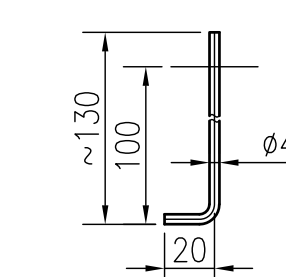
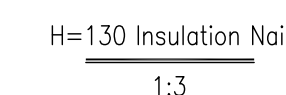
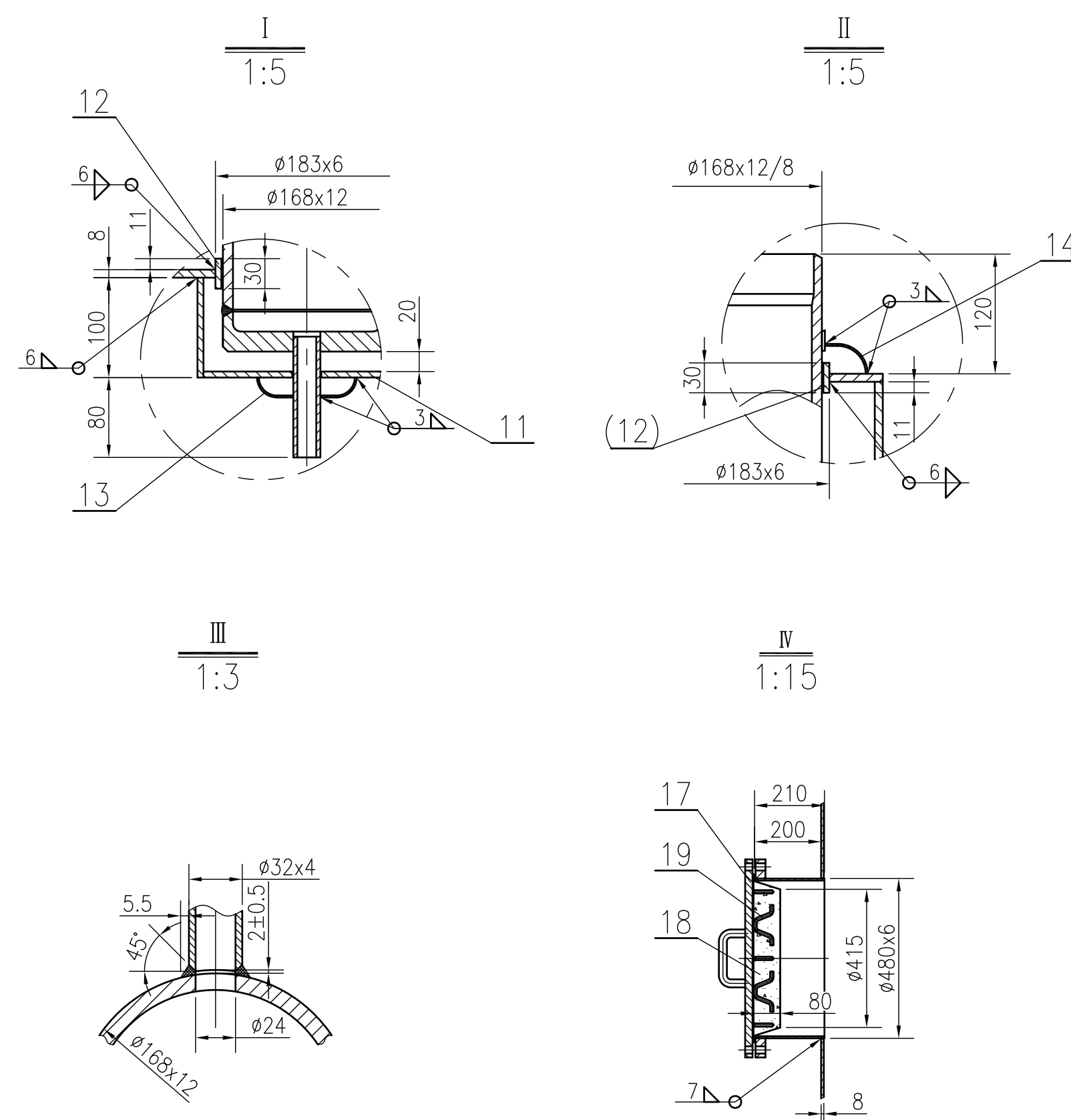
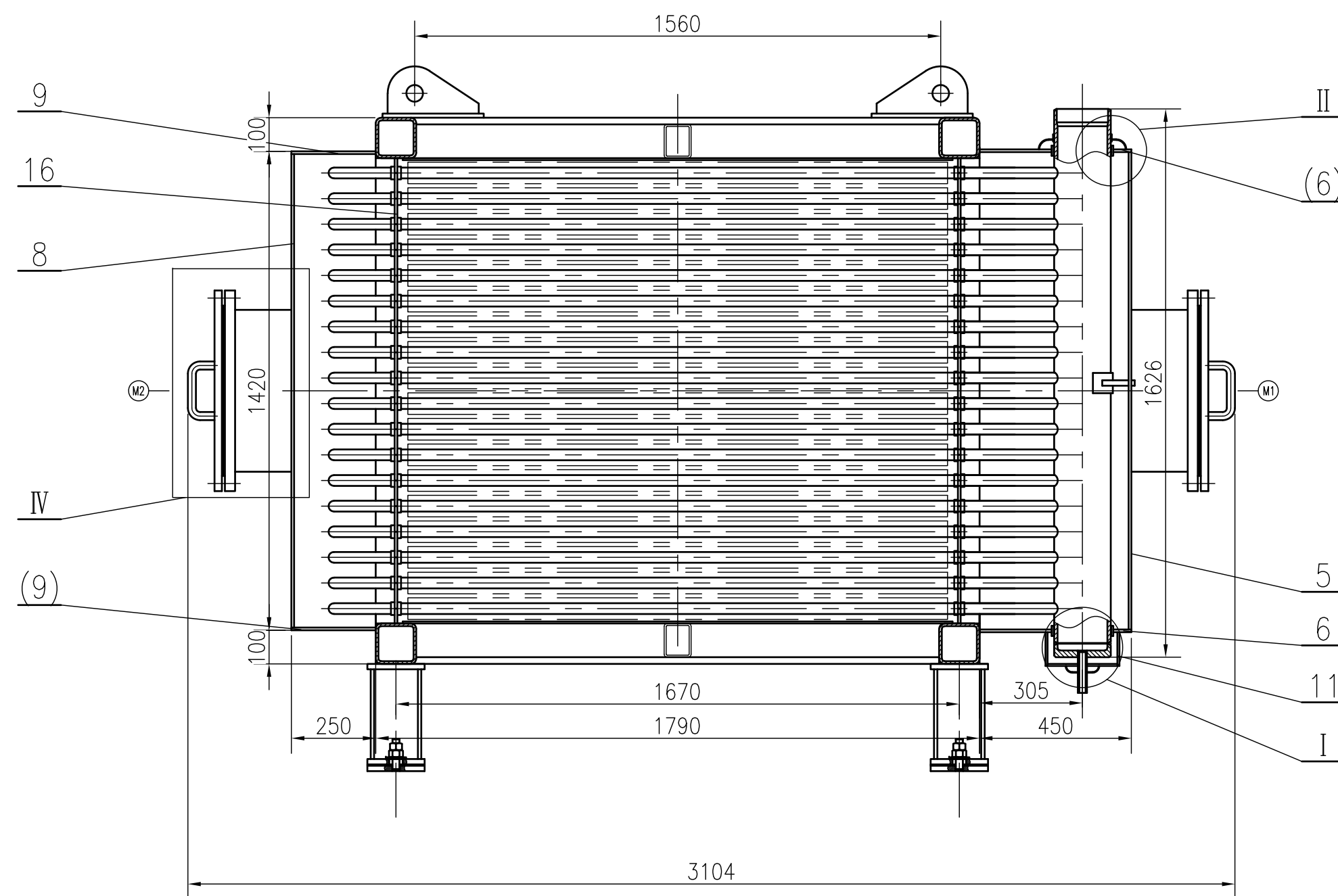






