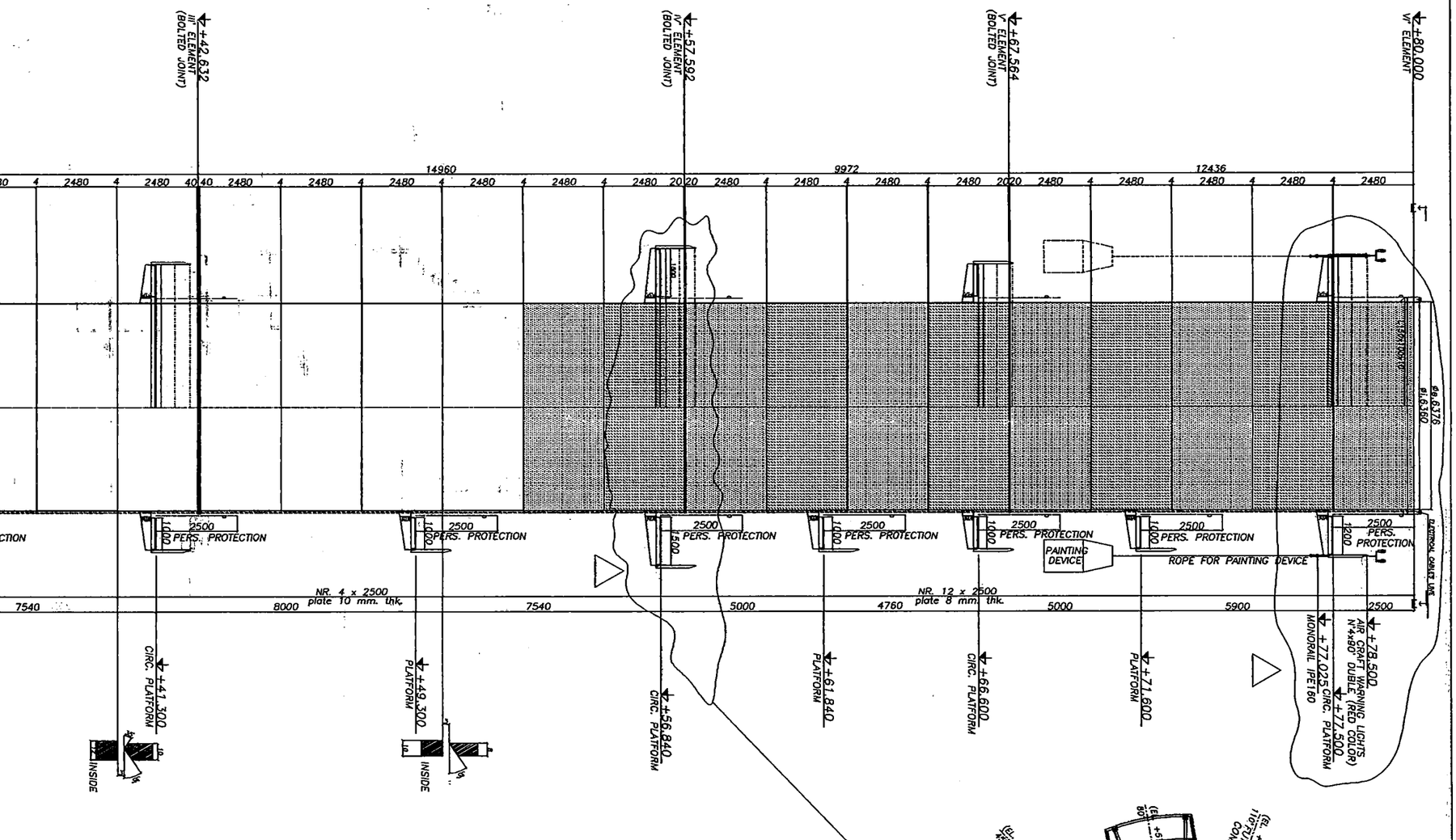

GENERAL NOTES:

