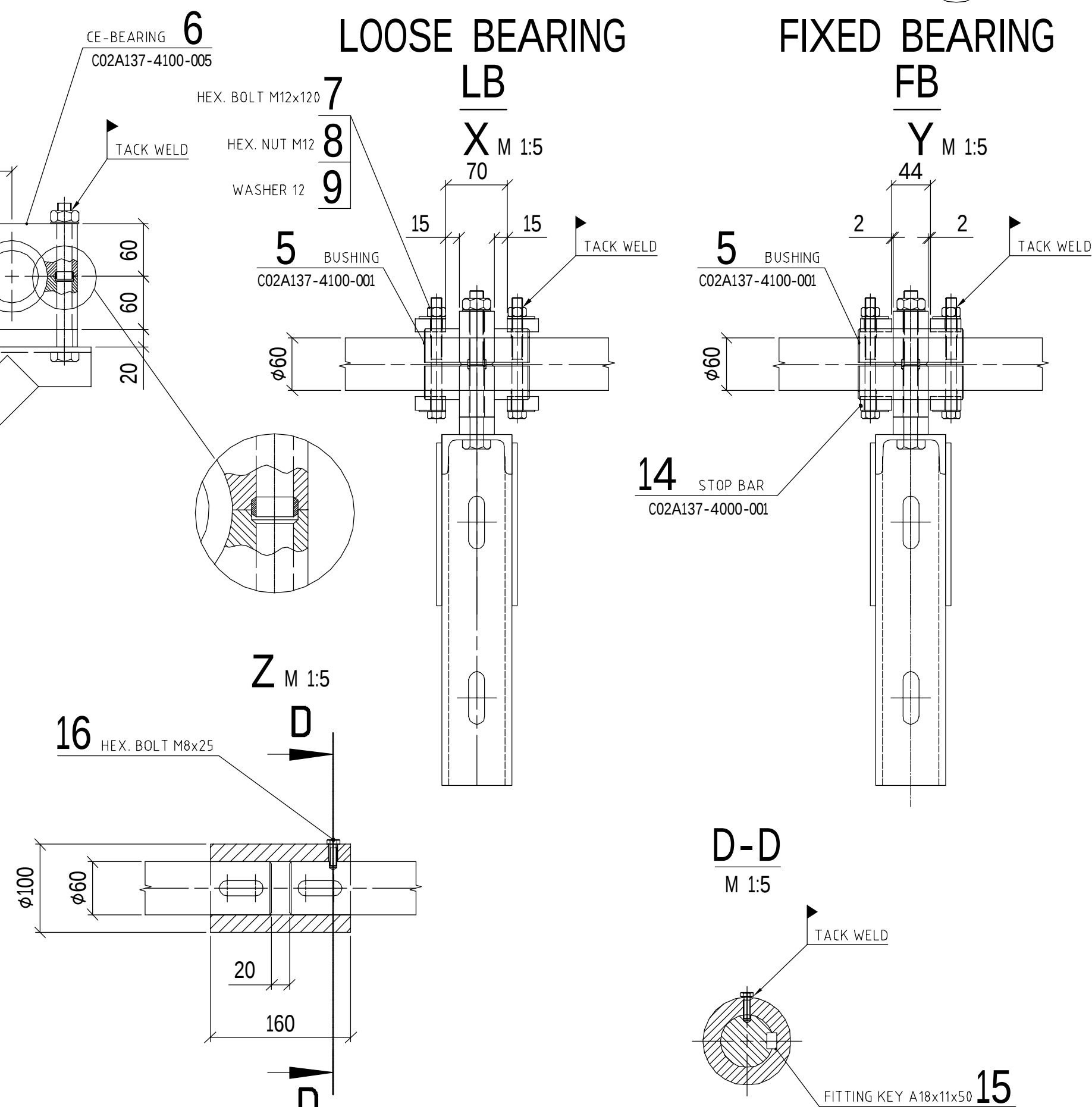
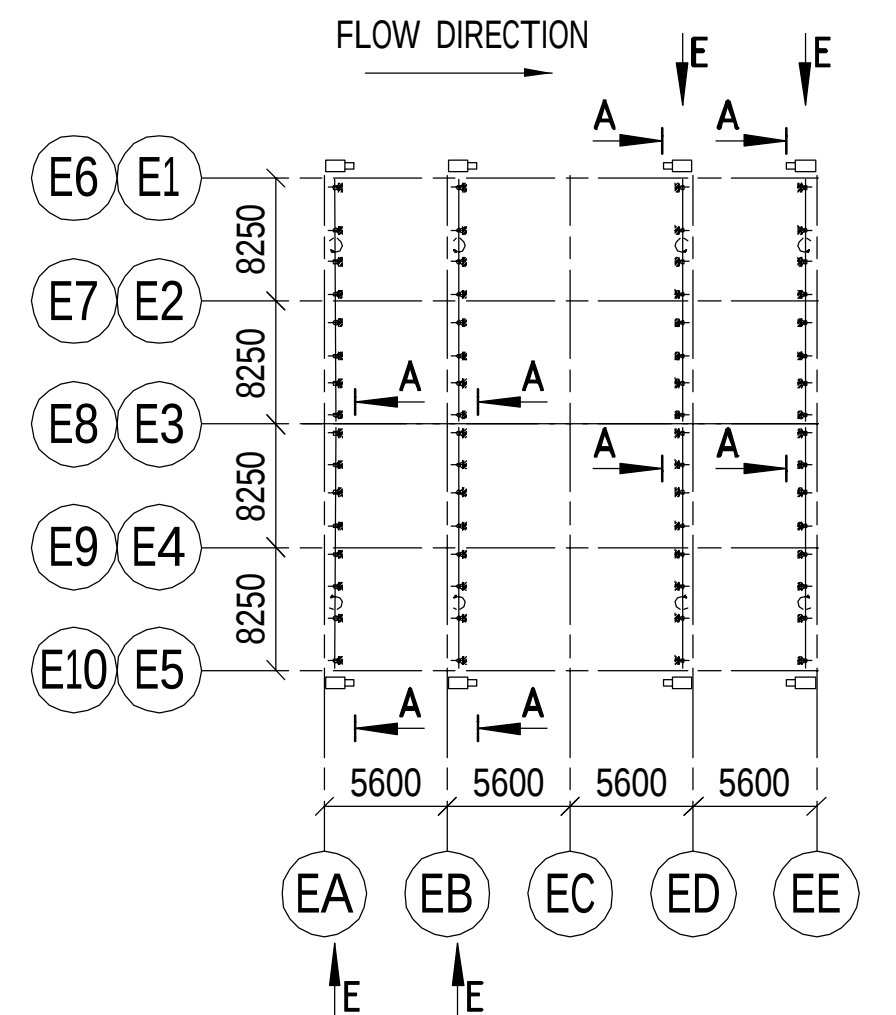


