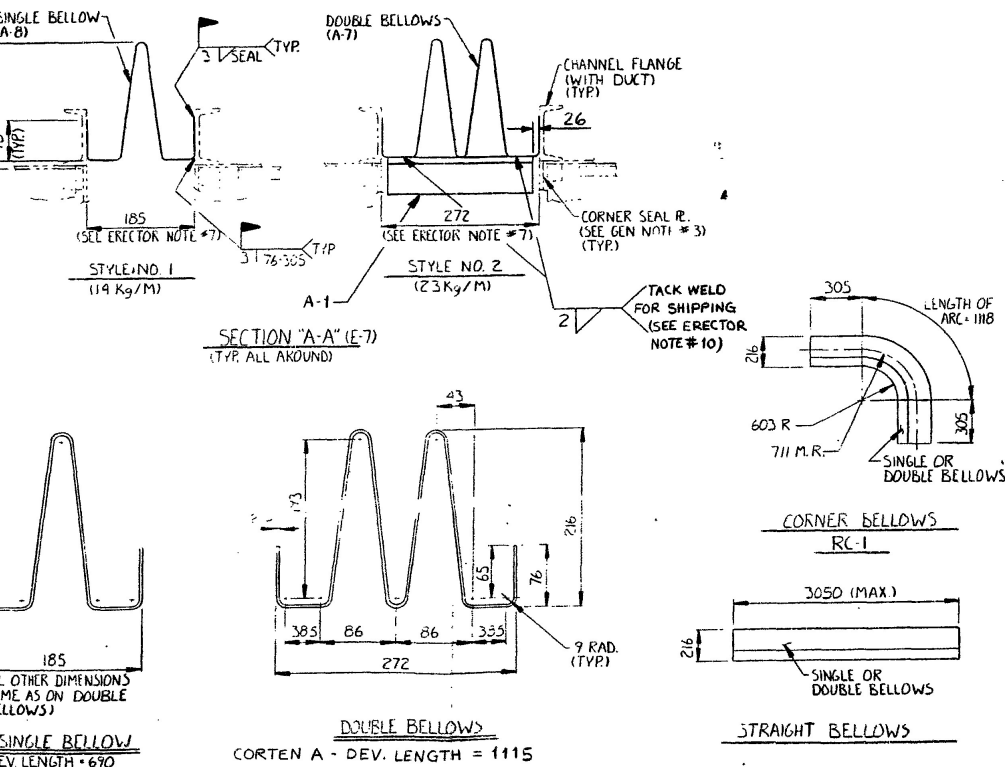
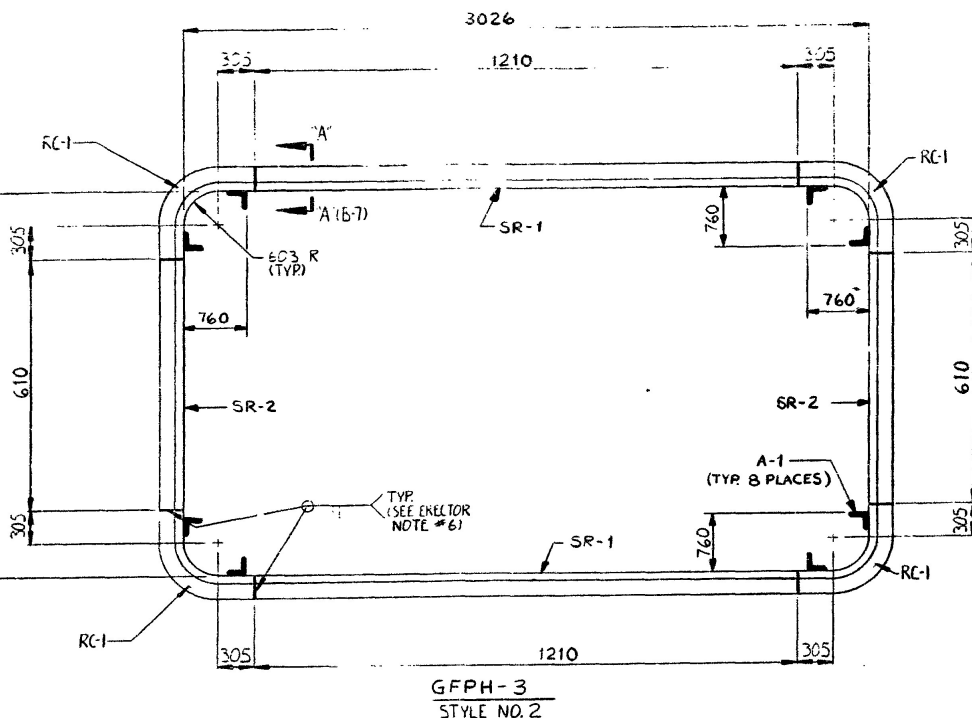




LINE NO.	ASSY NO.	PART NO.	UNIT	REQ'D CONT.	DESCRIPTION	[ONE] UNIT IN		ORD. NO.
						WIDTH MM	LENGTH MM	
1	6FPH	3	2		FULL SIZE STALE NO 2			
2					EXP. JT.			
3					(CONSISTING OF:			
4		SR-1	4		2 5MM STRAIGHT			
5					BEU	1115	1210	
6		NI-1	8		2 5MMH. BELL	1115	1720	
7					2 FLDWS			
8		SR-2	4		2.5 MM Ø STRAIGHT	1115	610	
9					BELLOWS			
10		A-1	8		2 50 X 50 X 5	—	220	
11					SHIPPING ANGLE			
12								
13								
14								
15								
16								
17								
18								
19								
20								
21								
22								
23								
24								
25								
26								
27								
28								
29								
30								
31								

