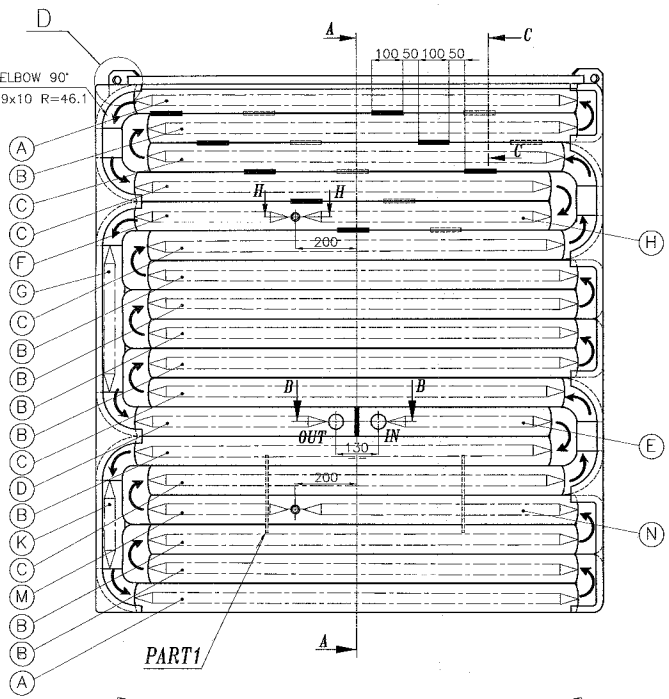
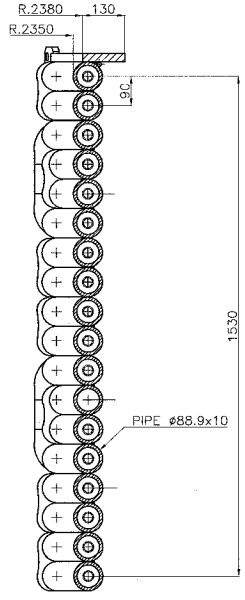
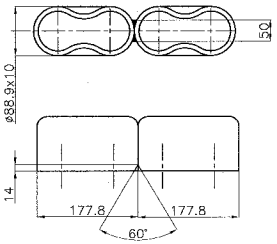
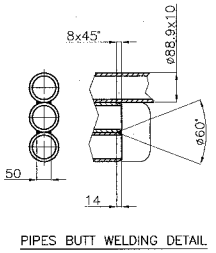
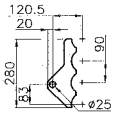


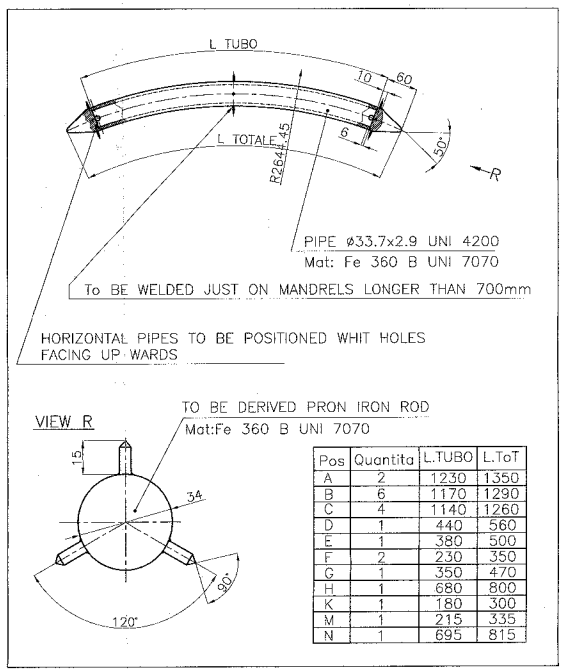




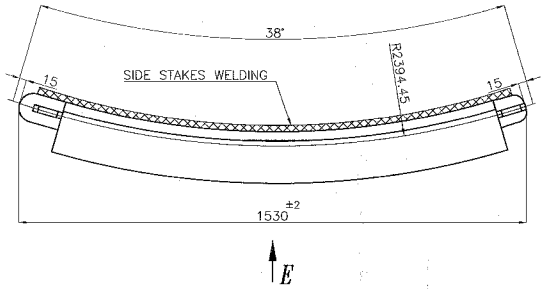


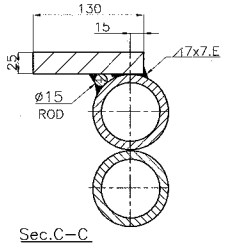
هنگام نصب بروی کار
به پانل جوش داده
می شود.

