressure on site see drawing B1074.1.21.01.955.ID16.001-XX F A0		Herstellungs Nr. / MFR'S serial No. 8496	Baujahr / Year built 2018
		Abnutzungszuschlag Wear allowance	*mm
Herstellung und Prüfung siehe Produkt Spec. Manufacturing and Inspection acc. to Prod. Spec.		B1074.1.20.33.945.GD11.002-003 F A4	
Korrosionsschutz nach Corrosion Protection acc. to		B1074.1.20.50.300.GD29.002-XX F A4	
Beschichtungssystem Coating System			

Schweißnahtsymbole nach DIN EN ISO 2553-A
Weld Seam Symbols acc. to DIN EN ISO 2553-A
Symbol für Montagenaht =
Symbol for Site Weld =

Allgemein Toleranzen nach DIN ISO 2768 -mK
General tolerances according to DIN ISO 2768 -mK

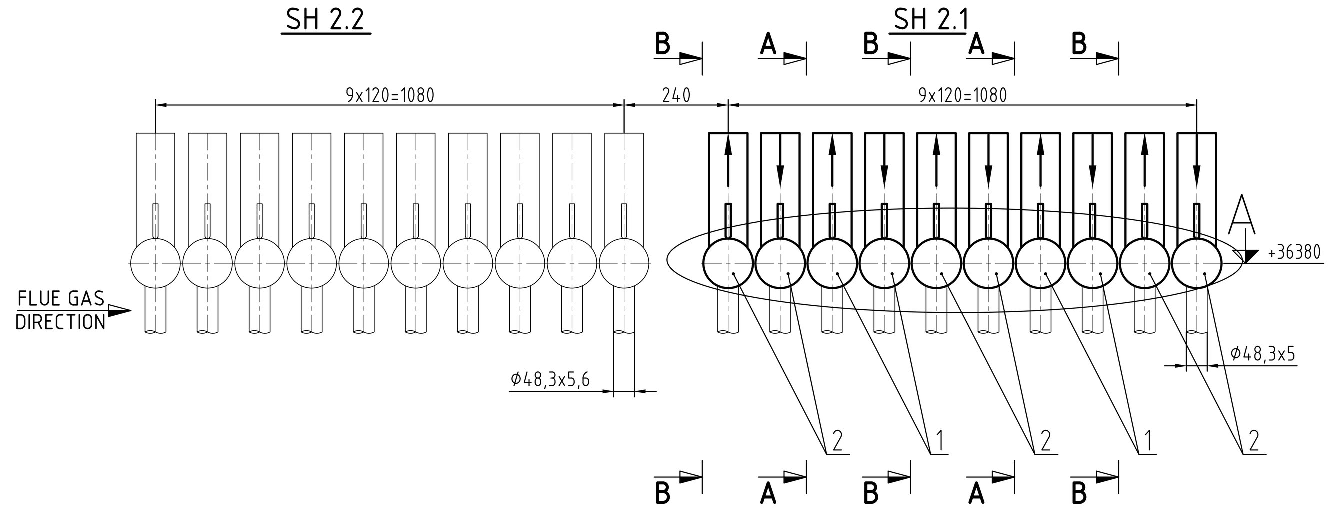
Detail W

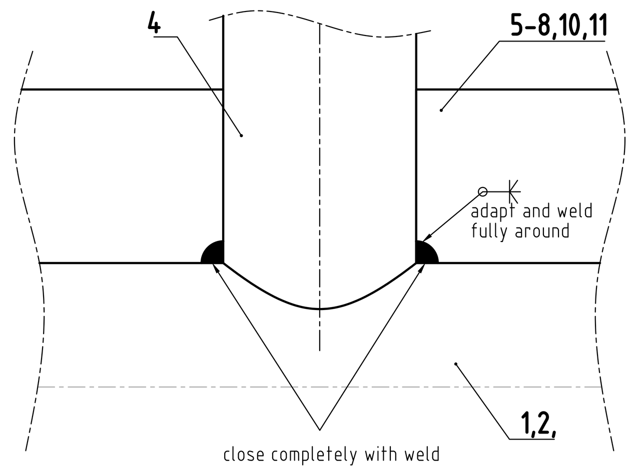


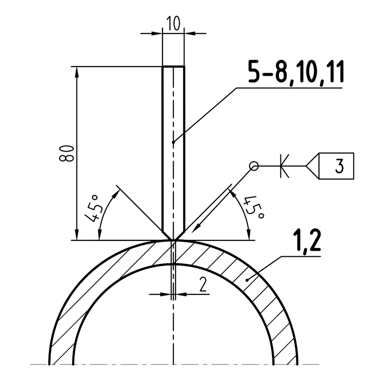
Schw.Pos. WELD POS.	1
Teil ITEM	1,2
Teil ITEM	3
Ø D1	114,3
e1	12,5
Ø D2	114,3
e2	11,65
eh	16
Ø dp	91
hb	16
rik	5
Hges	37,0

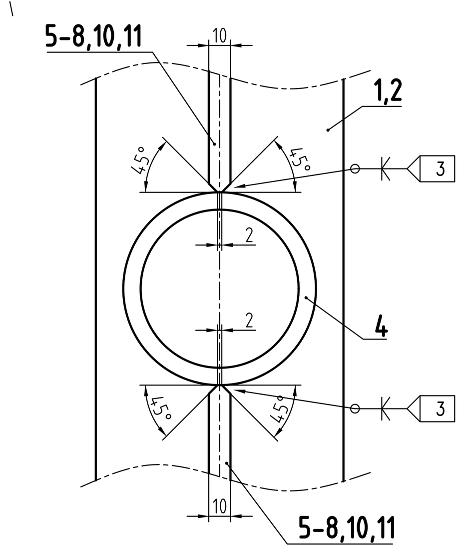
ROUNDED EDGE / Kante brechen — R_z 100µm (R_z 25 µm)