* CORTEN A - MEETING SPEC. A-242 TYPE 1

FRECTION NOTES

1. LIFTING OF STRAIGHT SECTIONS OF EXPANSION JOINT MUST BE DONE BY PICKING UP THE SECTION AT QUARTER POINTS
2. IF EXPANSION JOINTS ARE HANDLED IN UPRIGHT POSITION (ONE SIDE SITTING ON GROOVES) THEY MUST BE SEEKED AGAINST SIDESWAY TO PREVENT CONJUGS FROM GETTING "OUT OF SQUARE".
3. IF EXPANSION JOINTS ARE STACKED ON THEIR FLANGES, WOODEN SPACERS MUST BE USED.
4. EXPANSION JOINT FLANGE MUST BE PROPERLY AND ADEQUATELY PROTECTED AGAINST DAMAGE DURING HANDLING.
5. ALL WELDS TO BE SHOP ON FIELD, AS REQ'D.
6. QUALITY OF THESE WELDS MUST BE MAINTAINED. GALLOW, MAY BE WELDED FROM ONE SIDE ONLY; IF WELDING IS REQ'D. ON TWO SIDES, A MINIMUM OF 25 MM OF OVERLAP IS REQ'D. WELDS SHALL BE FULL PENETRATION (AS WELL AS POSSIBLE) FROM ONE SIDE. MAINTAIN CLEARANCE AS SHOWN IN DET. (P. 4)
7. MOST JOINTS ARE COLLAPSING IN SEVERAL DIRECTIONS. THEREFORE, FLANGES ARE NOT PARALLEL AND THE DUCT OPENING BETWEEN FLANGES (OR "BREECH") IS VARIABLE. COLD SPRINGING IS ACCOMPLISHED BY APPROPRIATE COLD PRE-SETTING OF DUCT. ERECTION TO FOLLOW INSTRUCTIONS GIVEN ON DUCT ARRANGEMENT DRAWING.

GENERAL NOTES:

1. WEIGHTS IN KG/M GIVEN FOR EACH STYLE DO NOT CHANNELS. THESE CHANNELS ARE FURNISHED WITH THE
2. THESE TOLERANCES MUST BE MAINTAINED IN THE VICE ANY BUTT WELD THAT IS WITHIN APPROX. 76 MM EITH
3. CORNER SEALER IS TO BE SUPPLIED WITH DUCT. INSTALL
4. FABRICATION OF EXP JTS NOT BY C.E.
5. ALL DIMENSIONS ARE IN MILLIMETERS.

SHOP NOTES:

1. SURFACE IMPERFECTIONS:
- a) NO SCRIBE MARKS OR MARKS, SCRATCHES OR OTHER IMPERFECTIONS RUNNING IN THE LONGITUDINAL DIRECTION OF THE CONE ARE PERMITTED IF SUCH MARKS DO OCCUR, THEY MUST BE IN THE BASE MATERIAL, WHEN BLENDING MARKS, THE THICKNESS SHALL NOT BE LESS THAN 2 MM.
 - b) WAVES (FLUTTERS) FORMED DUE TO BENDING OF CORNER FREQUENCIES NOT LESS THAN 25 MM AND THE AMPLITUDE TO EXCEED 5 MM.
 - c) NO WAVES (FLUTTER) BEYOND THE NEUTRAL RADIUS OF BENT CORNER PIECES ARE PERMITTED.
2. WELD JOINTS: E-43 ELECTRODE
- DRAWING R

3 PAINT PER REF DWG. NO. 2. ITEM S.O.

CONTRACT/ORDER NO. : OPJ 1159
ESCOM DRG NO. : 064/3206

ECSOM 1987-10-13 EVKOM		CONT. NO 01882
		CONT. NO 01782
		CONT. NO. 01682
		CONT. NO. 15681-1
		15581
		15481

EXPANSION JOINT-GAS DUCT FROM PA.TUBULAR
ELECTRICITY SUPPLY COMMISSION
KENDAL POWER STATION-UNITS NO. 1 THRU 4

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COMBUSTION ENGINEERING, INC.

SCALE: NONE
DRAWN BY: G. ROCHE
CHECKED BY: D. SZCZEWYK
APPROVED BY: *H. T. Smith*
CWP. CODE: 52-25-33
DRAWING NO. 15481-28

REFERENCE DRAWINGS

1. DUCT CONSTRUCTION DETAILS _____ 15481-1E2500
2. SHOP PAINT DRAWING _____ 15481-1E0019
3. GAS DUCT FROM P.A. TUBULAR A/HTR W/HOPPERS _____ 15481-1E254

MAX. ALLOWABLE
MISALIGNMENT

— 1. MAX

MAX. WELD
REINFORCEMENT

DETAIL "1"

(SEE GEN. NOTE #2)

DRAWING R
TECHENING

TERENTIN

J 11595

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0 21862 U

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0. 15481 - 11

15581
15481

A. TUBULAR

HOPPER
I. FLANK

TARZU

KHE
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-25-336

UD285

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