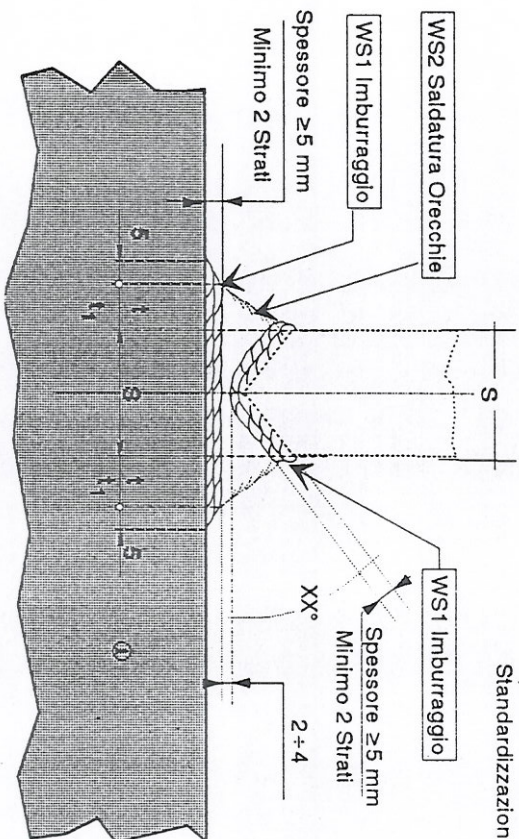


Orecchie di Sollevamento

I valori t_1 , t_2 , XX° sono uguali a quelli riportati nella tabella di Standardizzazione



NOTE: Soak at 260°C ± 20°-0° per 1h ogni 25.4 mm Max 4h

ANSALDO
Energia

Stabilimento
MILANO

TABELLA DI SALDATURA
WELDING TABLE

WT. 00.01

Pag. 2 di 2

PROGETTO Project: **KFMKO**

SIGLA della SALD. / Designation of weld

COMMESSA Job:

DISSEGNO Drawing No.:

Allegati Temporanei

CIENTE / Customer:

F1 0057 VN

MATERIALI BASE / Base Material

POS: SIGLA/Designation

DNI / AWS / ASTM / UNI / BS

1 SA 508 Cl.3 a

2

3

PREPARAZIONE LEMBI DI SALDATURA:

Preparation of welding edges:

PREPARAZ. INDICE / Preparation of root:

TRATT. TERM. DOPO SALDATURA

Post weld heat treatment

PCF : n° Attacchi temporanei

CONTROLLI / Examination:

ESSICCAZIONE / Drying

BLATTROCK/Entstos

MANTENIMENTO / Maintenance

RUSSO / Flux

MANTENIMENTO / Maintenance

PARAMETRI DI SALDATURA / Welding parameters

Capitolo

DC

AC

AMPS

VOLTS

VEL. SALD

PRENSC.

CORO STRET.

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Welding Procedure Specification

ANSALDO Energia S.p.A. Specifica Procedimento di Saldatura ASME Code Sect. IX & III NB

Pag.: 1 di 2

PQR No. 1727

WPS No. 269.04

No. PQR di Supporto

Date

21/04/98

Revision No.

00

Welding Process(es)

SMAW

Type

Manual

Procedimento di Saldatura

Elettrodo Fissato

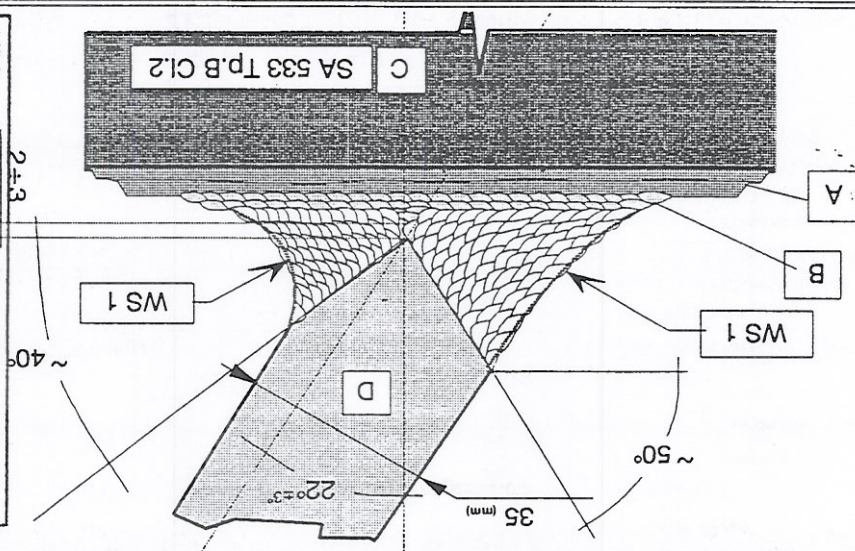
Manuale

JOINTS (QW-402)

Joint Designe / Tipo di Giunto:

W.Process(es): SMAW	Backing: YES	Backing Mat.: Weld Metal	Retainers: NO
Sostegno Bagno S.			