Technical Requirements:

1. This component shall be manufactured, inspected and accepted in accordance with TSG 11—2020 Boiler Safety Technical Regulations, GB/T 16507—2022 Water-tube Boilers and the requirements of the drawings.
2. The 18 heat exchange tube groups shall be manufactured using the same jig.
3. All unmarked welds in the drawing are conventional continuous welds, and the fillet weld height is the thickness of the thinner part.
4. TIG welding shall be used for the welding of the heat exchange tube group and the header (see Detail Ⅲ). 100% surface non-destructive testing shall be performed on the fillet joints of the pipe joints on the header, and the quality grade of the welded joints shall not be lower than Grade I.
5. After the header and heat exchange tube group are welded together, a hydrostatic test shall be carried out in accordance with the requirements of TSG 11—2020 and GB/T 16507—2022, with the hydrostatic test pressure being 3.75MPa (working pressure 2.5MPa).
6. The overall outer surface of this component shall be painted with anti-corrosion paint before leaving the factory. The surface treatment grade shall reach Sa2.5. One coat of inorganic zinc-rich primer (temperature resistant to 400°C) shall be applied, with a minimum dry film thickness of 50μm, and then one coat of silver gray (B04) silicone heat-resistant paint (temperature resistant to 400°C) shall be applied, with a minimum dry film thickness of 25μm. The total thickness of the outer surface paint film shall not be less than 75μm.
7. The packaging of this component shall comply with the relevant provisions of NB/T 47055—2017 General Technical Conditions for Boiler Coating and Packaging.
8. This component requires on-site insulation with an insulation thickness of 100mm. The insulation nails provided at the time of delivery are 150mm straight sections, with one end welded and fixed to the wall plate. During on-site insulation, the insulation nails shall be bent to a height of approximately 130mm. After installing the insulation cotton, the protruding part shall be bent again to fix the insulation cotton.
9. During the operation of this component, the boiler feed water quality shall comply with the requirements of GB/T 1576—2018 "Water Quality for Industrial Boilers."



Economizer		Material Component Scale 1:15					WT. 6205kg	
B0 供审查								2025.04.29
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 WUHAN ENGINEERING CO., LTD.		 上海瑞鼎环境工程技术有限公司 SHANGHAI RUIDING ENVIRONMENTAL ENGINEERING CO., LTD.						
用户 OWNER	PT PETRO OXO NUSANTARA			Owner Doc. No.				
项目 PROJ.	30000 TPA NPG PROJECT			阶段 PHASE	Detailed design	合同号 CONT. NO.	SHD-2025-04	
装置/厂区 UNIT	Waste Gas & Waste Liquid Incineration			比例 SCALE	1:15	第 1 张 SHEET	共 1 张 OF	
图名 DWG. NAME	Economizer			项目号 PROJ. NO.	SRD2502	专 业 SPECIAL	Device	
				图号 DWG. NO.	RD202WH-51-00			