

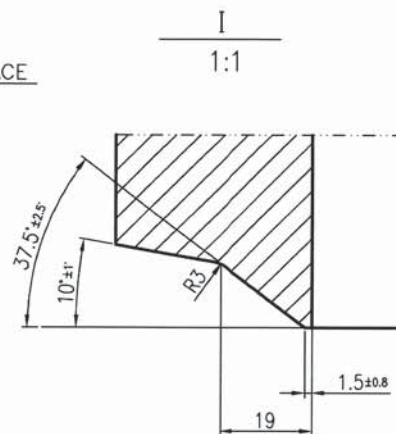
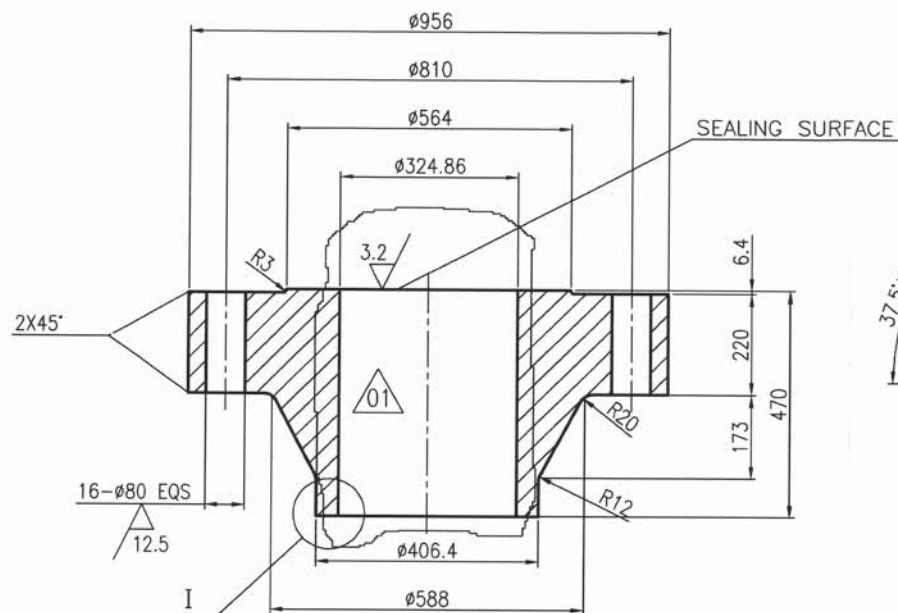
الف: مشخصات فنی و الزامات ساخت به شرح زیر است:

۱. بعد از اعلام برنده مناقصه، ITP شامل مراحل تست و بازرسی در جلسه PIM به تایید طرفین برسد.
۲. جنس بلوک اولیه مطابق با استاندارد ASTM A182 F347 و بصورت فورج شده باشد.
۳. چنانچه کالای مذکور تولید داخل باشد می بایست فرایند فورج در حضور نماینده کارفرما باشد و قبل از تراشکاری و تولید فلنج، نمونه برداری از بالک متریال برای انجام آزمون ترکیب شیمیایی، خواص مکانیکی و ریزساختاری انجام گیرد و بعد از تایید نتایج، عملیات تولید آغاز گردد.
۴. چنانچه کالای فوق از منابع خارجی تامین گردد می بایست اصل MTC ارائه شود و امکان انجام آزمون ترکیب شیمیایی، متالوگرافی سطحی و آزمون های NDT توسط آزمایشگاه معتبر همکار استاندارد وجود داشته باشد.
۵. انجام آزمون UT و PT روی کالای تولید شده الزامی است.
- ۶ - ارائه گواهینامه عملیات حرارتی آنیل انحلالی و پایدارسازی روی کالای تولید شده الزامی است.
۷. همه آزمون های فوق می بایست در آزمایشگاه معتبر همکار استاندارد و با هزینه شرکت تامین کننده انجام گیرد و گواهینامه معتبر صادر گردد.
۸. کلیه ابعاد و اندازه ها و تolerانس ها باید با توجه به نوع فلنج طبق آخرین نسخه استاندارد ASME B16.5 باشد.
۹. باتوجه به اینکه فلنج ۱۶ اینچ کلاس ۲۵۰۰ special می باشد سازنده قبل از ساخت باید نقشه را به تایید کارفرما برساند.
۱۰. ارائه MILL TEST CER الزامی می باشد.
۱۱. بسته بندی می بایست مناسب باشد تا آسیبی به کالا وارد نشود.