Bemerkung / REMARK: e1, e2 > 12mm

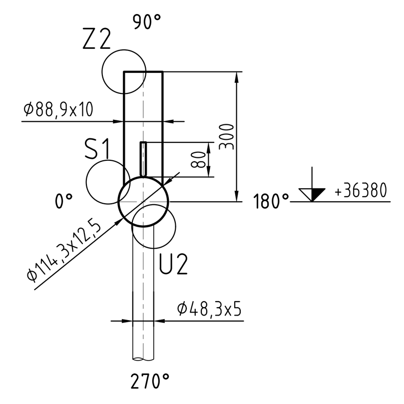


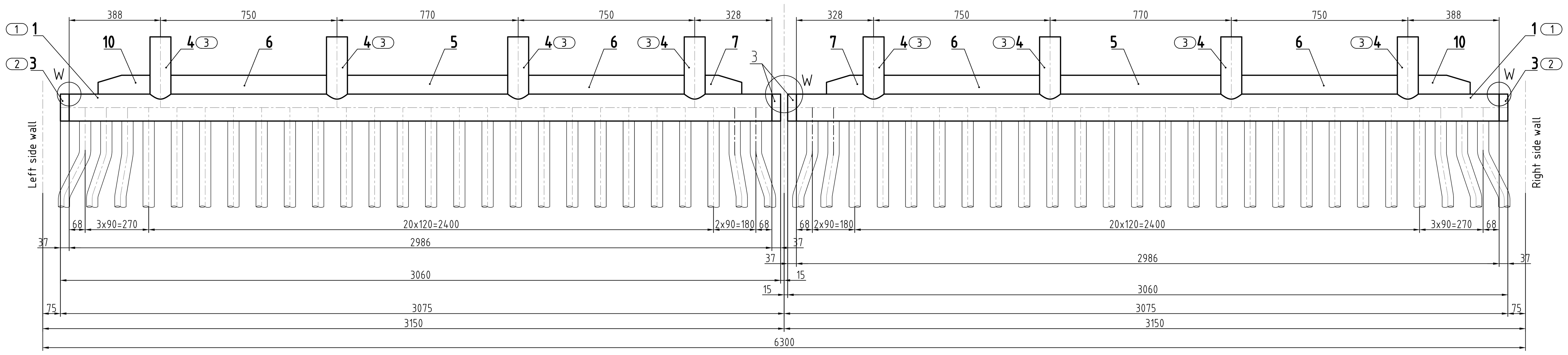




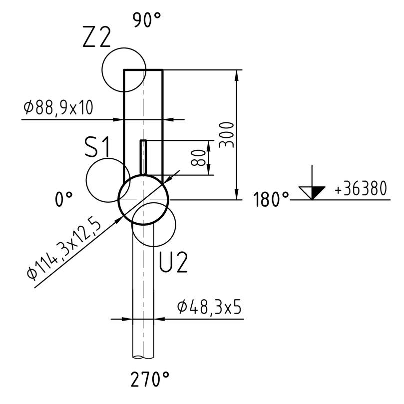


