



**SITE WELDS DATA
(TURBINE INTEGRAL PIPING)**

**PROJECT: 2x150 MW
STG, SIPL Shirpur**

**Single Cylinder Reheat
Turbine**

S.no	Service medium	Parameters		Pipe			No. of weld joints	X – ray (%)	I B R Yes / No
		Pr. (Kg / cm ²)	Temp (°C)	Size OD x Thk. (mm)	Length (m)	Material			

A. TURBINE WATER DRAIN PIPING (PGMA: 13126)

1.	Steam	Full vacuum	120	610 x 12.7	15	A106 Gr B	4	10	No
2.	Condensate	Full vacuum	120	273.1 x 12.7	20	A335 P11	20	-	No
3.	Steam	126	537	33.4 x 6.35	40	A335 P22	20	100	Yes
4.		126	537	48.3 x 7.14	4	A335 P22	4	100	Yes
5.		32	538	33.4 x 4.55	80	A335 P22	40	20	Yes
6.		32	538	48.3 x 7.14	4	A335 P22	4	100	Yes
7.		5.7	290	33.4 x 4.55	20	A106 Gr B	10	10	Yes
8.		5.7	290	48.3 x 5.08	2	A106 Gr B	10	10	Yes
9.		1.0	303	33.4 x 4.55	20	A106 Gr B	10	10	Yes
10.		126	537	60.3 x 11.0	40	A335 P22	20	100	Yes
11.		126	537	76.1 x 12.5	4	A335 P22	4	100	Yes
12.		32	538	48.3 x 5.08	40	A335 P22	20	20	Yes
13.		32	538	76.1 x 12.5	4	A335 P22	4	20	Yes
14.		15	404	33.4 x 3.38	20	A335 P11	10	10	Yes
15.		15	404	48.3 x 5.08	2	A335 P11	2	10	Yes
16.		2.4	205	33.4 x 4.55	20	A106 Gr B	10	10	Yes
17.		2.4	205	48.3 x 5.08	2	A106 Gr B	2	10	Yes
18.		35	450	60.3 x 11.0	20	A335 P22	10	20	Yes
19.		35	450	76.1 x 12.5	2	A335 P22	2	20	Yes

B. CONDENSATE SPRAY PIPING (PGMA: 13109)

1.	Condensate	18	60	219.1 x 6.35	60	A106 Gr B	80	5	No
2.		18	60	114.3 x 6.02	2	A106 Gr B	16	5	No
3.		18	60	168.3 x 7.11	30	A106 Gr B	60	5	No
4.		1.0	60	114.3 x 6.02	40	A106 Gr B	60	-	No
5.		3	60	33.4 x 4.55	100	A106 Gr B	100	-	No

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				Page 1 of 3	00



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C. SEAL STEAM PIPING (PGMA: 13105)									
1.	Steam	11	320	60.3x5.54	36	A106 Gr B	30	10	Yes
2.		1.1	331	48.3 x 5.08	1	A106 Gr B	5	10	No
3.		1.1	331	88.9 x 5.49	16	A106 Gr B	40	-	No
4.		1.1	331	114.3 x 6.02	90	A106 Gr B	100	-	No
5.		1.1	331	168.3 x 7.11	110	A106 Gr B	90	-	No
6.		1.1	331	219.1 x 6.35	80	A106 Gr B	10	-	No
7.		126	537	33.4 x 4.55	80	A335 P22	60	100	Yes
8.		126	537	60.3 x 3.91	50	A335 P22	40	100	Yes
9.		126	537	21.6 x 3.7	60	A335 P22	30	100	Yes
10.		126	537	26.7 x 3.91	100	A335 P22	50	100	Yes
11.									
12.									
13.									
D. LUBE OIL PIPING (PGMA: 13111)									
1.	Oil	atm	70	323.9 x 6.35	20	A106 Gr B	20	-	No
2.		atm	70	219.1 x 6.35	15	A106 Gr B	10	-	No
3.		atm	70	273.1x6.35	10	A106 Gr B	5	-	No
4.		10	70	168.3x7.11	60	A106 Gr B	130	10	No
5.		10	70	114.3x6.05	50	A106 Gr B	120	10	No
6.		10	70	88.9 x 5.49	30	A106 Gr B	10	-	No
7.		10	70	60.3 x 3.91	30	A106 Gr B	10	10	No
8.		10	70	48. 3x 5.08	70	A106 Gr B	20	10	No
9.		10	70	33.4 x 4.55	80	A106 Gr B	25	10	No
10.		10	70	114.3x3.05	45	A312 TP321	40	10	No
11.		10	70	88.9 x 3.05	20	A312 TP321	10	10	No

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				Page 2 of 3	00



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12.		10	70	60.3 x 2.8	35	A312 TP321	20	10	No
13.		10	70	48.3 x 2.7	60	A312 TP321	15	10	No
14.		10	70	33.4 x 4.5	40	A312 TP321	15	10	No

E. CONTROL OIL PIPING (PGMA: 13113)

1.	Oil	1.0	70	88.9 x 5.43	15	A106 Gr B	300	-	No
2.		1.0	70	76.1 x 3.2	200	A106 Gr B	300	10	No
3.		1.0	70	33.4 x 3.4	200	A312 TP321	50	10	No
4.		160	70	26.7 x 3.8	200	A312 TP321	150	100	No

NOTES: -

- 1) THIS INCLUDES SITE WELDS FOR TURBINE INTEGRAL PIPING ONLY.
- 2) THIS SITE WELDS ARE APPROXIMATE. TO BE USED FOR TENDERING PURPOSE ONLY.
- 3) VALID FOR SINGLE WORK-ORDER ONLY.

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				Page 3 of 3	00