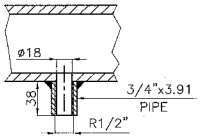


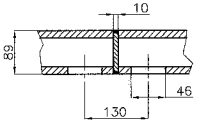


Pos	Quantita	L.TUBO	L.ToT
A	2	1230	1350
B	6	1170	1290
C	4	1140	1260
D	1	440	560
E	1	380	500
F	2	230	350
G	1	350	470
H	1	680	800
K	1	180	300
M	1	215	335
N	1	695	815









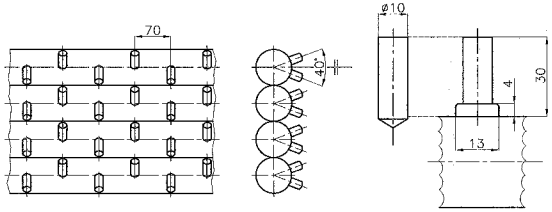
WELDINGS:
EDGE PREPARATION FOR WELDING TO UNI 11001
TICKNESS TO CONNECT IS A=0.7

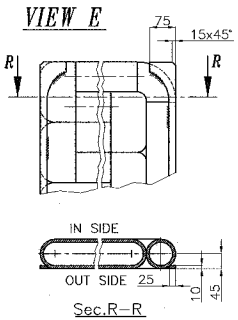
MATERIALS:
PIPES
PLATES
Fe 410– 1KW – UNI 5869
C=0.1%MAX
Mn=0.5%MAX
Si=0.35%MAX

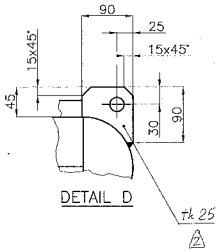
HOT–ROLLED AND SEAMLESS STEEL PIPE BENTLER OR SIMILAR
MATERIAL: St 37.0.3.DWA DIN 1629/84 WITH DIN 50049/3.1.B CERTIFICATES
C=0.1%MAX
Mn=0.5%MAX
Si=0.35%MAX

ANNELING MUST DO BETWEEN 620–650 °C FOR ONE TIME OF 4 HOURS AT REGIME . WITH ONE TEMPERATURE ON INCREASE OF 50°C/g AND ONE SLOPE OF30°C/g TILL 300 °C THAN HAVE TO BE COOLED OFF ON AIR

Stakes
s10(18–10–70)trw – nelbon type
material:st37– 3k din 17100
weld on panel inner side(see drwg)







Panel 2-3-4
7-8-9

all the welding must be at whole shime edge preparation for welding according to uni 1101 rules
all welding s must be executed using philips flux cored welding wire type pz 6129 ni basic 20 – e71 t –5

wash the inner parts very well
weld assuring seal:
test presure 1000 kpa
OPERATING PRESSURE 600 KPa
MAKE TEST PRESSURE FOR 24 HOURS TOTAL TIME

REV. تغییرات	DATE تاریخ	DESCRIPTION– شرح	Design طراح	Drawn ترسیم‌کننده	Checked بازرس	Approved تأییدکننده
2	91/4/31	add thickness 25 mm for det(D)				
1	85.12.26	تهیه نقشه				