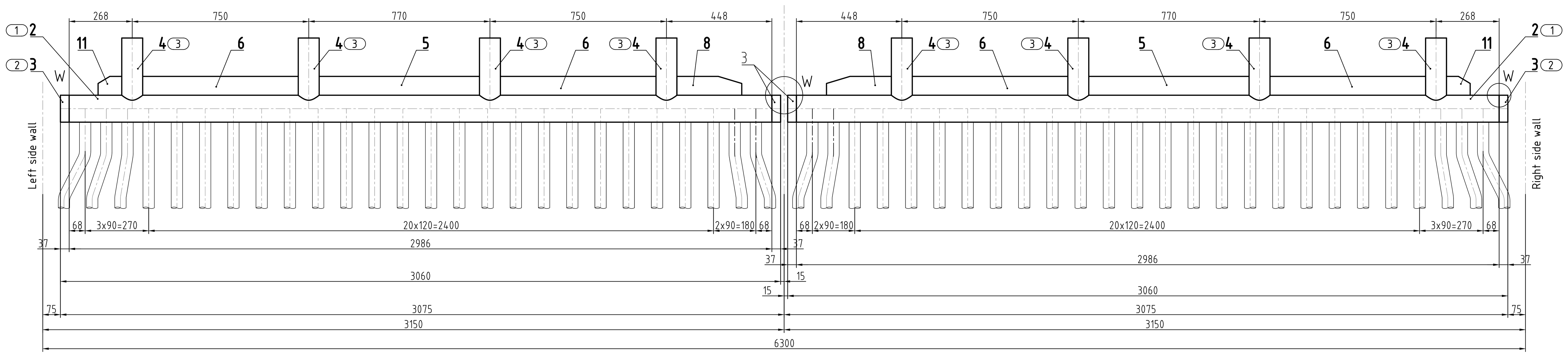
Section A-A Type A





Section B-B Type B





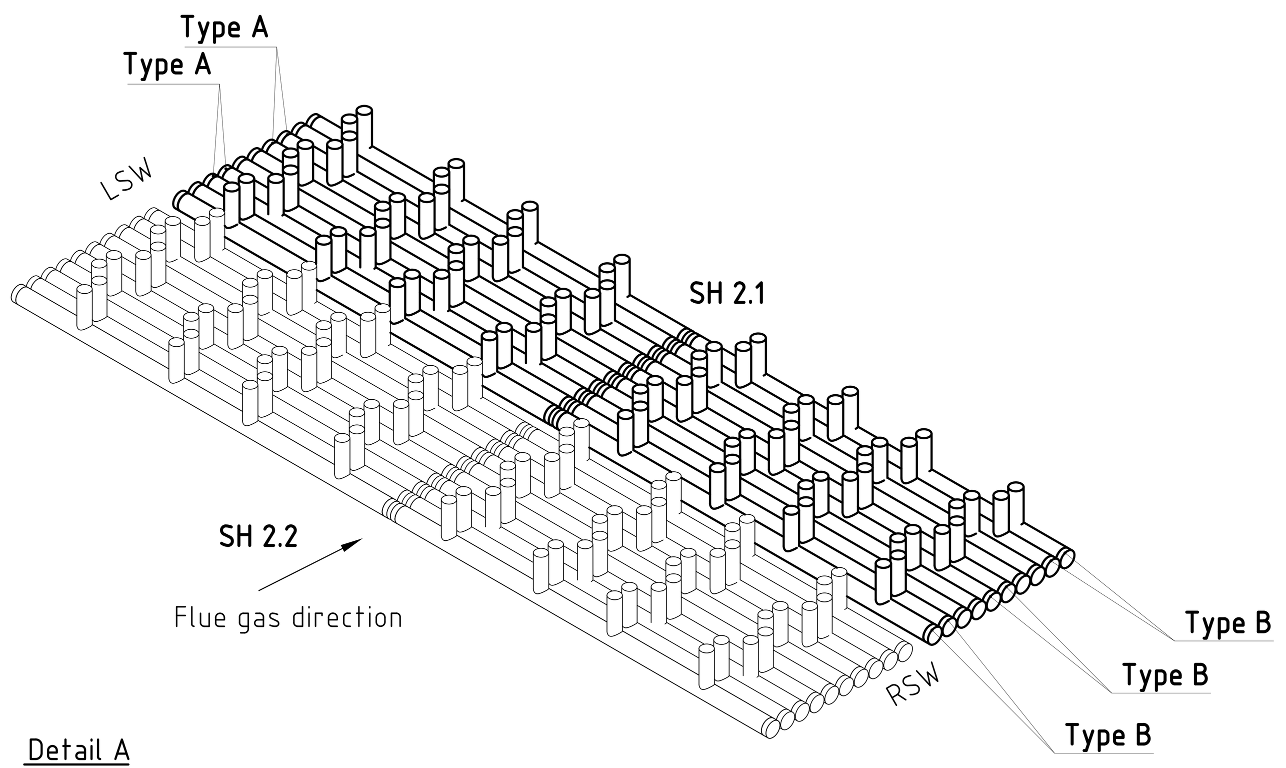
SH 2.1	TYPE	upper headers 20 pieces (2x10)	2 types
8X	A	301-308	301-304R 305-308L
