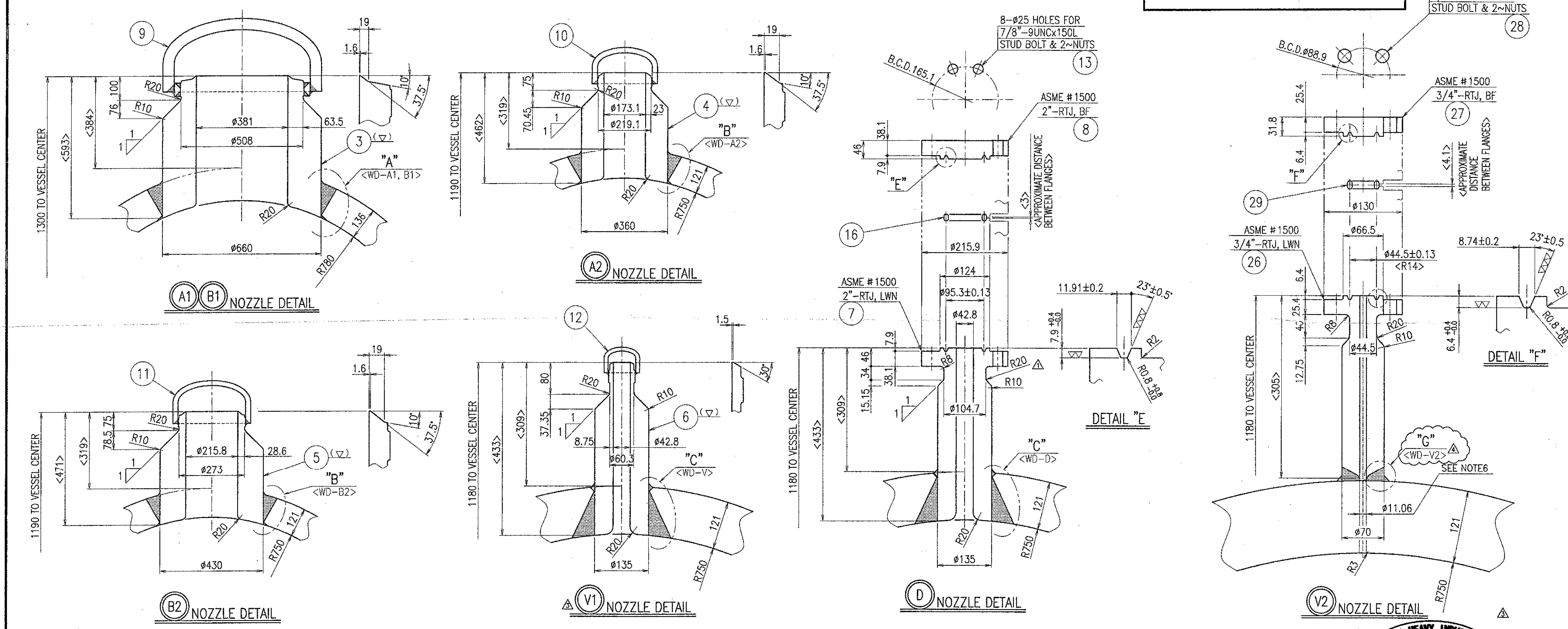
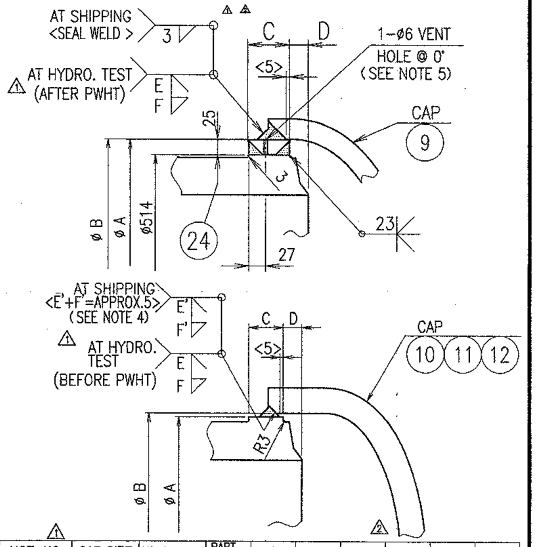