REVISIONS–تغییرات

IRAN ALLOY STEEL CO. شرکت فولادآلیاژی ایران

Heat Treatment: عملیات حرارتی: See Note

DAMCODE: کدداخلی | WAREHOUSE CODE: کدانبار: 3 8 0 3 0 4 0 0 1 2

Material: جنس: See Draw

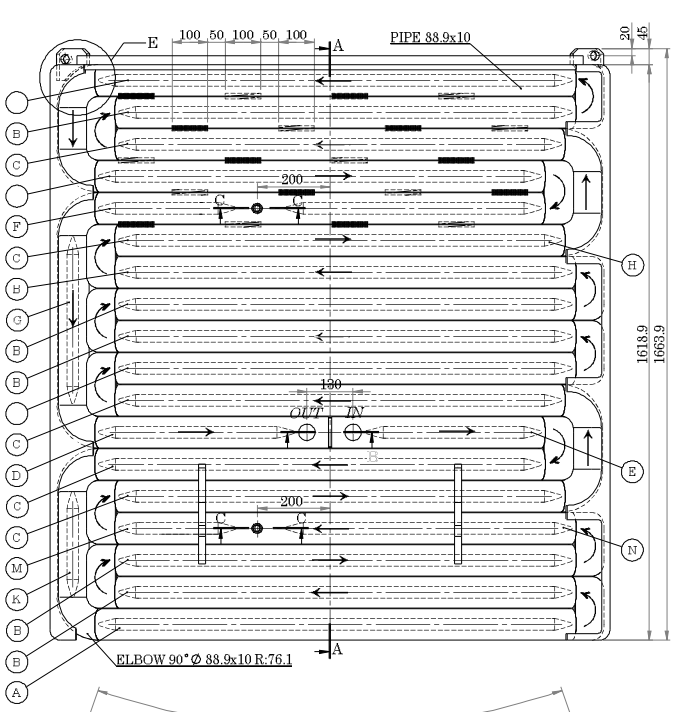
COMPUTER AIDED FILE: فایل کامپیوتری کنکو C D 0 3 0 0 5 4

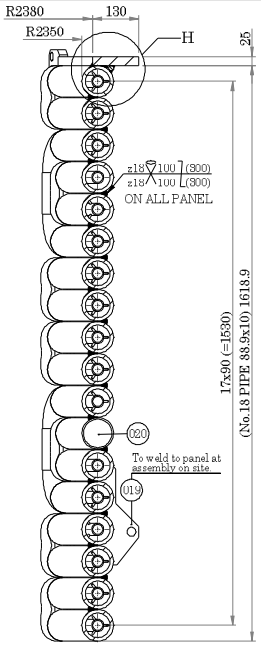
TITLE: عنوان نقشه: PANEL

Scale: مقیاس: 0:0 | Mass(kg): وزن: | Size: سایز: A1

Date: تاریخ: 85.12.26 | Sheet: صفحه: 1/1

DRAWING NO: شماره نقشه: ND1103M2202200314 | Rev. تغییرات: 0 2





SECTION A-A

ALL THE WELDING ◺ ▽ ⧖ MUST BE AT WHOLE SHIM.

EDGE PREPARATION FOR WELDING ACCORDING TO UNI 11001 RULES.

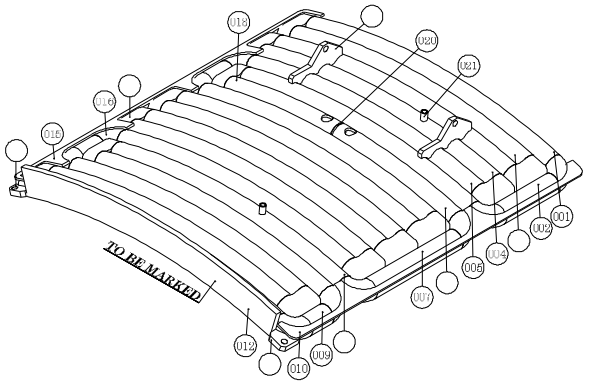
WELDING
ALL WELDING MUST BE EXECUTED
USING PHILIPS FLUX CORED WELDING WIRE
TYPE PZ 6129 N1 BASIC 20-E71T-5

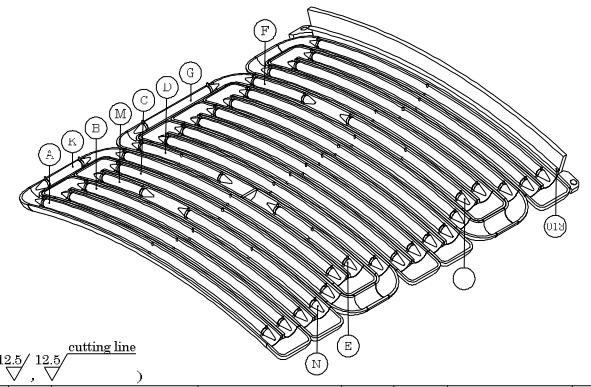
WASH THE INNER PART VERY WELL
WELD ASSURING SEAL
OPERATING PRESSURE 600 KPa
TEST PRESSURE 1000 KPa
MAKE A TEST PRESSURE FOR 24 HOURS TOTAL,TIME