AFTER FINAL ASSEMBLY
HEXAGONAL NUTS AND
U-BOLTS ARE TO BE
LOCKED BY TACK WELDING



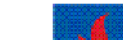
TOTAL WEIGHT =	881.93 Kg
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Deelim Industrial Co., Ltd.	
job No.	110180
A – APPROVED B – APPROVED WITH COMMENTS C – RETURNED FOR CORRECTION D – REJECTED N – NOT APPLICABLE (REFERENCE ONLY)	
SIGNED BY :	DATE :
DIC'S PERMISSION TO PROCEED OR REVIEW TAKEN ON VENDOR PRINTS SHALL NOT RELIEVE VENDOR FROM ITS RESPONSIBILITIES OR LIABILITIES UNDER THE PURCHASE ORDER.	

NOTE: 1. ALL DIMENSIONS SHOWN ARE IN MILLIMETERS(mm)
2. REFERENCE TO DRAWING NO: TB2-SDC.VP126-00HDE-M-M9-DRD-4140-01
3. Erector Notes
- After final adjustments are completed, hex nuts are to be tack welded.
- After adjustments are completed, U-bolts have to be tack welded to Hammer Arm & Shaft.
- After installation, all rafter hammers to be checked for freedom of movement.

[illegible]

OWNER  VIETNAM OIL AND GAS GROUP (PVN)	OWNER'S CONSULTANT FICHTNER  FV POWER PCC
EPC CONTRACTOR  PETROVIETNAM CONSTRUCTION JOINT STOCK CORPORATION (PVC)	EPC CONTRACTOR'S CONSULTANT  WorleyParsons WORLEYPARSONS
POWER ISLAND PACKAGE SUPPLIER  SOJITZ CORPORATION	DAELIM DAELIM INDUSTRIAL CO., LTD.

