

NOTE

- FOCOLARE ONDULATO FORMATO A CALDO, NEL RANGE DELLE TEMPERATURE DI NORMALIZZAZIONE DI 950°-890°C CON LA REGISTRAZIONE DEI CICLI TERMICI NECESSARI
- ANELLO PASSO D'UOMO FORMATO A CALDO
- OVALIZZAZIONE MAX 1%
- MATERIALI IN ASTM CON C MAX IN ANALISI DI COLATA < 0,22%
- PIASTRE TUBIERE COSTRuite IN DUE PEZZI CON TRATTAMENTO DI NORMALIZZAZIONE E DISTENSIONE DOPO RULLATURA A FREDDO
- RASTREMATURA TRONCHETTO ALIMENTAZIONE PART. "N" ESEGUITA A CALDO

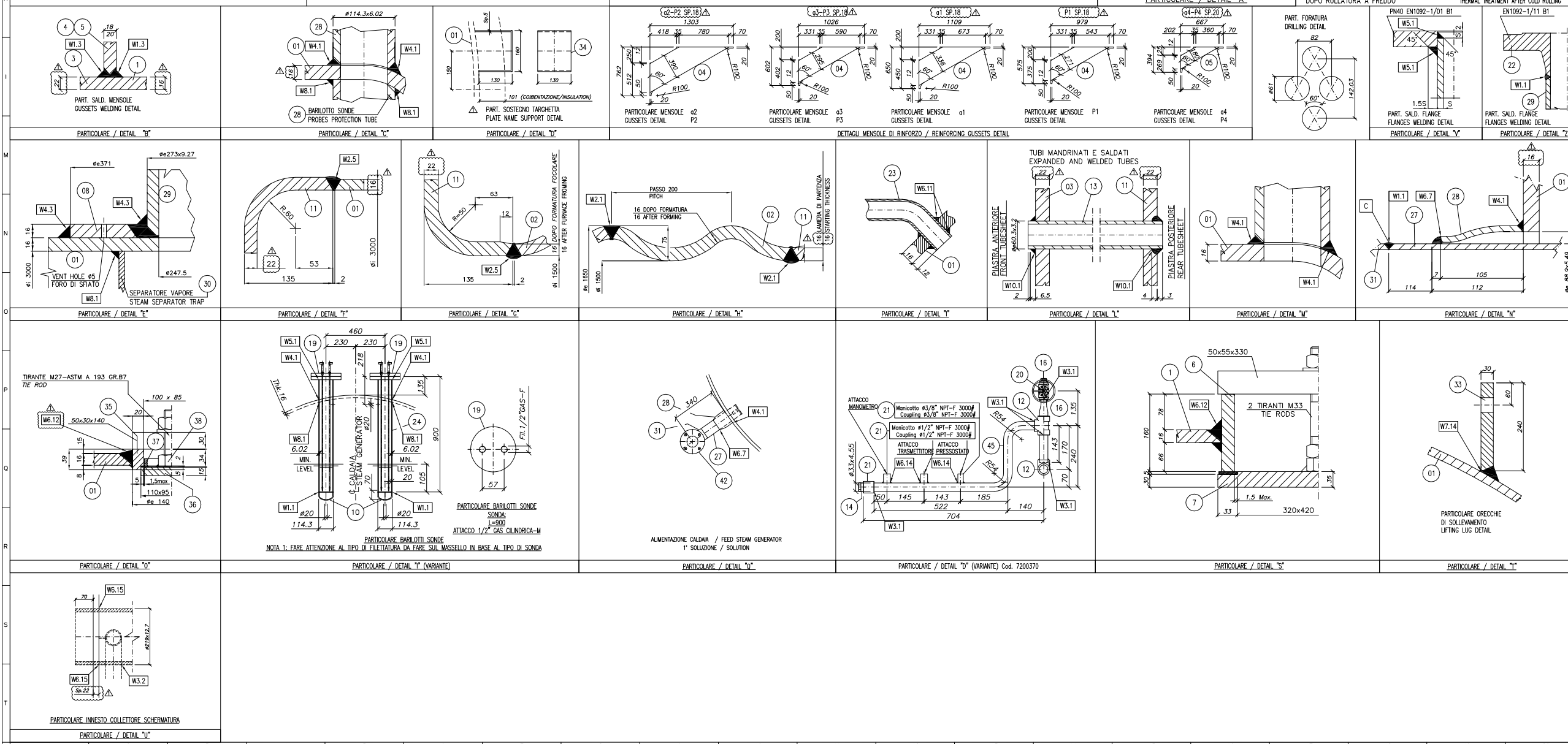
NOTES

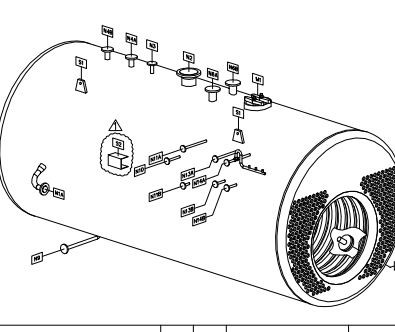
- CORRUGATED FURNACE HOT FORMED, IN THE NORMALIZING TEMPERATURE RANGE OF 950°-890°C, WITH RECORDING OF THE NEEDED THERMIC CYCLES
- MAN HOLE RING HOT FORMED
- OVALITY MAX 1%
- ASTM MATERIALS WITH C CONTENT < 0,22%
- END PLATES MANUFACTURED IN TWO PIECES WITH NORMALIZATION AND STRESS RELIEVING HEAT TREATMENT AFTER COLD ROLLING
- FEED BRANCH TAPERING DET."N" HOT FORMED


NOTE:

- PER LA TABELLA SUI CARICHI BOCCHELLI VEDERE Doc. N° T-A 18164
- FOR NOZZLES TABLE LOAD SEE Doc. N° T-A 18164
- PER I DETTAGLI DI SALDATURA VEDERE Doc. T-33116
- FOR WELDING DETAIL SEE Doc. T-33116

RIFERIMENTI DESEGNI / REFERENCE DRAWINGS	
N° DOCUMENTO / DOCUMENT N°	DESCRIZIONE / DESCRIPTION