12X	B	311-322	311-316R 317-322L

4	(3)	8525	40
		8575	40
Pos.Nr.		P.P.Item	Q.T.Y.

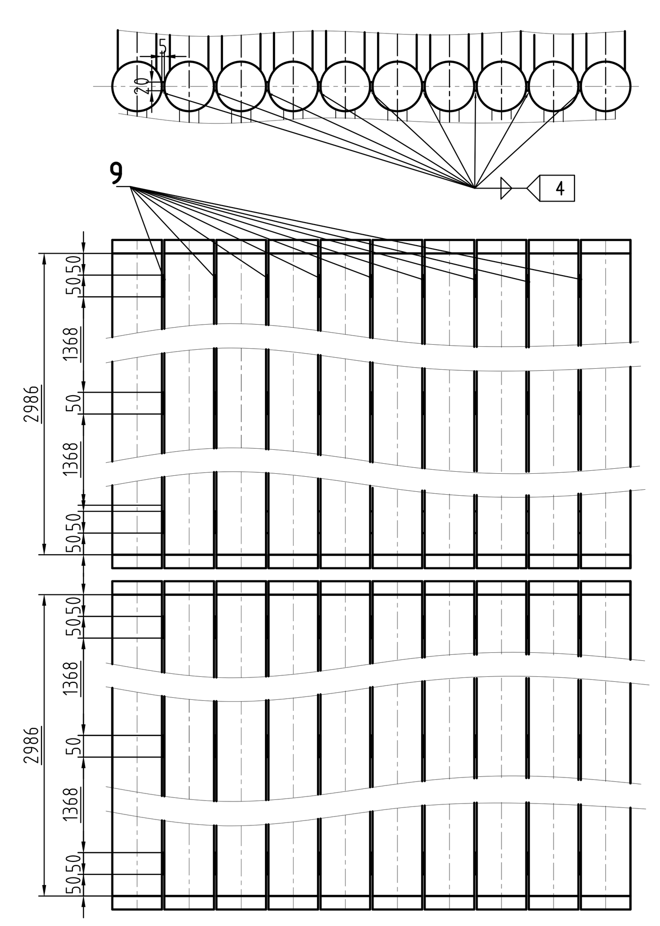
3	(2)	8530.1	20
		8570.1	20
Pos.Nr.		P.P.Item	Q.T.Y.