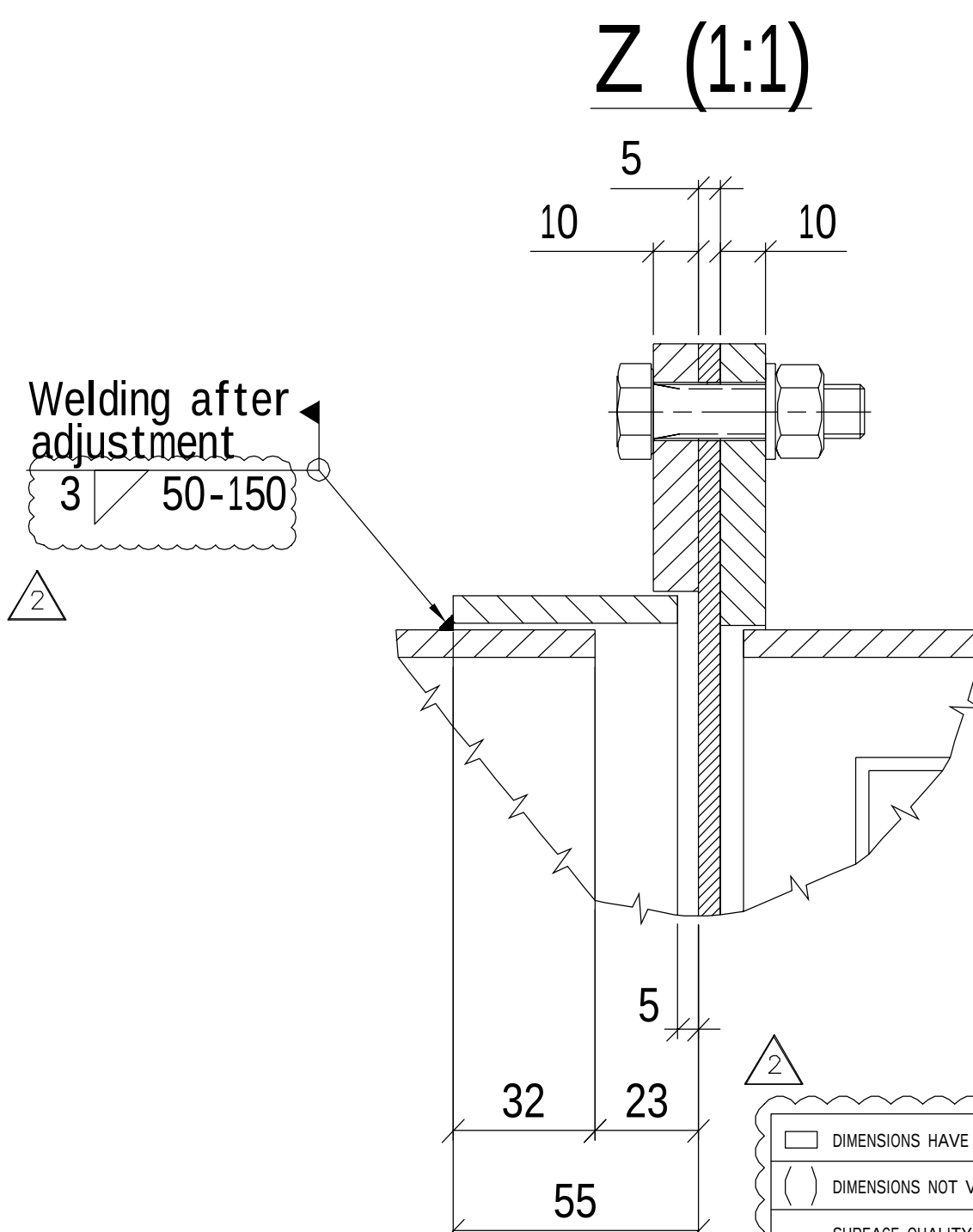
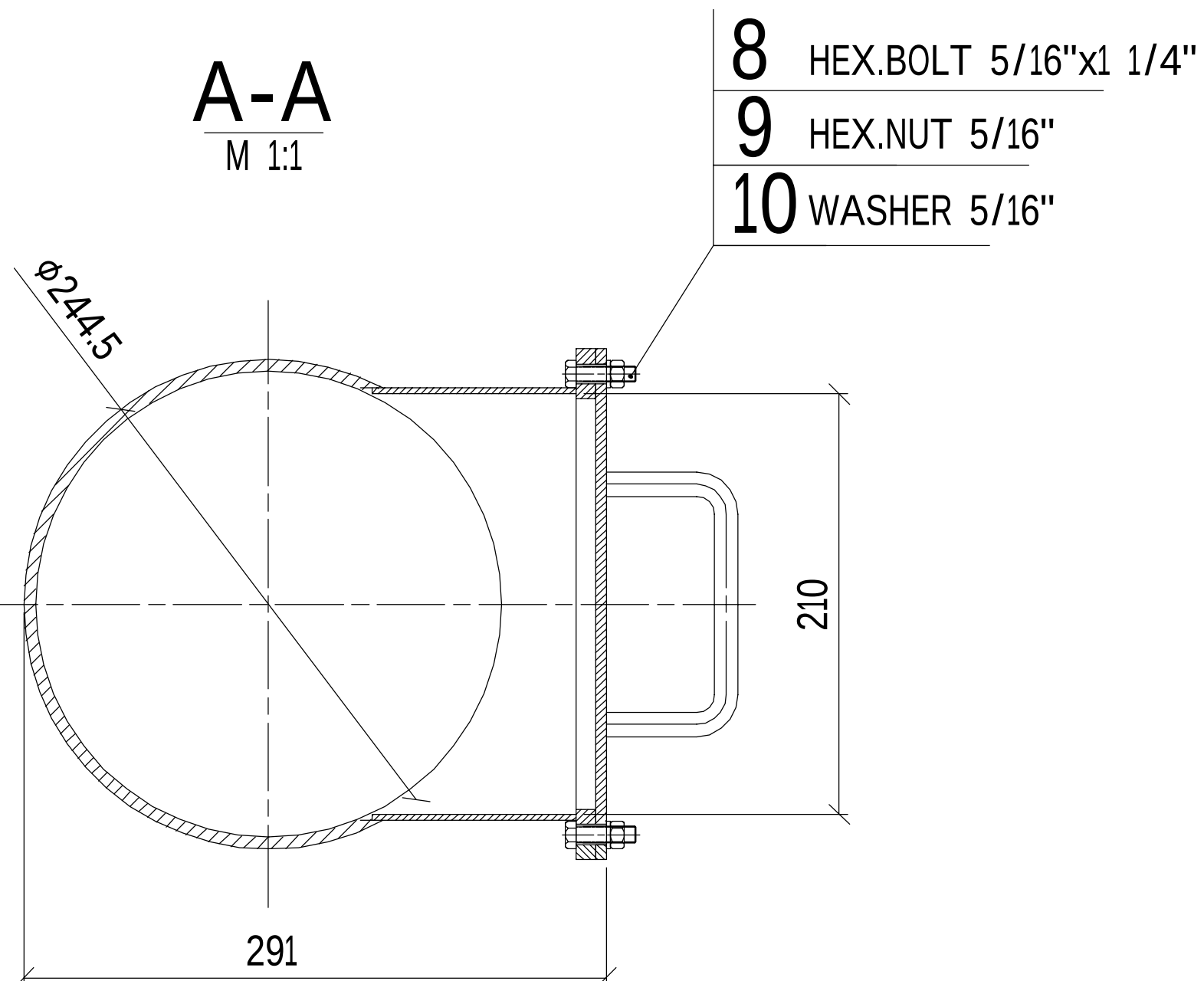
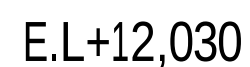
PROJECT TITLE	THAI BINH2 THERMAL POWER PLANT 2 x 600MW
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DRAWING TITLE					
CE-RAPPING for ESP, Sheet 1/2					
VENDOR NAME		FUNCTION	NAME	SIGN	DATE
 Hamon Korea Co., Ltd. Hamon Plaza, 33-2, 200il, Bongdodero Seoshae-Chu, Seoul, Korea Tel : +82-70-4367-2483 Fax : +82-2-3473-5378		DRWN	S.M LEE	이문인	16.Aug.2016
		CHKD	S.M CHO	조성록	16.Aug.2016
		APPD	B.J KIM		16.Aug.2016
		APPD	K.H YI	이영우	16.Aug.2016
DRAWING NO.		JOB NO.	SCALE	REV. NO.	
TB2-SDC.VP126-00HDE-M-M9-DRD-4140-01		111810	1/10	16.AUG. 	