ب: نقشه ها

U2

OTHERS 6.3



GENERAL NOTES

1. FABRICATION, INSPECTION AND ACCEPTANCE SHALL CONFORM TO THE <<IRAN NIOEC SHAZAND ARAK REFINERY EXPANSION & UPGRADING PROJECT RCD UNIT REACTOR CUSTOMER'S REQUISITION>>.
2. THE TOLERANCES OF BOLT HOLE CIRCLE DIAMETER, CHORD LENGTH BETWEEN ADJACENT HOLES ARE LESS THAN $\pm 0.6\text{mm}$ AND THE TOLERANCES OF CHORD LENGTH BETWEEN ANY TWO HOLES ARE LESS THAN $\pm 1\text{mm}$.
3. THE FLANGE FACE SHALL BE PERPENDICULAR TO THE CENTER LINE OF THE FLANGE, THE DEVIATION SHALL NOT EXCEED $30'$.
4. THE SEALING SURFACE OF FLANGE SHALL BE PROTECTED.

REFERENCE DRAWINGS

DWG No.

R-1422 Assembly	R07301508

REV.	DATE	DESCRIPTION	PREP'D	CHK'D	APPR'D
01	21.05.08	Issued for Re-Approval	UNB	ZLH	DPL
02	12.03.08	Issued for Approval	UNB	ZLH	DPL

NATIONAL IRANIAN OIL REFINING & DISTRIBUTION COMPANY
NATIONAL IRANIAN OIL
ENGINEERING & CONSTRUCTION CO.
SHAZAND ARAK REFINERY EXPANSION
AND UPGRADING PROJECT



CONTRACTOR:



DRAWING TITLE:

R-1422
RCD Unit
1st Main Reactor A
Inlet And Outlet Mating Flange

ME Code:	2260	Mat:	RCD	
Vendor Job No:	R073015080000004	Vendor Job No:	ME-3-0-0001-1-DW-002	
Item No:	R-1422	Designation:	Equipment layout drawing	
MEC PROJ No:	2260	Revision No:	2260-R-ME-3-0-0001-1	
DOC DWG No:	2260-PO-ME-3-0-0001-1-DW-002	Rev:	A3	1:10

1. Approved (Indicate for Issued/Issued for Construction) 2. Approved as Issued for Construction (Indicate when Issued for Construction) 3. Issued for Construction 4. Issued for Construction 5. Issued for Construction 6. Issued for Construction 7. Issued for Construction 8. Issued for Construction 9. Issued for Construction 10. Issued for Construction 11. Issued for Construction 12. Issued for Construction 13. Issued for Construction 14. Issued for Construction 15. Issued for Construction 16. Issued for Construction 17. Issued for Construction 18. Issued for Construction 19. Issued for Construction 20. Issued for Construction 21. Issued for Construction 22. Issued for Construction 23. Issued for Construction 24. Issued for Construction 25. Issued for Construction 26. Issued for Construction 27. Issued for Construction 28. Issued for Construction 29. Issued for Construction 30. Issued for Construction 31. Issued for Construction 32. Issued for Construction 33. 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设计 PRE. 刘文强 08.5.19
校核 CHK. 张明 08.5.19
审核 REV. 张明 08.5.19