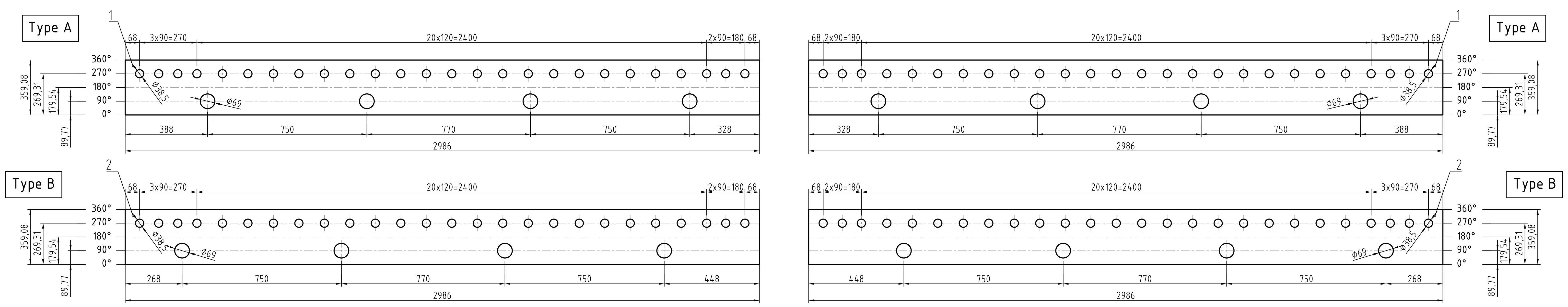
1,2	(1)	8530	10
		8570	10
Pos.Nr.		P.P.Item	Q.T.Y.

	Shematic pos.	8530,8570,8530.1. 8570.1	8525,8575
*	Allowable corrosion	2,0	0,0



Detail A
Scale 1:10



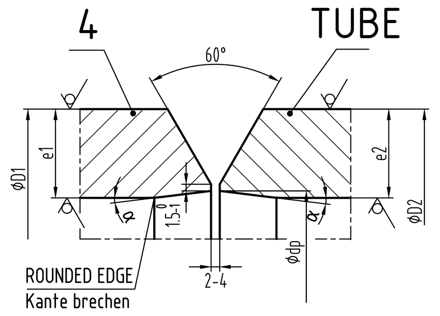


552-001	SH 2.2 AND SH 2.1 OVERVIEW
Zeich.Nr./Draw.No.	Benennung/Description
Zugehörige Zeichnungen/Reference Drawings	

Total: 2 684,2 kg

Stück Q.T.Y.	Benennung/DESCRIPTION	Teil ITEM	Werkstoff MATERIAL	Gewicht WEIGHT	Abn.Zeugn. INSP.CERT.	Bemerkung REMARKS	S.Pos. P.P.Item	S=Site F=Free part	Supply Manufacturer
12	Plate 80x10x100	11	16Mo3	7.7	3.1	EN 10028-2 EN 10029			
8	Plate 80x10x220	10	16Mo3	11.1	3.1	EN 10028-2 EN 10029			
54	Plate 20x5x50	9	16Mo3	2.1	3.1	EN 10028-2 EN 10029			
12	Plate 80x10x275	8	16Mo3	20.1	3.1	EN 10028-2 EN 10029			
8	Plate 80x10x155	7	16Mo3	7.7	3.1	EN 10028-2 EN 10029			
40	Plate 80x10x661	6	16Mo3	166.0	3.1	EN 10028-2 EN 10029			
20	Plate 80x10x681	5	16Mo3	85.5	3.1	EN 10028-2 EN 10029			
80	Tube ø88,9x10x251	4	16Mo3	390.7	3.1	EN 10216-2	8525 8575		
40	Bottom Ø114,3x37	3	16Mo3	119.2	3.1	EN 12952-3 EN 10222-2	8530.1 8570.1		
12	Tube ø114,3x12,5x2986	2	16Mo3	1124.5	3.1	EN 10216-2	8530 8570		
8	Tube ø114,3x12,5x2986	1	16Mo3	749.6	3.1	EN 10216-2	8530 8570		