10

11

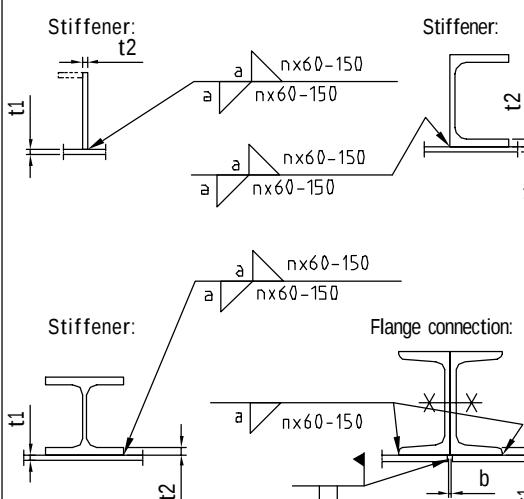
FILE NAME : 070417_1430_000-A-02-001



-  DIMENSIONS HAVE TO BE CHECKED
-  DIMENSIONS NOT VALID FOR MACHINING

SURFACE QUALITY ACC. AWS C41-77

DIMENSIONS WITHOUT TOLERANCES ACC. TO TABLE GENERAL TOLERANCES						
t _w	3	4	5	6	7	8
a	2	3	4	4	4	5
t	3	4	5	6	7	8
b	4	5	6	8	9	10



Stiffener: t1

Flange connection: t2

Dimensions: a, b, nx60-150

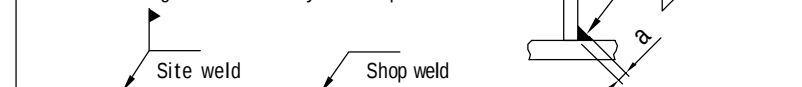
General tolerances:

- Welded plate constructions: AWS D6.1
- Prefabricated steel components: AWS D9.1
- Mechanically worked parts: AWS D9.1
- Connecting Flanges: Hole axis and distance ± 0.10 mm

Welding quality according to QA- and Q-Plan related to order

WELDING DETAILS:

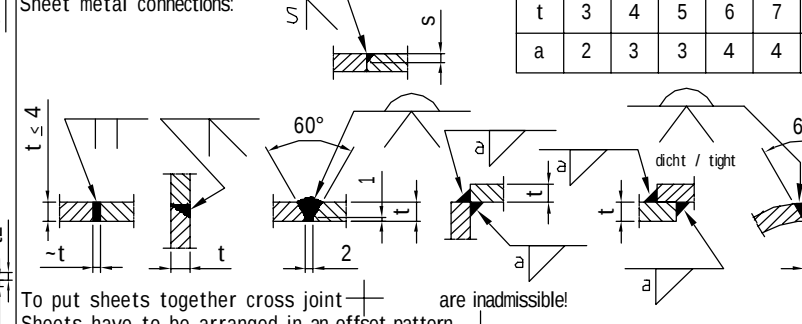
- GENERAL:** Welding coordination acc. to AWS A6.0
- Quality requirements for weldings: AWS B02.1
- Welding joint preparation acc. to AWS A6.2.4
- Welding joint preparation for site welds must be implemented in the workshop
- All screw and welded connections in contact with fuel gas must be welded gas-tight
- All fillet welds a = 3mm, if not otherwise indicated
- Welding information: Symbolic representation



Site weld

Shop weld

Sheet metal connections:



Dimensions: t, a, b

Angles: 60°, 90°

Labels: dist / ränge

To put sheets together cross joint are inadmissible!
Sheets have to be arranged in an offset pattern

BILL OF MATERIAL		TOTAL WEIGHT FOR ONE BOILER =				69.44X16 = 111.04
Sl No	DESCRIPTION	MATL.SPEC.	UNIT WEIGHT	QTY	TOTAL WEIGHT	REMARKS
1	ASM-Q01	IS 2062 E-250-Gr.Br	55.96	1	55.96	C02A137-4150-001
2	Class Fiber Cord 12x12 Black Lead, L= 1055		0.2	1	0.2	
3	Hex. Bolt: 1/2"x2"	ASTM A325	0.06	3	0.18	GALVANIZED
4	Washer 1/2"	ASTM F436	0.006	3	0.018	GALVANIZED
5	Allen Screw, M10x30L	JIS B 1176 (8.8)	0.002	2	0.04	
6	Hex.Nut M10	JIS B 1181 (8)	0.01	2	0.02	
7	Coupling	JIS S5400	12.73	1	12.73	HE-STD-410C-014
8	Hex. Bolt: 5/16"x1 1/4"	ASTM A325	0.02	8	0.16	GALVANIZED
9	Hex.Nut 5/16"	ASTM A 563	0.01	8	0.08	GALVANIZED
10	Washer 5/16"	ASTM F436	0.01	8	0.08	GALVANIZED
TOTAL WEIGHT =					69.44Kgs	

Daelim Industrial Co., Ltd.	
job No.	110180
	A – APPROVED
	B – APPROVED WITH COMMENTS
	C – RETURNED FOR CORRECTION
	D – REJECTED
	N – NOT APPLICABLE (REFERENCE ONLY)
SIGNED BY :	DATE :
DIC'S PERMISSION TO PROCEED OR REVIEW TAKEN ON VENDOR PRINTS SHALL NOT RELIEVE VENDOR FROM ITS RESPONSIBILITIES OR LIABILITIES UNDER THE PURCHASE ORDER.	

NOTE: 1. ALL DIMENSIONS SHOWN ARE IN MILLIMETERS(mm)
2. ALL FIELD BOLTS, NUTS & WASHERS ARE FOLLOWED TO ASTM-A325 TYPE-1, A536&F-436 RESPECTIVELY.
3. ALL ERECTION BOLTS, NUTS & WASHER ARE FOLLOWED TO ASTM-A307, A536&F-436 RESPECTIVELY.

[illegible]