A: Manual or Automatic
B: Stainless Steel Cladding
C: Manual Buttering Type E NiCrFe-3



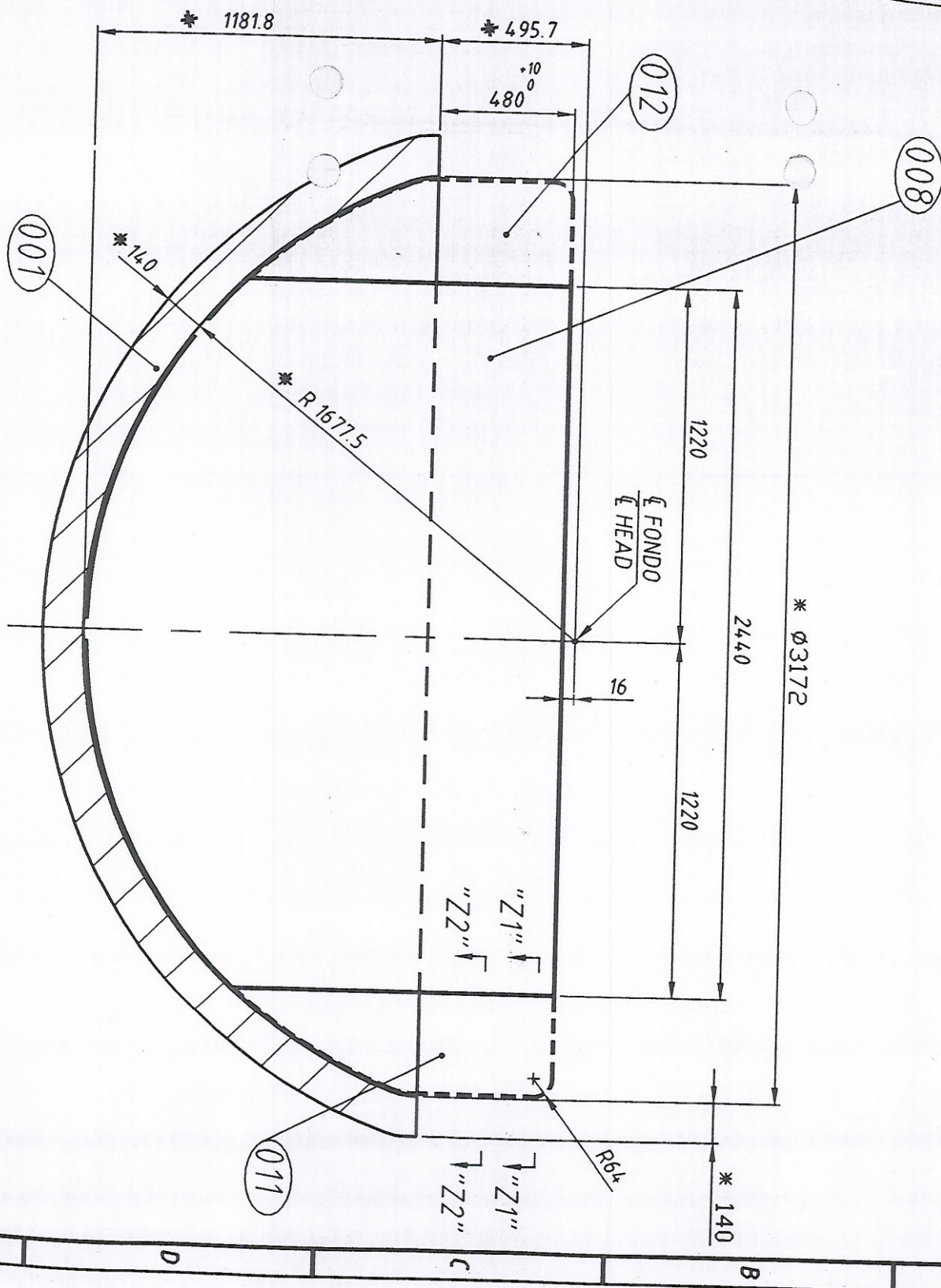
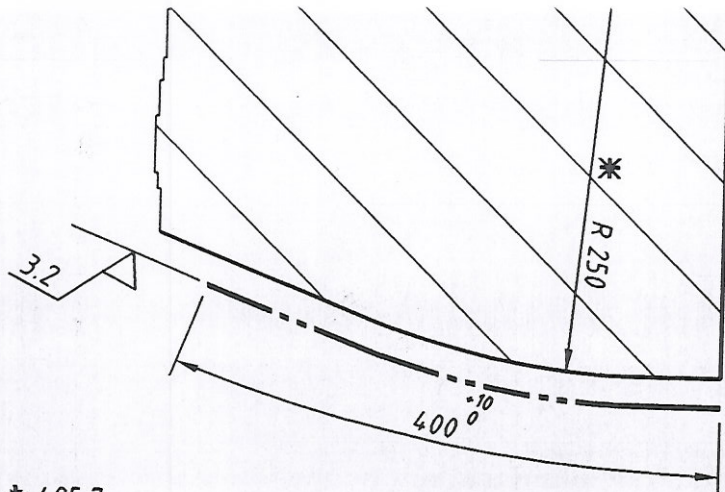
BASE METALS (QW-403)