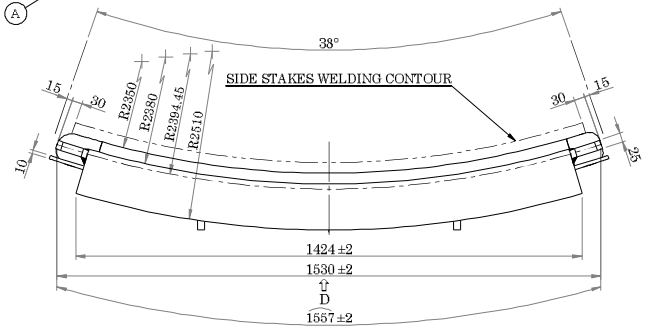
MATERIALS
-PLATES:
H II DIN 17155 , Fe 410. 1KW. UNI 5869 C = 0.1 % MAX
Mn= 0.5% MAX
Si = 0.35% MAX

-PIPES:
HOT ROLLED AND SEAMLESS STEEL PIPE
BENTLER OR SIMILAR
MATERIAL: ST 37.0.S.DWA DIN 1629/84
WITH DIN 50049/3.1.B CERTIFICATES
CARBON (C) 0.1% MAX.
MANGANESE (Mn) 0.5% MAX.
SILICIUM (Si) 0.35% MAX.

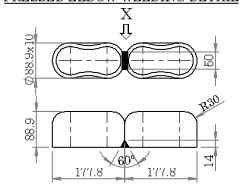
-ANNEALING MAST BE BETWEEN
620 ÷ 650 °C FOR ONE TIME OF
4 HOURS AT REGIME: WITH ONE
TEMPERATURE ON INCREASE OF
50°C /R AND ONE SLOPE OF 30°C/R
TILL 300°C THAN HAVE TO BE COOLED OFF ON AIR



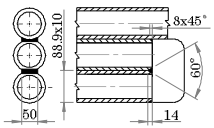




PRESSED ELBOW WELDING DETAIL



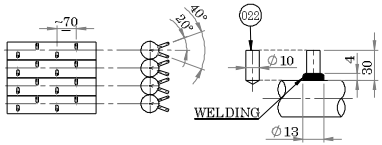
VIEW X
SCALE 1 : 10

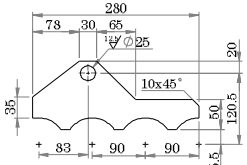


PIPES BUTT WELDING DETAIL

A- CHAMFERING BY MACHINE OF PARTS TO JOIN (PIPES-COUPLES).
B - SPOT -WELDING WITH PORT = 2.5mm AND FOLLOWING WELDING IN FIRST AND SECOND PASS WITH BASIC WIRE FEEDER " PHILIPS" (FILARC) PZ 6125 Ø1.2 O PZ 6129.
C- THIRD PASS OF FINISHING WITH SEMIBASIC WIRE FEEDER Ø1.2 "PHILIPS" (FILARC) TYPE PZ 6113.

STAKES
S10 (18.10.70) TRW-NELSON TYPE
MATERIAL: ST37.2 DIN 17100
WELD ON PANEL
INNER SIDE (SEE DRAW.)
NO. 200 PIECES/m2 EQUIDISTANT
WELDING ACCORDING TO TRW - NELSON METHOD





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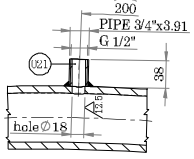
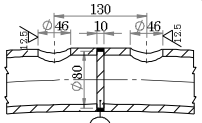
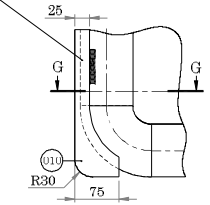


SECTION C-C
SCALE 1 : 5

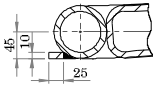
PLATES TO BE WELDED ON PIPE ONLY IN ORDER TO ALLOW DILATATION.