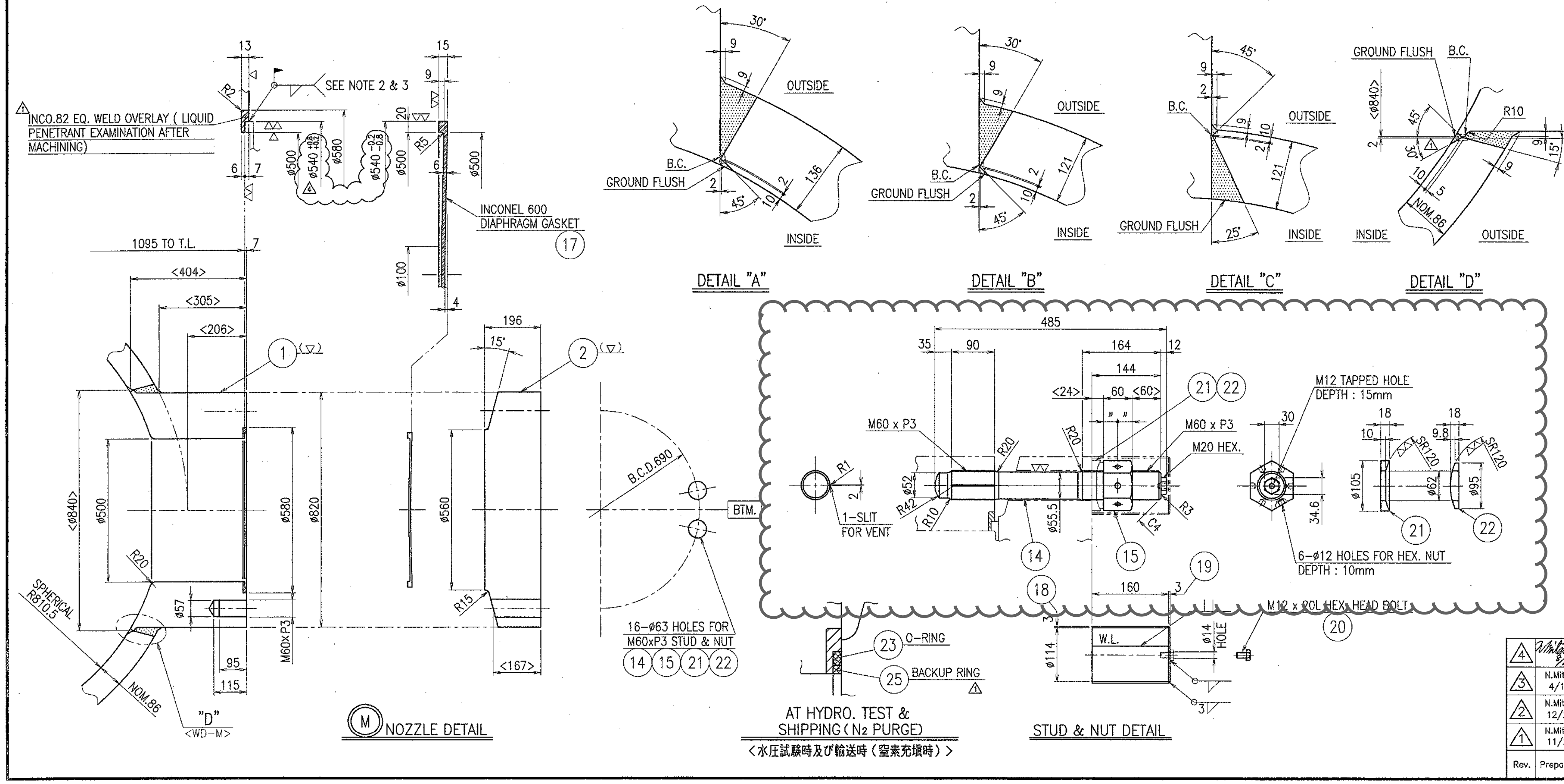
FOR CONSTRUCTION