T-33150 22BB	SOHERMATURA / REVERSAL CHAMBER D.76.1



	21		22		23	24		
	01	18	336	15°	1500	524	258582	SETTORE DI CORONA CIRCOLARE
	02	18	390	15°	1500	537	256777	PART OF CIRCLE RING
	03	18	295	15°	1500	744	222067	SETTORE DI CORONA CIRCOLARE
	04	20	180	52°30'	740		250882	PART OF CIRCLE RING
	P1	18	271	15°	1500	524	258582	SETTORE DI CORONA CIRCOLARE
	P2	18	390	15°	1500	537	256777	PART OF CIRCLE RING
	P3	18	295	15°	1500	744	222067	SETTORE DI CORONA CIRCOLARE
	P4	20	180	52°30'	740		250882	PART OF CIRCLE RING
POS.	b	h	β	γ	r	superficie mm² SURFACE mm²	FORMA - SHAPE	α
M1	PASSO UOMO / MAN HOLE							
S2	SUPP. PORTA TARGA / NAMEPLATE SUPPORT							
S1	ORECCHIE DI SOGL / LIFTING LUGS							
H2	PORT. GPEZ. / HAND HOLE							
N14/B	ANELLO VISIVO / LEVEL GLASS							
N13/B	ANELLO VISIVO / LEVEL GLASS							
N11A/B	IND. DI LIVELLO / LEVEL INDICATOR							
N10	SPURGO DI SUPERFICIE / SURFACE DRAIN							
N9	SCARICO / DRAIN							
N6A/B	SONDA DI BLOCCO / SHUT-DOWN PROBE							
N5	RISERVA / SPARE							
N4A/B	VALV. SICUREZZA / SAFETY VALVE							
N3	WPRSC/NFTA / STEAM PREHEATER							
N2	USCITA VAPORE / STEAM OUTLET							
N1A	ALIMENTAZIONE / F.W. CONNECTION							
								