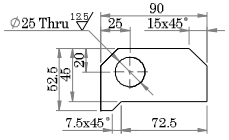
SECTION B-B
SCALE 1 : 5



VIEW D
SCALE 1 : 6



SECTION G-G
SCALE 1 : 6



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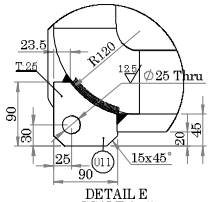
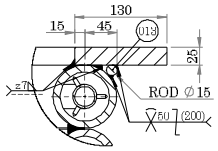
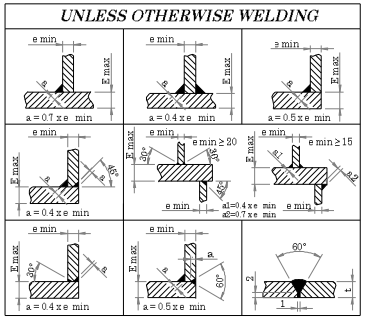


DETAIL E
SCALE 1 : 5



DETAIL H
SCALE 1 : 5



cutting line

POS	QTY	DESCRIPTION	MATERIAL		UNIT MASS (kg)	TOTAL	CODE NO.	ASSY . CODE
033	01	MANDREL CODE N	ST 37.2		-	-	3803040012	
032	01	MANDREL CODE M	ST 37.2		-	-	3803040012	
031	01	MANDREL CODE K	ST 37.2		-	-	3803040012	
030	01	MANDREL CODE H	ST 37.2		-	-	3803040012	
029	01	MANDREL CODE G	ST 37.2		-	-	3803040012	
028	01	MANDREL CODE F	ST 37.2		-	-	3803040012	
027	01	MANDREL CODE E	ST 37.2		-	-	3803040012	
026	01	MANDREL CODE D	ST 37.2		-	-	3803040012	
025	06	MANDREL CODE C	ST 37.2		-	-	3803040012	
024	07	MANDREL CODE B	ST 37.2		-	-	3803040012	
023	02	MANDREL CODE A	ST 37.2		-	-	3803040012	
022	200/m2	STAKES Ø 10x30	ST 37.2		-	-	3803040012	
021	02	PIPE Ø 3/4"x3.91x38	SEE NOTE		-	-	3803040012	
020	01	PL Ø 80x10	H II		-	-	3803040012	
019	02	PL 280x115x20	H II		-	-	3803040012	
018	01	PIPE Ø 88.9x10 Lb 695	SEE NOTE		-	-	3803040012	
017	18	PRESSED ELBOW	SEE NOTE		-	-	3803040012	
016	10	ELBOW 90° Ø 88.9x10 R.76.1	SEE NOTE		-	-	3803040012	
015	01	PL 1618.9x126x10	H II		-	-	3803040012	
014	01	PL 90x52.5x25	H II		-	-	3803040012	
013	01	ROD Ø 15 L 1460	ST 37.2		-	-	3803040012	
012	01	PL (R.2510,r.2380,T.25)	H II		-	-	3803040012	
011	01	PL 90x90x25	H II		-	-	3803040012	
010	01	PL 1618.9x126x10	H II		-	-	3803040012	
009	03	PIPE Ø 88.9x10 L 117.8	SEE NOTE		-	-	3803040012	
008	01	PIPE Ø 88.9x10 Lb 1259	SEE NOTE		-	-	3803040012	
007	01	PIPE Ø 88.9x10 L 477.8	SEE NOTE		-	-	3803040012	
006	01	PIPE Ø 88.9x10 Lb 663	SEE NOTE		-	-	3803040012	
005	06	PIPE Ø 88.9x10 Lb 1269	SEE NOTE		-	-	3803040012	
004	01	PIPE Ø 88.9x10 Lb 1290	SEE NOTE		-	-	3803040012	
003	07	PIPE Ø 88.9x10 Lb 1290	SEE NOTE		-	-	3803040012	
002	01	PIPE Ø 88.9x10 L 297.8	SEE NOTE		-	-	3803040012	
001	02	PIPE Ø 88.9x10 Lb 1848	SEE NOTE		-	-	3803040012	
314	01	ASSEMBLY	-		1018		3803040012	-

