



E) HYDRO TESTING:-

1. HYDRO TEST SHALL BE CARRIED OUT AS PER APPROVED PROCEDURES.
 2. CLEAN POTABLE WATER SHALL BE USED FOR HYDRO TEST & CHLORIDE CONTENT SHALL BE LESS THAN 25PPM.
 3. IF VERTICAL VESSEL IS TESTED IN HORIZONTAL POSITION, HYDRO TEST PRESSURE SHALL BE INCREASED IN ORDER TO TAKE THE EFFECT OF WATER HEAD CLEARANCE TO BE TAKEN FROM CLIENT/SAFEI.
 4. HYDRO TEST PRESSURE SHALL BE CHECK AT TOP MOST OF VESSEL.
 5. GASKET MATERIAL REQUIRED FOR HYDRO TEST SHALL BE SAME OR EQUIVALENT OF THE SERVICE GASKET.
 6. AFTER COMPLETION OF HYDRO TESTING & INSPECTION, EQUIPMENT SHALL BE THOROUGHLY DRAINED, CLEANED & DRIED.
 7. EQUIPMENT AFTER FINAL HYDROSTATIC TEST SHALL BE DISPATCHED IN AS TESTED CONDITION AFTER RELIVING PRESSURE TEST PRESSURE SHALL BE MAINTAINED FOR MIN. 1 HR.
- F) CLEANING & PAINTING:-**
1. VESSEL SHALL BE SWEEP BLASTED INTERNALLY TO REMOVE RUST, FREE SCALE, DERRIS, WELDING SLAG AND SPATTER.
 2. PAINTING/SURFACE FINISH:
 - i) ALL SS SURFACE SHALL BE PICKLED & PASSIVATED FROM INSIDE & OUTSIDE.
 - ii) ALL CS EXTERNAL SURFACE SHALL BE BLAST CLEANED TO SA2-1/2.
 - iii) ALL CS EXTERNAL SURFACE SHALL BE COATED WITH RED OXIDE PRIMER.
 3. EARLHING CLEATS/LUGS SHALL NOT GALVANIZED OR PAINTED.
 4. BOLTS, STUDS & NUTS SHALL BE PROTECTED BY RUST PREVENTING COATING PRIOR TO SHIPPING.

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G) SHIPPING & ERECTION:-

1. BEFORE SHIPING ALL THREADED CONNECTION TO BE PLUGGED. ALL FLANGES TO BE BLANKED OFF WITH 12THK. PLYWOOD OR STEEL DISC OF 5THK WITH RUBBER GASKET. EACH DISC TO BE SCREWED BY A MINIMUM OF FOUR BOLTS.
2. SPREADER BAR EMPLOYED DURING ERECTION OF EQUIPMENT.

H) APPLICABLE CODES & SPECIFICATION:-

1. DESIGN CODE SHALL BE ASME SEC.-VIII DIV.-1 LATEST EDITION.
2. ALL MATERIAL SHALL BE COMPLY WITH ASME SEC.-II PART A & B.
3. ALL FLANGES ACCORDING TO STANDARD ASME B16.5 FOR UP TO 600NB AND GREATER THAN 600NB SHALL BE AS PER ASME B16.47.
4. ALL PIPES SHALL BE SEAMLESS ACCORDING TO ASME B36.10 & ASME B36.19.
5. ALL FORGED-FITTING ACCORDING TO ASME B16.9.
6. ALL BOTTED FITTINGS, SOCKET WELDING AND THREADED ACCORDING TO ASME B16.11.

1) OTHER POINTS:-

1. THIS IS A DATASHEET CUM FABRICATION DRAWING, NO NEED TO SEND FABRICATION DRAWING SEPARATELY.
2. BILL OF MATERIAL IS VENDORS RESPONSIBILITY.
3. ALTHOUGH THE FABRICATION DRAWING ARE GIVEN BY CONSULTANTS, IT WILL BE RESPONSIBILITY OF VENDOR TO CHECK. FABRICATE & GUARANTEE AGAINST MANUFACTURE DEFECTS.

1	19.07.22	REVISED AS PER CLIENT COMMENTS & ISSUED FOR ENQUIRY/ENGINEERING	SDC	KKP	KKP
0	15.07.22	ISSUED FOR APPROVAL/ENQUIRY	SDC	KKP	KKP
REV. NO.	DATE	REVISIONS	BY	CHK	APPD.

CLIENT	M/s. UPL LTD. (ANKLESHWAR)	CONT.NO.	C-1581
PROJECT	ZDDP EXPANSION	CAD NO.	1581-VFSC-5418

TITLE	FABRICATION DRAWING FOR SCRUBBER COLUMN (SC-5418)
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