Detail Z2

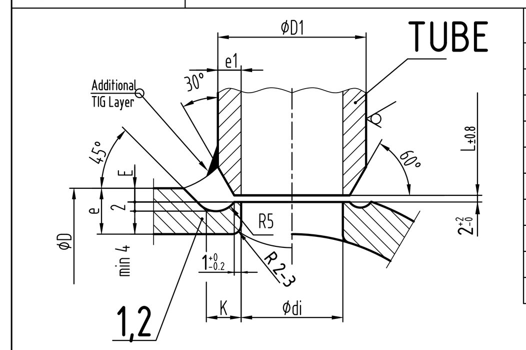


Schw.Pos. WELD POS.	-
Teil ITEM	4
Teil ITEM	TUBE
Ø D1	88,9
e1	10
Ø D2	88,9
e2	5,6
Ø dp	78
α	10°

R_Z63 µm

Bemerkung / REMARK: α = 10° f.Rohre/FOR TUBES, α =12° f. Schmiedeteile /FOR FORGINGS; 8 ≤ e1,2≤12mm & D1,2 ≥ 76,1

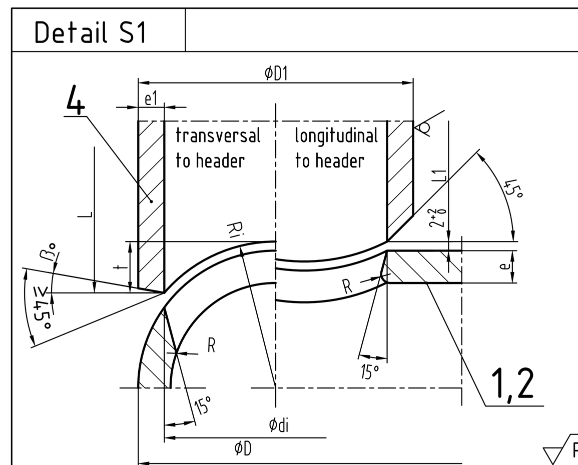
Detail U2



Schw.Pos. WELD POS.	-
Teil ITEM	1,2
Teil ITEM	TUBE
Ø D	114,3
e	12,5
Ø D1	48,3
e1	5
Ødi	38,5
L	-
E	4
K	8

R_Z63 µm

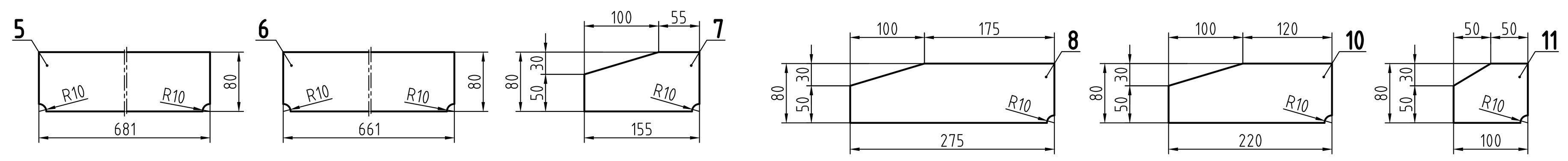
Detail S1



Schw.Pos. WELD POS.	2
Teil ITEM	1,2
Teil ITEM	4
Ø D	114,3
e	12,5
Ø D1	88,9
e1	10
Ødi	69
t	11
ß	10°
L	251
L1	240
R	2-3
Ri	59