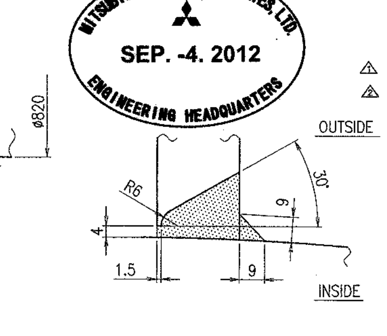




NOZ. NO.	CAP SIZE	CAP THICKNESS	PART NO.	A	B	C	D	E	F
A1 B1	NPS 26	46.5	9	564	<567>	55	30	35	12
A2	NPS 10	22.45	10	225.1	<228.1>	35	25	16	9
B2	NPS 12	20.9	11	279	<282>	35	25	16	9
△3 V1	NPS 3	9.8	12	66.3	<69.3>	30	20	–	12

HYDRO. TEST COVER DETAIL





MITSUBISHI HEAVY INDUSTRIES, LTD. ENGINEERING HEADQUARTERS SEP. -4. 2012

NOTES

1. < >DIMENSIONS ARE REFERENCE. (< >内寸法は参考寸法を示す。)
2. <FIELD NOTE>
THE SEAL WELDING FOR DIAPHRAGM GASKET SHALL BE CARRIED OUT AFTER FIXING THE GASKET BY USING INSTALLATION JIG (REFER TO DWG. NO. : 871A-22-03-10).
THE INCONEL SEAL WELDING SHALL BE CHECKED BY LIQUID PENETRANT EXAMINATION AFTER AIR LEAK TEST (5 kg/cm²).
(<注記（現地用）> シール溶接はガスケット固定用ジグ（図番 871A-22-03-10 参照）を用いてガスケット固定の後、溶接を行うこと。
また、シール溶接部は気密試験後（5 kg/cm²）、PT試験実施のこと。)
3. WELDING ROD FOR THE SITE SEAL WELD SHALL BE SUPPLIED BY Hitz.
(現地シール溶接用溶接棒を日立造船より支給のこと。)
4. AFTER HYDROSTATIC TEST, THE WELD BETWEEN CAP AND NOZZLE SHALL BE REMOVED AT APPROX. 5mm.
(水圧試験後にキャップ/ノズル間の溶接部は約5mmまで除去のこと。)
5. WHEN THE CAP REMOVED AFTER HYDRO. TEST, VENT HOLE SHALL BE EXPOSED BY GRINDER.
((注意) 耐圧試験後、耐圧蓋取外しの際ベントホールを露出させること。)
6. △3 HOLE OF V2 NOZZLE SHALL BE MADE AFTER WELDED V2 NOZZLE.
(V2ノズル取付後に穴加工を行うこと。)

1A+1B : WORKING T.W.= 4,751.4 kg

No. OF MFRS B	No. OF MFRS A	PART No.	NAME OF PART	MATERIAL		UNIT WEIGHT (kg)	REMARK
1	1	29	RING JOINT GASKET	SOFT IRON / HB ≤ 120	R14 (OCTAGONAL)	–	完 PYP6826
SETS 2	SETS 4	28	STUD BOLT & 2-NUTS	B : SA193 Gr.B7 N : SA194 Gr.2H	3/4"-10UNC x125L	0.5 / 2	完 PYP6825
	1	27	BLIND FLANGE	SA105	ASME #1500 3/4"-RTJ, BF	2.5	完 PYP6821
	1	26	FORGED NOZZLE	SA105	ASME #1500 3/4"-RTJ, LWN	18.5	完 PYP6821
	1	25	BACKUP RING	TEFLON	---	△1 –	完 PYP6208
	2	24	HOOP	SA516 Gr.60	t 25	16	保 #141 PYP4480 CP No.9692
	1	23	O-RING	RUBBER	---	–	完 PYP6208
2	16	22	SPHERICAL WASHER	SA194 Gr.4 EQ.	O.D.95	0.5 / 8	完 PYP6201
2	16	21	SPHERICAL WASHER	SA194 Gr.4 EQ.	O.D.105	0.7 / 11.2	完 PYP6201
	16	20	HEX. HEAD BOLT	C.STEEL	M12x20L	0.04 / 0.6	H 手配
	16	19	THREAD PROTECTOR	C.STEEL	t 3	0.2 / 3.2	H 手配
	16	18	THREAD PROTECTOR	C.STEEL	t 3	1.7 / 27.2	H 手配
1	1	17	DIAPHRAGM GASKET	INCONEL 600	t 15	13	完 PYP6190
1	1	16	RING JOINT GASKET	SOFT IRON / HB ≤ 120	R24 (OCTAGONAL)	0.4	完 PYP6202
2	16	15	NUT	SA194 Gr.7	M60xP3	2 / 32	完 PYP6201
2	16	14	STUD	SA193 Gr.B16	M60xP3 x485L	12 / 192	完 PYP6201
SETS 2	SETS 8	13	STUD BOLT & 2-NUTS	B : SA193 Gr.B7 N : SA194 Gr.2H	7/8"-9UNC x150L	0.6 / 4.8	完 PYP6201
	1	12	HYDRO. TEST COVER	SA234 Gr.WPB	NPS 3	2	半 PYP6206
	1	11	HYDRO. TEST COVER	↕	NPS 12	40	半 PYP6206
	1	10	HYDRO. TEST COVER	↕	NPS 10	30	半 PYP6206
	2	9	HYDRO. TEST COVER	SA234 Gr.WPB	△1 NPS 26	231 / 462	半 PYP6206
	1	8	BLIND FLANGE	SA105	ASME #1500 2"-RTJ, BF	10	完 PYP6197
	1	7	FORGED NOZZLE	↕	ASME #1500 2"-RTJ, LWN	46	↕
	1	6	STUB END (2")	↕	ø135	33	↕
	1	5	STUB END (10")	↕	ø430	291	↕
	1	4	STUB END (8")	SA105	ø360	209	完 PYP6197
	2	3	STUB END (20")	SA182 Gr.F22 CL.3	ø660	802 / 1604	完 PYP6195
	1	2	BLIND FLANGE	SA182 Gr.F22 CL.3	t 196	670	完 PYP6195
	1	1	FORGED NOZZLE	SA182 Gr.F22 CL.3	ø820	1023	半 PYP6195

