

Scope of work for Sec.II (Middle sections 2,3, and 4 as applicable)

- Down comers and equalizer nozzles of Storage tank shall exactly match with corresponding nozzles on Heater. Alignment of nozzles to be checked in presence of BHEL QC / TPIA with a fixture prepared by vendor for marking and trail assembly checking, before closing these nozzles with end covers
- Trial assembly of Storage tank sections (Sec-I to II, Sec-II to III as applicable) shall be carried out and match mark on both assemblies in presence of BHEL QC / TPIA (If Storage tank in multiple sections)
- Heat Treatment for storage tank

After fabrication of storage tank (without blind flanges & stud with two nuts) is to be stress relieved as per plant Std.HY0640763 Rev.03

HT cycle for storage tank. sec II (if applicable)

stress relieving temp : 600 - 650, deg.C
Rate of heating above 300 deg.C : 135°C/hr
soaking time :120 mins
Rate of cooling upto 400deg.C:170°C/hr

(Soaking, rate of Heating / cooling Subjected to change in line with code requirements)

- Painting scheme
 - a) Inside the shell: Steam washable temporary rust preventive as per Std:AA55151
 - b) Outside the Shell: One coat of zinc silicate primer and Two Coats of Heat resistant Aluminium paint as per Std: AA56134

Note:- Qualified painters shall only to be engaged on the job.