R_Z63 µm

Bemerkung / REMARK: di > 0,8 x (d-2e) ; ß>7°
L≤400 n. dem Schweißen innen glatt schleifen /GRINF SMOOTH AFTER WELDING
Maß "L" ohne Wurzelspalt / Figure "L" without rootgap



Naht Nr. Joint No.	Teil Nr. Part No.	Werkstoff Material	Teil Nr. Part No.	Werkstoff Material	Naht-Symbol Weld-Symbol	Abmessung Dimension	Betr. Shop	Mont Site	111=LBH / MMAW	141=WIG / TIG	121=UP / SAW	135=MSG / MAG	136=MSG-F / FCAW	Zusatzwerkstoff Filler metal	Vorwärmetemperatur °C	Temperatur °C	Haltezeit min.	Bemerk./ Remark	PT	MT	RT	UT	HT	LT	VT	Bemerk./ Remark
4	1,2	16Mo3	9	16Mo3		a=3	108			X				WMoSi+I1					10							
3	1,2,4	16Mo3	5-8,10,11	16Mo3	K	t=10	100			X	or		X	WMoSi+I1/ TMolP						100						
2	1,2	16Mo3	4	16Mo3	V	Ø88,9x10	80		F	W				WMoSi+I1/ EMoB42H5						10						
1	1,2	16Mo3	3	16Mo3		Ø114,3X12,5	40			W	F			WMoSi+I1/S2Mo+ SAAB1/SAFB1						100	100					

Anzahl / Qty — Verfahren/Procedure — Wärmebehandlung / Heat treatment

	Erstellt von: Datum / Unterschrift Prepared by: Date / Signature	Geprüft von: Datum / Unterschrift Checked by: Date / Signature	Genehmigt von: Datum / Unterschrift Approved by: Date / Signature
Schweißen / Welding	08.01.2018 Harms	08.01.2018 Christmann	08.01.2018 Bremicker
Prüfen / Testing	08.01.2018 Harms	08.01.2018 Christmann	08.01.2018 Bremicker

Legende Verfahren : / Legend procedures :
X = alle Lagen — all passes
W = Wurzellage — root pass
F = Füllvolumen — filler passes

PT = Eindringprüfung in % — Penetrant testing
MT = Magnetpulverprüfung in % — Magnetic particle testing
RT = Durchstrahlungsprüfung in % — Radiographic testing
UT = Ultraschallprüfung in % — Ultrasonic testing
HT = Härteprüfung in % — Hardness testing
LT = Dichtheitsprüfung in % — Leak testing
VT = Sicht-u. Sauberkeitsprüfung in % — Visual & Cleanness Testing

STA.	REV.	DATE	PREP.	CHCK.	APPR.	COMMENT
F	01	15.02.2018	Planum	Lietz	Schröder	Released for fabrication

EMPLOYER Contract Number: VKJ_S_2016-92
EMPLOYER Project Code: VKJ01
Lietuvos energija — VILNIAUS KOGENERACINĖ JĖGAINĖ

EMPLOYER DOCUMENT DESIGNATION			LANGUAGE	REV NO	STATUS
PROJECT CODE VKJ01	LOT ID 1	DOC COUNTER 110275	EN	01	F

CODE WORD: CHP - Vilnius
FILENAME: 1074-552-004-F01.dwg

	DATE	NAME
PREP.	21.03.2017	R.Holubec
CHECKED	12.12.2017	Lietz
APPROV.	12.02.2018	Schröder

budimex KDS — Steinmüller Babcock Environment

SCALE: 1:10
TITLE: SUPERHEATER 2.1 TOP DISTRIBUTOR & HEADER DETAIL DRAWING Linie 1

DRAWING NO.: B1074 . 1 . 21 . 01 . 552 . IG04 . 005 – 01 — STAT. F — FORMAT A0

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