47	TRONCHETTO Ø633,4 4.55 ±12.5% ASTM A 106 GR. B SAC.1.1 192°C							
46	NOZZLE							
45	NOZZA							
44	STUDIOS							
43	FLANGIA UNI EN 1092-1 DN85 5.08 ±12.5% ASTM A 193 GR. B7 SAC.1.1 192°C							
42	FLANGIA UNI EN 1092-1 DN85 5.16 ±12.5% ASTM A 105 SAC.1.1 192°C							
41	PROFILATO 1 50x7 S275JR UNI EN 10025 192°C							
40	COUPLING M33 ASTM A 105 SAC.1.1 192°C							
39	COUPLING M27 ASTM A 105 SAC.1.1 192°C							
38	ANELLO 20x5 5 0.3 ASTM A 516 GR.60 SAC.1.1 192°C							
37	COPRICHIO PASSA VANGO 15 0.3 P 355 NH EN 10028/3 SAC.1.2 192°C							
36	ANELLO 20x5 20 ±12.5% ASTM A 106 GR. B SAC.1.1 192°C							
35	NAME PLATE SUPPORT S275JR UNI EN 10025 192°C							
34	FLANGIA 30x3 30 0.3 P 355 NH EN 10028/3 SAC.1.2 192°C							
33	FLANGIA L.R. ASME B16.9 Ø6 48.3 5.08 ±12.5% ASTM A 234 GR. WPB SAC.1.1 192°C							
32	FLANGIA L.R. ASME B16.9 Ø6 88.9 5.16 ±12.5% ASTM A 234 GR. WPB SAC.1.1 192°C							
31	NOZZA 4"x3.1/2" ASME B16.9 8.74 ±12.5% ASTM A 106 GR. B SAC.1.1 192°C							
30	NOZZA 4"x3.1/2" ASME B16.9 8.74 ±12.5% ASTM A 106 GR. B SAC.1.1 192°C							
29	NOZZA Ø6 88.9 5.49 ±12.5% ASTM A 106 GR. B SAC.1.1 192°C							
28	NOZZA Ø6 73 5.16 ±12.5% ASTM A 106 GR. B SAC.1.1 192°C							
27	NOZZA Ø6 48.3 5.08 ±12.5% ASTM A 106 GR. B SAC.1.1 192°C							
26	NOZZA Ø6 114.3 6.02 ±12.5% ASTM A 106 GR. B SAC.1.1 192°C							
25	NOZZA Ø6 33.4 5.65 ±12.5% ASTM A 106 GR. B SAC.1.1 192°C							
24	FLANGIA UNI EN 1092-1 DN100 9.27 ±12.5% ASTM A 105 SAC.1.1 192°C							
23	MANICOTTI NPT-F 3000# ANSI B16.1 ASTM A 105 SAC.1.1 192°C							
22	VALVOLA A SICUREZZA 1/2" SHARP-T BODY ASTM A 105 SAC.1.1 192°C							
21	FLANGIA UNI EN 1092-1 DN100 ASTM A 105 SAC.1.1 192°C							
20	FLANGIA UNI EN 1092-1 DN85 ASTM A 105 SAC.1.1 192°C							
19	FLANGIA UNI EN 1092-1 DN85 ASTM A 105 SAC.1.1 192°C							
18	FLANGIA UNI EN 1092-1 DN40 ASTM A 105 SAC.1.1 192°C							
17	NIPPLO A BOTTEGLIA 1"x1/2" SHARP-T BODY ASTM A 105 SAC.1.1 192°C							
16	FLANGIA UNI EN 1092-1 DN25 ASTM A 105 SAC.1.1 192°C							
15	NIPPLO FILARETTI NPT-F 3000# ANSI B16.1 ASTM A 105 SAC.1.1 192°C							
14	NIPPLO FILARETTI NPT-F 3000# ANSI B16.1 ASTM A 105 SAC.1.1 192°C							
13	SMOKE TUBES Ø6 33.4 3.2 60000 112.5% ASTM A 210 GR. A P 355 ST 1008/16/1							