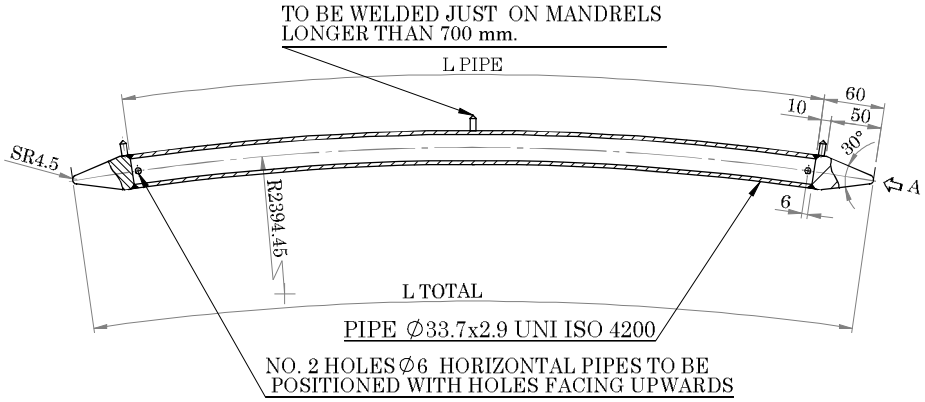
NOTE:
Dimension without tolerance follow:
ISO 2768-M
Heat treatment :
SEE DWG

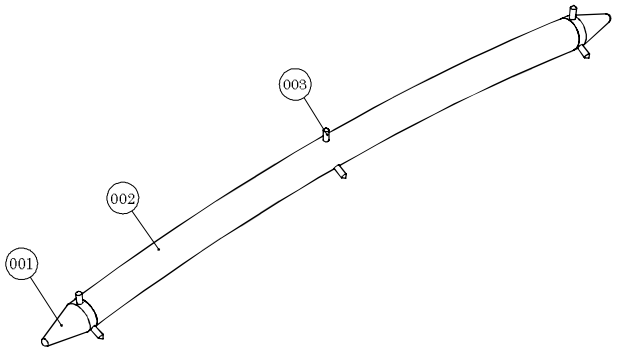
	NAME	DATE
DES.		
DRA.		92/03/14
CHK.	A.Mamdar	92/03/18
APPR.	M.Mirjalili	92/03/18

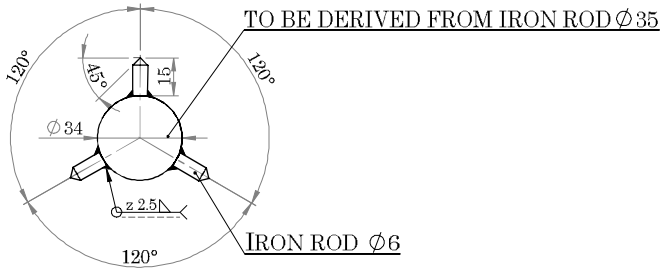
TITLE:
PLANT UNIT 03
PANEL 2-3-4-7-8-9

IRAN ALLOY STEEL CO

ORDER	RF1/5	REF.DRAW	*ND1103M2202200314* REV
CODE NO.	3803040012	DWG NO.	*FD1103M2202200314* 00
QCTM NO.	BF50246	SCALE : 1 : 10	SIZE: A2 SHEET: 1 OF 3







VIEW : A
SCALE 1 : 2

POS	QTY	L.PIPE	L.TOTAL
A	2	1230	1350
B	7	1170	1290
C	6	1140	1260
D	1		560
E	1		500
F	1		400
G	1	350	470 (right)
H	1		740
K	1	180	300 (right)
M	1		340
N	1	710	830

cutting line

12.5 (▽ , 12.5 ▽)

POS	QTY	DESCRIPTION	MATERIAL	UNIT MASS (kg)	TOTAL MASS (kg)	CODE NO.	ASSY . CODE
003	09	ROD ∅6x15	ST 37-2	-		-	3803040012
002	01	PIPE ∅33.7x2.9	ST 37-2	-	-	UNI ISO 4200	3803040012
001	02	ROD ∅35x60	ST 37-2	-			3803040012
314	01	ASSEMBLY	-	1018	1018	3803040012	-

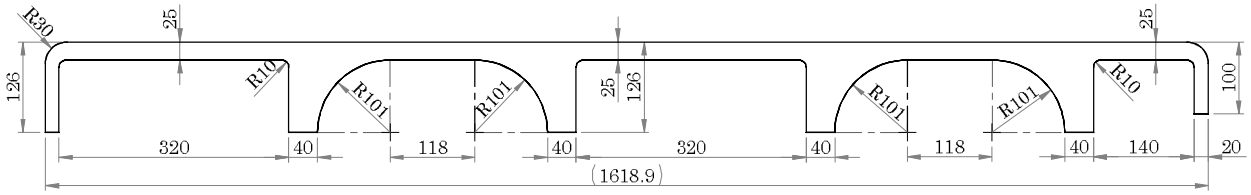
NOTE:
Dimension without tolerance follow:
ISO 2768-M
Material:
ST 37-2 DIN 17100

