

Please add cover pages for this document.



-Please add a column for description.  
 -Please add columns for mention the material of the two pieces which are joined to each other.  
 -Please follow the attach sample for NDT before PWHT (RT,UT & PT).  
 -Please add tube to tube sheet joint.  
**(Attach file can be a sample. please use it and ignore the columns and rows which have been crossed)**



Project Document Number:

EI027-DMF-VD-QC-PRO-023-R01

REV. 01

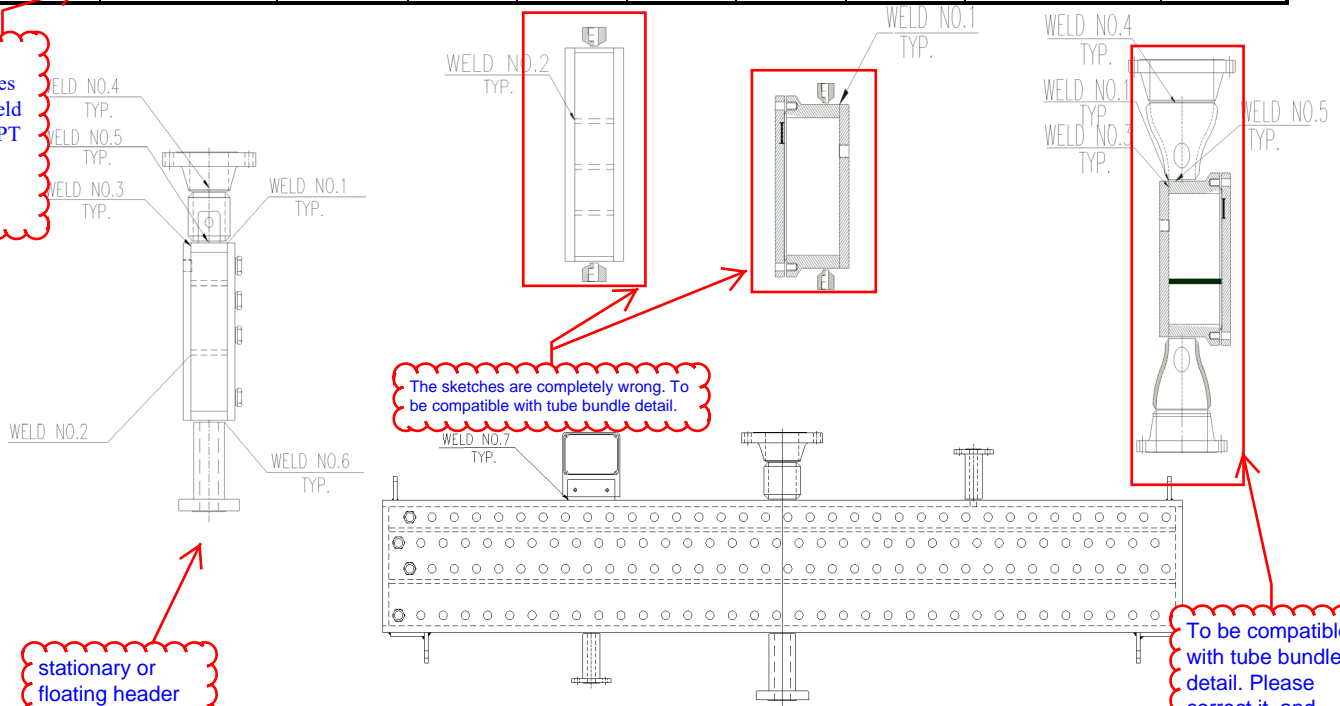
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Partition plate to tube sheet and plug sheet (weld No.2) to be 100% UT

**NDT TABLE**

| WELD NO. | WPS No.      | PQR No. | RT before PWHT (Note3) |       | UT BEFORE PWHT |       | Visual Check | Hardness After P.W.H.T | PT AFTER PWHT |
|----------|--------------|---------|------------------------|-------|----------------|-------|--------------|------------------------|---------------|
|          |              |         | Long.                  | Circ. | Long.          | Circ. |              |                        |               |
| 1        | DS11-W010/01 | P052    | -                      | -     | Note 2         | -     | 100%         | 225 (HB) MAX.          | 100%          |
| 2        | DS11-W010/02 |         | -                      | -     | -              | -     | 100%         | 225 (HB) MAX.          | -             |
| 3        | DS11-W011/01 | P052    | -                      | -     | 100%           | -     | 100%         | 225 (HB) MAX.          | 100%          |
| 4        | DS11-W012/01 |         | -                      | 100%  | -              | -     | 100%         | 225 (HB) MAX.          | 100%          |
| 5        | DS11-W012/02 |         | -                      | -     | 100%           | -     | 100%         | 224 (HB) MAX.          | 100%          |
| 6        | DS11-W012/03 |         | -                      | -     | -              | 100%  | 100%         | 225 (HB) MAX.          | 100%          |
| 7        | DS11-W014/01 |         | -                      | -     | -              | -     | 100%         | 225 (HB) MAX.          | 100%          |

Name plate bracket and other accessories to header boxes (weld NO.7) to be 100% PT before PWHT



The sketches are completely wrong. To be compatible with tube bundle detail.

stationary or floating header to be specified

To be compatible with tube bundle detail. Please correct it. and specify the header (stationary or floating)

**NOTES:**

- 1) Visual check should be applied For Internal, External, Pressure Parts, NON Pressure Parts And any Applied Weldings.
- 2) 100% of the length should be ultrasonic tested .
- 3) Regarding Header box geometry , RT examination can be used only for flange to nozzle weld .
- 4) Spot radiographic or ultrasonic examinations shall include each start and stop of weld made by the automatic submerged arc-welding process and repaired areas of burn-through.