22	PORTA TARGA NAME PLATE SUPPORT	60x20	3	—	S275 JR	—	—	—
21	TARGHETTA NAME PLATE	60x20	3	—	SA 240 TP 304	—	—	—
20	TUBO PIPE	Øe42.2	4.85	±12.5%	ASTM A106 Gr.B	—	SAC. 1.1	224°C
19	MANICOTTI NPT-F 3000# ANSI B16.11 COUPLINGS	1.1/2"	—	—	ASTM A 105	—	—	224°C
18	MANICOTTI NPT-F 3000# ANSI B16.11 COUPLINGS	1/2"	—	—	ASTM A 105	—	—	224°C
17	TUBO PIPE	Øe26.7	3.91	±12.5%	ASTM A106 Gr.B	2	—	274°C
16	TUBO PIPE	Øe48.3	5.08	±12.5%	ASTM A106 Gr.B	—	—	274°C
15	LAMIERE PLATES	—	5	0.3	P 355 NH UNI EN 10028/3	—	—	224°C
14	DADI NUTS	—	—	—	ASTM A 194 Gr.2H	—	—	—
13	VITI STUDS	—	—	—	ASTM A 193 Gr.B7	—	—	—
12	FLANGE FLANGES	DN32 PN40 EN1092-1/01 B1	—	—	ASTM A 105	—	SAC.1.1	224°C
11	FLANGE CIECHE BLIND FLANGES	ASME B16.5 300# R.F.	—	—	ASTM A 105	—	SAC.1.1	224°C
10	FLANGE FLANGES	ASME B16.5 300# R.F. W.N.	—	—	ASTM A 105	—	SAC.1.1	224°C
9	MEMBRATURE AUSILIARIE E ALETTE RINS AND AUXILIARY STRUCTURES	—	6	0.3	ASTM A516 Gr.60	—	SAC.1.1	274°C
8	FONDELLI HEADS	—	8-12-15	0.3	ASTM A516 Gr.60	—	SAC.1.1	274°C
7	PROFILATO A T T PROFILE	50x5	-	-	S275 JR	—	—	—
6	TUBI TUBES	Øe76.1	4	0/+35%	ASTM A210 Gr.A1	—	SAC.1.1	274°C
5	COLLETTORE HEADER	Øe101.6	5.74	±12.5%	ASTM A106 Gr.B	—	SAC.1.1	274°C
4	COLLETTORE HEADER	Øe114.3	6.02	±12.5%	ASTM A106 Gr.B	—	SAC.1.1	274°C
3	COLLETTORE HEADER	Øe141.3	6.55	±12.5%	ASTM A106 Gr.B	—	SAC.1.1	274°C
2	COLLETTORE HEADER	Øe219.1	12.7	±12.5%	ASTM A106 Gr.B	—	SAC.1.1	292°C
(Pos.)	MEMBRATURE MANUFACTURERS	Sp. THK	Toil. Tol.	—	MATERIALI MATERIALS	—	Gr. ACCIAIO S.T. CLASS	T. PROGETTO DESIGN T.
TOLLERANZE DI FABBRICAZIONE SECONDO STANDARD T-1081 / MANUFACTURING TOLERANCES ACCORDING TO STANDARD T-1081								
⑤								
④								
③								
②	19/06/13	REVISIONATO DOVE INDICATO ②			R.VILLA	DEFILIPPI		LURAGHI
①	10/05/23	REVISIONATO DOVE INDICATO ①			R.VILLA	DEFILIPPI		LURAGHI
0	17/04/13	EMISSIONE - ISSUE			R.VILLA	DEFILIPPI		LURAGHI
REV.	DATE	DESCRIPTION			PRPD	CHKD	APPR	
COMMESSA PROD. ORDER		COMMITTEE CUSTOMER			VERSIONE INTERNA INT. VESITE		PROVA IDRAULICA HYDR. TEST	
ANNO YEAR	2013				DENOMINAZIONE SCHEMATA D76.1 PER SG 2200/2500			
MATRICOLO PART NUMBER					DESCRIPTION REVERSAL CHAMBER D76.1 SG 2200/2500			
N° SERIAL N.	PROTOTIPO	Proprietà riservata a termini di legge			Numero Documento T-33150 22BB 2			
COORD. COORD.	7002405	This drawing contains proprietary information, which must not be disclosed in any form, without prior written permission.			Page/Page 1 di 1			
SCALA SCALE	1 : 20				Revisione Revision			
13		14		15		16		