	NAME	DATE
DES.		
DRA.	A.Alamdar	92/03/14
CHK.	A.Alamdar	92/03/18
APPR.	M.Minjaliti	

TITLE:
PLANT UNIT 03
PANEL 2-3-4-7-8-9
(MANDREL)

IRAN ALLOY STEEL CO

ORDER.	RF7/5	
CODE NO.	3803040012	
QCTM NO.	BF50246	
REF.DRAW	***ND1103M2202200314***	REV
DWG NO.	***FD1103M2202200314***	00
SCALE 1 : 5	SIZE: A3	SHEET: 2 OF 3



PIECE No.015,T=10
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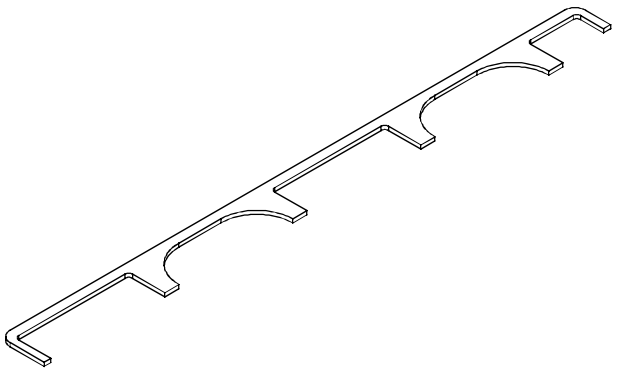
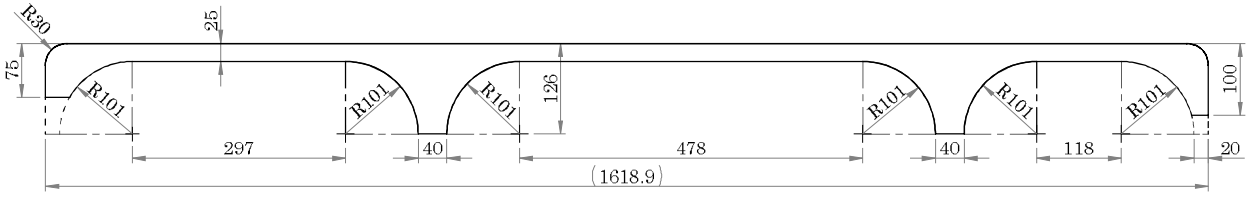
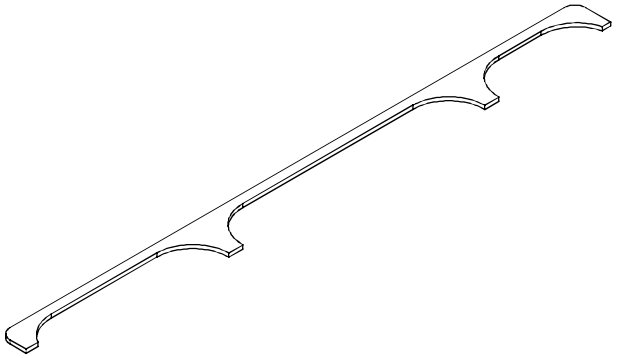




PIECE No.010,T=10
SCALE : 1:7



cutting line
12.5

POS	QTY	DESCRIPTION	MATERIAL	UNIT MASS (kg)	TOTAL MASS (kg)	CODE NO.	ASSY . CODE
015	01	PL 1618.9x126x10	H II	-			3803040012
010	01	PL 1618.9x126x10	H II	-			3803040012
314	01	ASSEMBLY	-		1018	3803040012	-

NOTE:
Dimension without tolerance follow:
ISO 2768-M
MATERIAL:
H II DIN 17155

	NAME	DATE
DES.		
DRA.		92/03/14
CHK.	A.Alamdar	
APPR.	M.Mirjalili	92/03/18

TITLE:
PLANT UNIT 03
PANEL 2-3-4-7-8-9
(PIECE NO.015,010)

IRAN ALLOY STEEL CO

ORDER.	RF7/5	REF.DRAW	***ND1103M2202200314*** REV
CODE NO.	3803040012	DWG NO.	***FD1103M2202200314*** 00
QCTM NO.	BF50246	SCALE: 1 : 7	SIZE: A3 SHEET: 3 OF 3