R-1422
RCD UNIT 1ST MAIN REACTOR A
INLET AND OUTLET MATING FLANGE
Δ 油气出入口对应法兰

中国一重
CFHI

PO.No. 2260-PO-ME-3-0-0001-1

图纸代号
DWG.No. R073015080000004

第1张 共1张 SHEET 1 OF 1

会签单位	签字	日期
UNIT	SIGN.	DATE

项 目
PROJECT
ARAK REFINERY

用 户
CLIENT
NIOEC

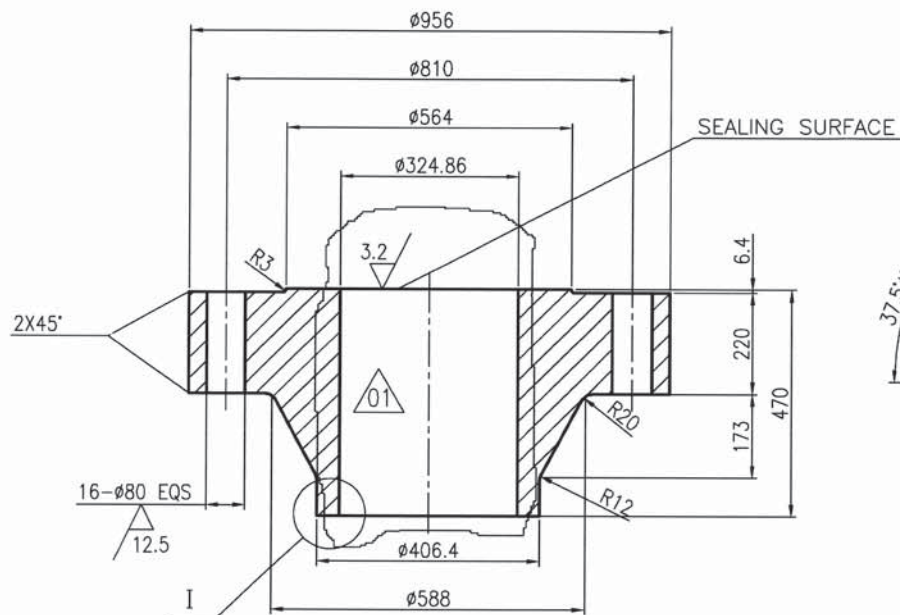
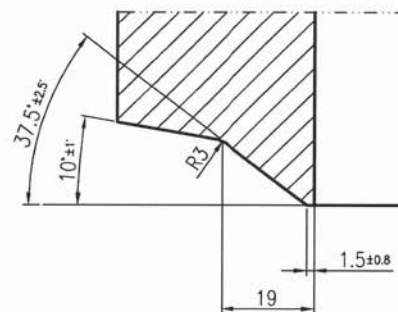
材 料
MATERIAL
SA-182-F347

重量(kg)
WEIGHT
1296

2008.11.18

U2

OTHERS 6.3

I
1:1

GENERAL NOTES

- 1.FABRICATION, INSPECTION AND ACCEPTANCE SHALL CONFORM TO THE <<IRAN NIOEC SHAZAND ARAK REFINERY EXPANSION & UPGRADING PROJECT RCD UNIT REACTOR CUSTOMER'S REQUISITION>>.
- 2.THE TOLERANCES OF BOLT HOLE CIRCLE DIAMETER, CHORD LENGTH BETWEEN ADJACENT HOLES ARE LESS THAN $\pm 0.6\text{mm}$ AND THE TOLERANCES OF CHORD LENGTH BETWEEN ANY TWO HOLES ARE LESS THAN $\pm 1\text{mm}$.
- 3.THE FLANGE FACE SHALL BE PERPENDICULAR TO THE CENTER LINE OF THE FLANGE, THE DEVIATION SHALL NOT EXCEED $30'$.
- 4.THE SEALING SURFACE OF FLANGE SHALL BE PROTECTED.

REFERENCE DRAWINGS	DWG No.
R-1423 Assembly	R07301608

REV.	DATE	DESCRIPTION	PREP'D	CHK'D	APPR'D
01	21.05.08	Issued for Re-Approval		LMH	ZLH
02	12.03.08	Issued for Approval		LMH	ZLH

NATIONAL IRANIAN OIL REFINING & DISTRIBUTION COMPANY
NATIONAL IRANIAN OIL
ENGINEERING & CONSTRUCTION CO.
SHAZAND ARAK REFINERY EXPANSION
AND UPGRADING PROJECT

CONTRACTOR:
SAZEH CONSULTANTS
OIL Design & Construction Co.
中国石化工程公司

DRAWING TITLE:
R-1423
RCD Unit
2nd Main Reactor A
Inlet And Outlet Mating Flange

DEC Code: 2260 Unit: RCD
Vendor Job No: R073016080000004 Vendor Job No: ME-3-0-0001-1-DW-002
Rev No: R-1423 Designation: Equipment Isometric Detail Drawing

NIOEC Prod No: 2260 Requisition No: 2260-IR-ME-3-0-0001-1

NIOEC DWG No: 2260-PO-ME-3-0-0001-1-RW-4112-1

Comments:
1. Issued for Re-Approval
2. Issued for Approval
3. Issued for Approval
4. Issued for Approval

Scale: 1:1

设计 PRE: 刘立强 08.5.19
校核 CHK: 张明 08.5.19
审核 REV: 张明 08.5.19

R-1423
RCD UNIT 2ND MAIN REACTOR A
INLET AND OUTLET MATING FLANGE
△ 油气出入口对应法兰



PO. No. 2260-PO-ME-3-0-0001-1

图纸代号
DWG. No. R073016080000004

第1张 共1张 SHEET 1 OF 1

项 目	用 户	材 料	重 量 (Kg)
PROJECT	CLIENT	MATERIAL	WEIGHT
会 签 单 位	签 字	日 期	
UNIT	SIGN.	DATE	

项 目 用 户
PROJECT CLIENT
ARAK REFINERY NIOEC

材 料 重 量 (Kg)
MATERIAL WEIGHT
SA-182-F347 1296