ORDER NO.	565739
PROJECT TEAM	TAF
APPROVED	[signature]
SECTION	EQUIPMENT ENG'G Group
APPROVED	[signatures] H. Okuda
DATE	Aug-31, 2012
DWG. TITLE	1-E-1502 SG BFW PREHEATER NOZZLE DEATIL
DWG. No.	6417 V322-150200-03
Rev.	4

DISTRIBUTION: CUSTOMER E, CCI, PM, DPM, EM, SEM, QA/QC 1, PROCURE, SUBCONT, COST, SCHEDULE, PROCESS, PIPING 2, INST, SYSTEM, EQUIP 1, MACHINE, ELECT, CIVIL, CONST, FURNACE, MHI-P(CONST), MHI-P(B&D), MHI EC-(EQUIP) 1, VENDOR 1

MITSUBISHI HEAVY INDUSTRIES, LTD.

Rev.	Prepared by	Reviewed by	Approved by	Reviewed by Q.A.E.	Description
△4	N.Mitamura 8/4 '12	8/4 '12	8/4 '12		ADDED WELD JOINT NO..
△3	N.Mitamura 4/16 '12	R.Nakashima 4/16 '12	R.Nakashima 4/16 '12		ADDED V2 NOZZLE.
△2	N.Mitamura 12/23 '11	K.Okada 12/23 '11	R.Nakashima 12/23 '11		DELETED NOTE 6 & etc...
△1	N.Mitamura 11/21 '11	R.Shiotsu 11/21 '11	R.Nakashima 11/21 '11		FOLLOWED CUSTOMER'S COMMENT & etc...

W16P00198

MITSUBISHI HEAVY INDUSTRIES, LTD. MCEC AMMONI, REPUBLIC OF TATARSTAN

P.O. NO. : 563410-V0035
PROJECT NAME : TAF PROJECT
ITEM NO. & NAME: 1-E-1502 SG BFW PREHEATER

NOZZLE DETAIL

SCALE 1/10, 1/6, 1/5, 1/2

Hitz
HITACHI ZOSEN CORPORATION
ARIAKE WORKS

Drawn By	Y. Tabata	6/17 '11
Prepared By	N. Mitamura	7/13 '11
Reviewed By	R.Shiotsu	7/13 '11
Approved By	R. Nakashima	7/13 '11
Reviewed By QAE	—	

DATE 6/17 '11 RELATED SECTION —
MANUF. No. W16P00198-01
SHEET No. —
CODE No. —
DRAWING No. 871A-22-03-01 △4

配布先	A	F
提出	3C+1R	3C+1R
アリシ	1	1
アリシ1(CP)	1	1
アリヒ	1	1
アリヒ(NDE)	2	2
アリコ(1)	1	1
アリヨ	2	2
キセキ	1	1
キセカ(1)	1	1
キセカ(1C)	1	1
キセカ(1H)	1	1
キセセ(K1)	3	3
キセセ(K2)	1	1
キセセ(G1)	3	5
キセセ(G3)	1	1
近鉄	1	1
計	21+3C+1R	23+3C+1R

M A1 A2 B1 B2 V1 V2 D

13