1. ALL SHELL MATERIAL FE430B, STRUCTURAL FE430B.
2. FABRICATION IS IN ACCORDANCE WITH ITALIAN CODE.
3. ALL EXTERIOR WELDS SHOULD BE SEAL WELDS, SKIP WELDING OF STIFFENERS NOT ALLOWED.
4. ALL LONGITUDINAL AND CIRCUMFERENTIAL JOINTS SHALL BE FULL PENETRATION BUTT WELDS: NO UNDERCUTS ARE PERMITTED.
5. LONGITUDINAL SEAM WELDS TO BE STAGGERED A MINIMUM OF ONE QUARTER OF THE STACK CIRCUMFERENCE BETWEEN ANY TWO CYLINDRICAL SEGMENTS.
6. MAXIMUM DEVIATON FROM A STRAIGHT EDGE APPLIED TO THE STACK SHALL NOT EXCEED 3 IN ANY 3048.
7. STACK SHALL NOT BE OUT OF PLUMB MORE THAN 19 IN 15240.
8. OUT OF ROUNDNESS SHALL BE SUCH THAT THE DIFFERENCE BETWEEN MAX. AND MIN. DIAMETERS AT ANY CROSS-SECTION SHALL NOT EXCEED 1% OF THE NOMINAL DIAMETER FOR THAT SECTION, EXCEPT FOR BREECHING OPENING WHERE THE DIFFERENCE SHALL NOT EXCEED 2%.
9. MISALIGNMENT BETWEEN PLATES AND ANY JOINT SHALL NOT EXCEED 25% OF THE NOMIMAL PLATE THICKNESS OF THE THINNER PLATE, OR 3 WHICHEVER IS SMALLER.
10. THE LOCALIZED DEVIATION OF THE SHELL CONTOUR AT A VERTICAL JOINT FROM A TRUE CIRCLE SHALL NOT EXCEED 6 MAX. DEPTH, AS MEASURED FROM AN 457 TEMPLATE CENTERED AT THE WELD AND CUT TO THE PRESCRIBED RADIUS.
11. THE LOCALIZED DEVIATION OF THE SHELL CONTOUR AT A GIRTH JOINT SHALL NOT EXCEED 10 MAX. DEPTH AS MEASURED FROM A 914 LONG STRAIGHT EDGE CENTERED AT THE WELD.
12. DEFECTIVE AREAS SHALL BE REPAIRED IN SUCH A MANNER AS NOT TO GOUGE, GROOVE OR REDUCE THE BASE METAL THICKNESS.
13. ALL STRUCTURAL WELDS AND FABRICATION TOLERANCES SHALL BE SUBJECT TO INSPECTION BY THE OWNER'S REPRESENTATIVE.
14. FOR N.D.E. REFER TO DOCUMENT N° 03-MH-E-96919(N1001/6-Q-600)
15. BEFORE STACK SECTIONS ABOVE BREECHING OPENING ARE ATTACHED, ALL LOWER ROUNDABOUTS MUST BE WELDED COMPLETE AND STIFFENERS ATTACHED.
16. IF STIFFENER RING IS REQUIRED IN THIS AREA TO MEET STRUCTURAL REQUIREMENTS, PLACE RING 559 DOWN FROM T.O.G. ELEVATION OF PLATFORM.
17. PAINTING :
    - STACK (TOTAL 125 µm)
      - -SAND BLAST : SA 21/2
      - -PRIMER : ZINC ETIL-SILCATO 75 µm
      - -FINISH : UP TO 5300 EL. 1° ACRIL-SILICONE RAL 7035 25 µm
        2° ACRIL-SILICONE RAL 7035 25 µm
        OVER 5300 EL. 1° ACRIL-SILICONE RAL 9010/RAL 2002 25 µm
        2° ACRIL-SILICONE RAL 9010/RAL 2002 25 µm
    - STAIR PLATFORM LADDERS (TOTAL 125 µm)
      - -SAND BLAST : SA 21/2
      - -PRIMER : ZINC ETIL-SILCATO 75 µm
      - -FINISH : UP TO 5300 EL. 1° EPOSSIDICO-BICOMP RAL 7035 50 µm
        2° EPOSSIDICO-VINIL BICOMP RAL 7035 100 µm
        OVER 5300 EL. 1° EPOSSIDICO-BICOMP RAL 9010/RAL 2002 50 µm
        2° EPOSSIDICO-VINIL BICOMP RAL 9010/RAL 2002 100 µm
    - GRATING : HOT DIP GALVANIZED
    - PERSONAL PROTECTION : HOT DIP GALVANIZED
    - CABLE TRAYS : HOT DIP GALVANIZED
18. FOR STACK FOUNDATION SEE DWG N° 03-MH-B-96001 (N° N1001/6-M-050)
19. ALL DIMENSIONS ARE IN MILLIMETERS.

NOOTER/ERIKSEN

RELEASE DATE: 05-SEPTEMBER-2001

JOB NO	CODE	SHT	REV	FE

PROJECT:

DRAWING NUMBER: 013139-ES-N-01

EniPower

COMM.

Centrale a Ciclo Combinato- Ravenna

Snamprogetti

COMM.

DIS. N.

Fg di

REV.	DATA
0	05-07-01
2	22-04-02
3	04-09-02

REVISION	DATE	DESCRIPTION	DRW	CHECKED	APPROVED
3	04-09-02	FIXED PREVIUS HOLD	C. D. B.	G. C.	G. C.
2	22-04-02	VALID FOR CONSTRUCTION	C. D. B.	G. C.	G. C.
1	19-07-01	REVISED FOR INTERNAL ISSUE	MC		
0	05-07-02	FIRST ISSUE	MC		

PROJECT:

DRAWING: EXHAUST STACK REQUIREMENTS

CUSTOMER:

SCALE -

DATE: 04-09-02

DRAWING N° : N1001/6-M-700

sh. 1 of1

NECCT NOOTER/ERIKSEN - CCT
GRUPPO MARCEGAGLIA
VIA RAFFAELLO SANZIO N° 2D
GALLARATE (VA)
ITALY

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