D P-No. 43 Gr-No. # To B #
OR:
Specification, Type, Grade A Specifica, Tipo, Grado D
SB 169 Alloy 690
Buttering type E NiCrFe-3

Thickness Range	Limiti di Spessore	Material Base	Deposito saldatura	Limiti D ~ Tubo	MAX spessore per ogni passata
Base Metal	Groove Cianhino	Groove Cianhino	Groove Cianhino	Groove Cianhino	Groove Cianhino
1. Deposit Weld Metal	4.76 ÷ 70 (mm.)	MAX 70	MAX 70	MAX 70	MAX 70
Pipe D ~ Range	4.76 ÷ 70 (mm.)	MAX 70	MAX 70	MAX 70	MAX 70
Max (t): for one pass	4.76 ÷ 70 (mm.)	MAX 70	MAX 70	MAX 70	MAX 70
Uner/Aitro	4.76 ÷ 70 (mm.)	MAX 70	MAX 70	MAX 70	MAX 70

FILLER METAL (QW-404)

Welding Process	Procedimento di saldatura	SMAW	Note
4 F-No.	F-No.	F-No. 43	
5 A-No.	A-No.	UNS Number W86182	
6 D ~ of Filler Metal	D ~ of del Mat.d'Apporto	3.25 ; 4.0	
7 D ~ of Filler Metal > 1/4"	D ~ of del Mat.d'Apporto > 6mm.	< 6 mm	
12 Specification (SFA)	Specifica SFA (No.)	SFA 5.11	
30 \$ t beyond range	\$ t superiore ai limiti qualificati	See Above	
33 \$ AWS Class.	\$ AWS Classificazione	SFA 5.11 E NiCrFe-3	
Legend: \$ Change; t thickness w.metal; T thickness B.Metal; > Greater than; < Less than; + Addition; - Deletion			
Pag 1 di 2	Prepared	Verified	Approval
Signature	Ciriale	KWU fluids	AMMO
Date	11/05/98	11/05/98	11/05/98