Please add a sketch for tube to tube sheet joint.

CC  
ENC

Weld maps are not compatible with tube bundle detail. please check all of them.

Damafin  
technology

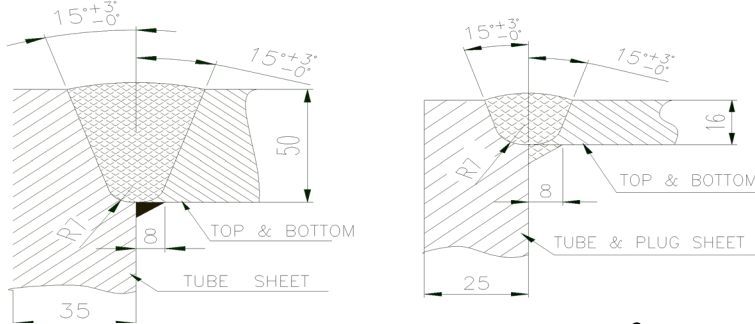
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Project Document Number:

WELD MAP

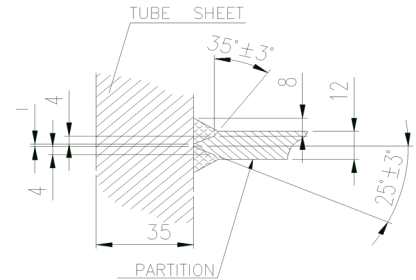
1

TOP & BOTTOM PLATE TO TUBE SHEET & PLUG SHEET



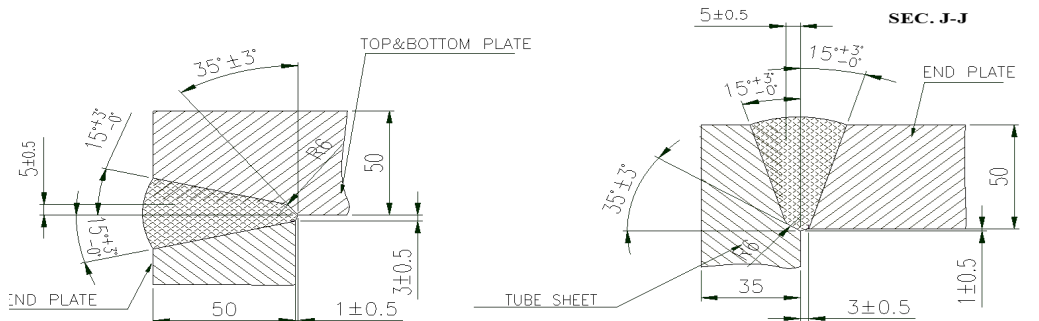
2

PARTITION OR STIFFENER TO TUBE SHEET & PLUG SHEET

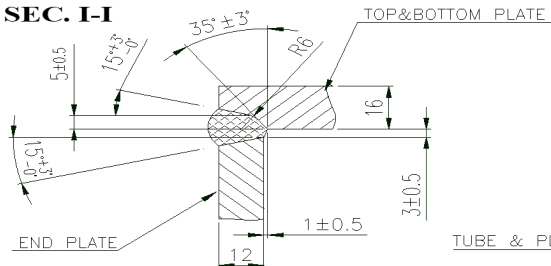


3

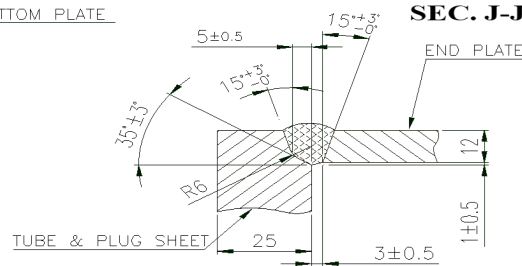
END PLATE TO TUBE SHEET AND PLUG SHEET & TOP AND BOTTOM PLATE & PARTITION OR STIFFENER



SEC. I-I

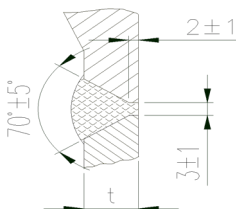


SEC. J-J



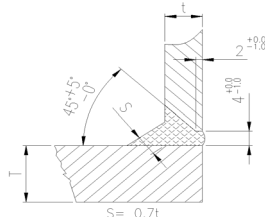
4

OBROUND/ PIPE NOZZLE TO FLANGE



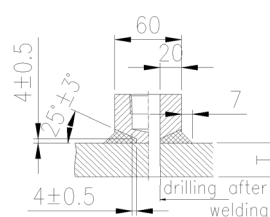
5

PIPE & VENT OR DRAIN FLANGE TO TOP & BOTTOM PLATE



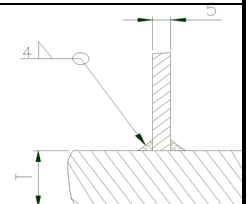
6

COUPLING TO TOP & BOTTOM PLATE



7

NAME PLATE BRACKET AND OTHER ACCESSORIES TO HEADER BOXES



to be removed and compatible with final tube bundle detail. There is no coupling on header.