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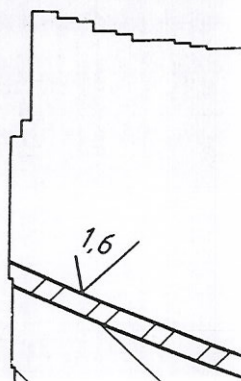
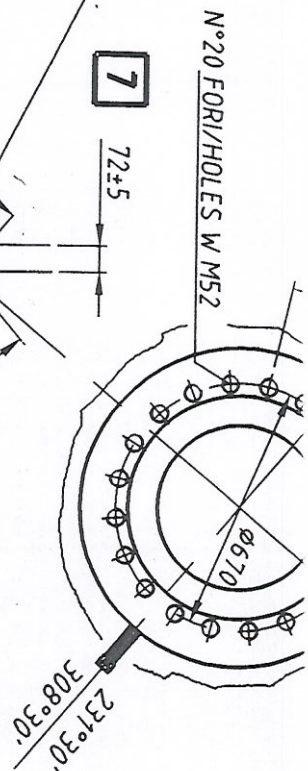
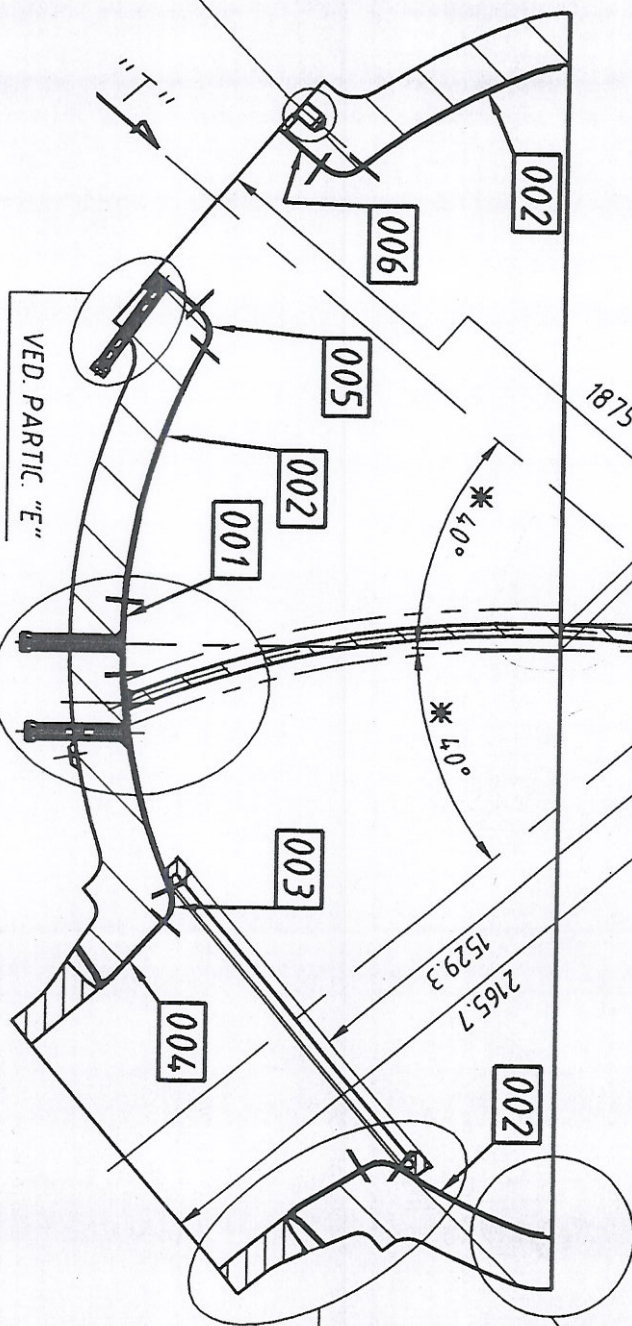
SEZ. "M-N-0-P-Q"
SECT. "M-N-0-P-Q"

SEE DETAIL "X"

VED. PARTIC. "X"

VED. PARTIC. "E"
SEE DETAIL "E"

VED. PARTIC. "D"
SEE DETAIL "D"



NPP
KRSKO
Revised
NEK Letter
Consortium Framatome-Siemens
Certified for Construction
18.11.98
dd.

ANSALDO

ANSALDO ENERGIA S.P.A.
STABILIMENTO MILANO

INGEGNERIA MILANO
MILAN ENGINEERING

IMPIANTO
PLANT

TITOLO
KRSKO REPLACEMENT STEAM GENERATORS

TITLE

DESCRIZIONE
FONDO PRIMARIO - DETTAGLI
DESCRIPTION
CHANNEL HEAD - DETAILS

COMM./JOB
F1 0057VN

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TITOLO		KRSKO REPLACEMENT STEAM GENERATORS								COMM./JOB F1 0057VN			
DESCRIZIONE		FONDO PRIMARIO - DETTAGLI											
DESCRIPTION		CHANNEL HEAD - DETAILS											
FIRME/SIGN.		DATE		FIRME/SIGN.		DATE		DISEGNO N° DRAWING N°					
DESIGN./DTM.		02/10/97		TEFA		03/10/97				0 1 2 3			
VENARUCCI				MULFARI						4 5 6 7			
CONTR./CHKD.		03/10/97		INSA		03/10/97							
BALDELLI				CIRAUOLO									
COSP		03/10/97		COOP		03/10/97							
Ing.GIANQUINTO				COLLEONI									
Ing.		03/10/97		AMMO		03/10/97							
GIANQUINTO				INTELSANO									
GIANQUINTO		03/10/97				03/10/97							
								Scala Scale 1:5					
								DIS.PREC./REF. JOB.		FOGLIO N SHEET N			
										1 di 1			

DWG10-00-1

Questo disegno e' vincolato a norma di legge
All rights of this drawing are reserved