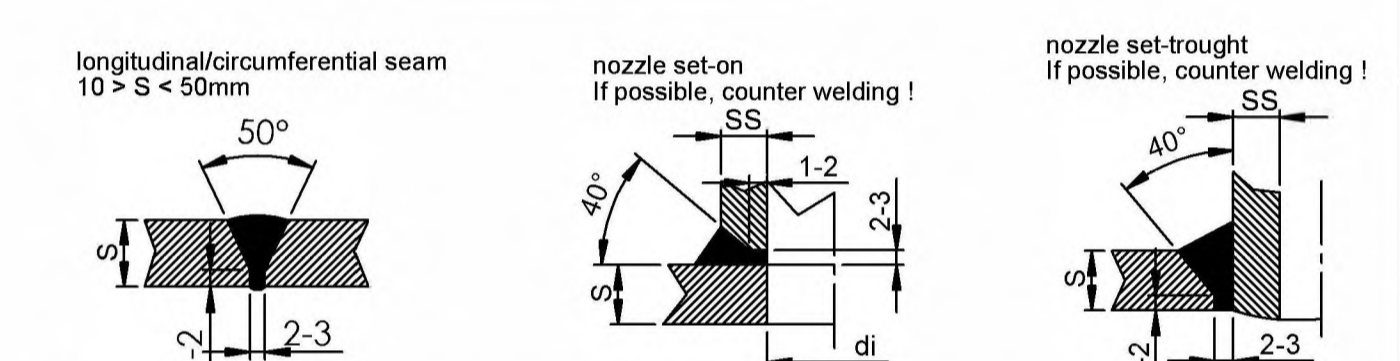
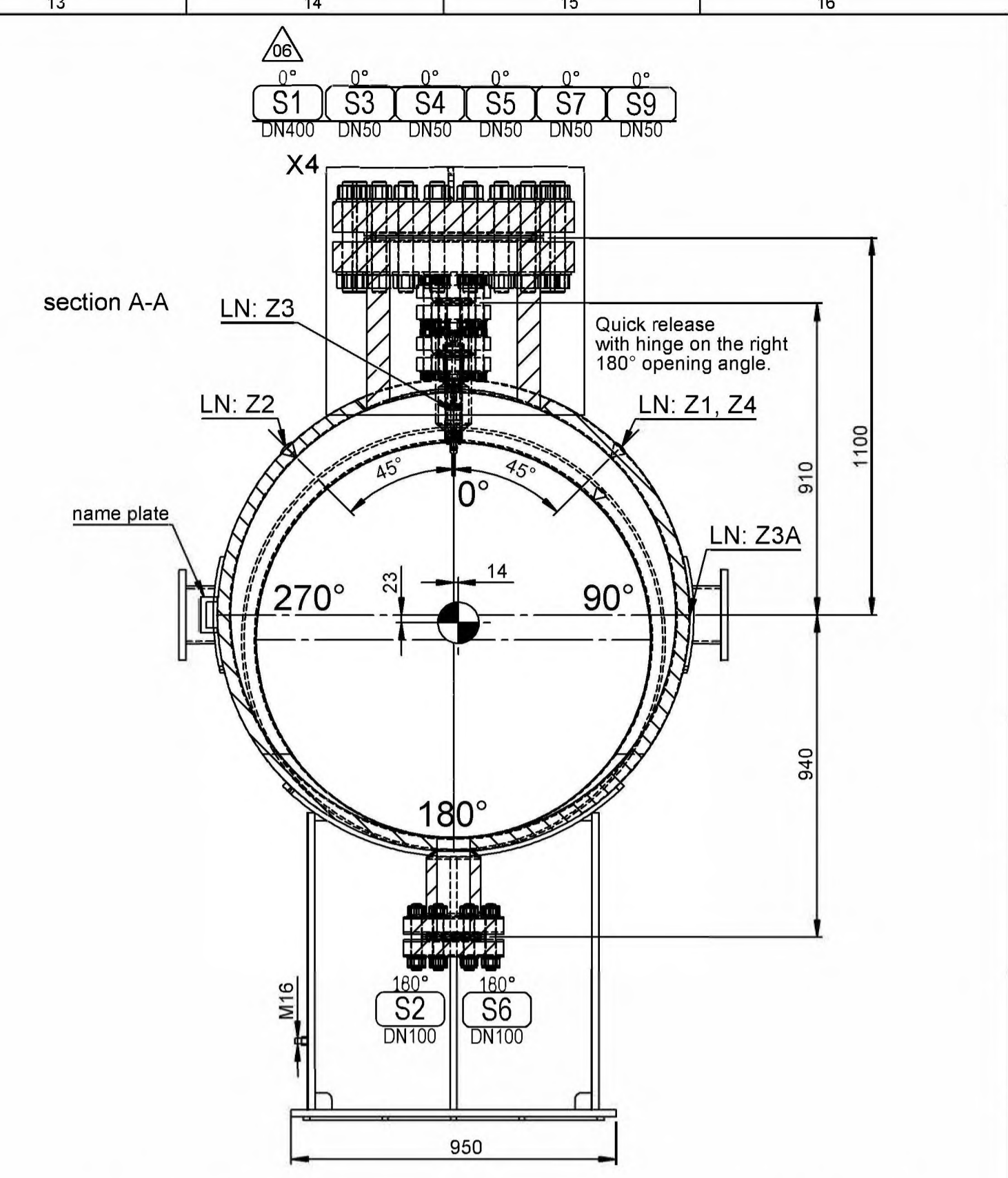
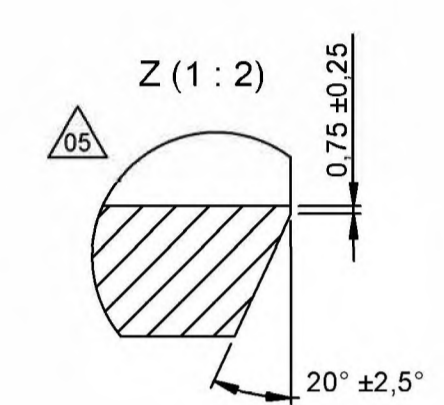
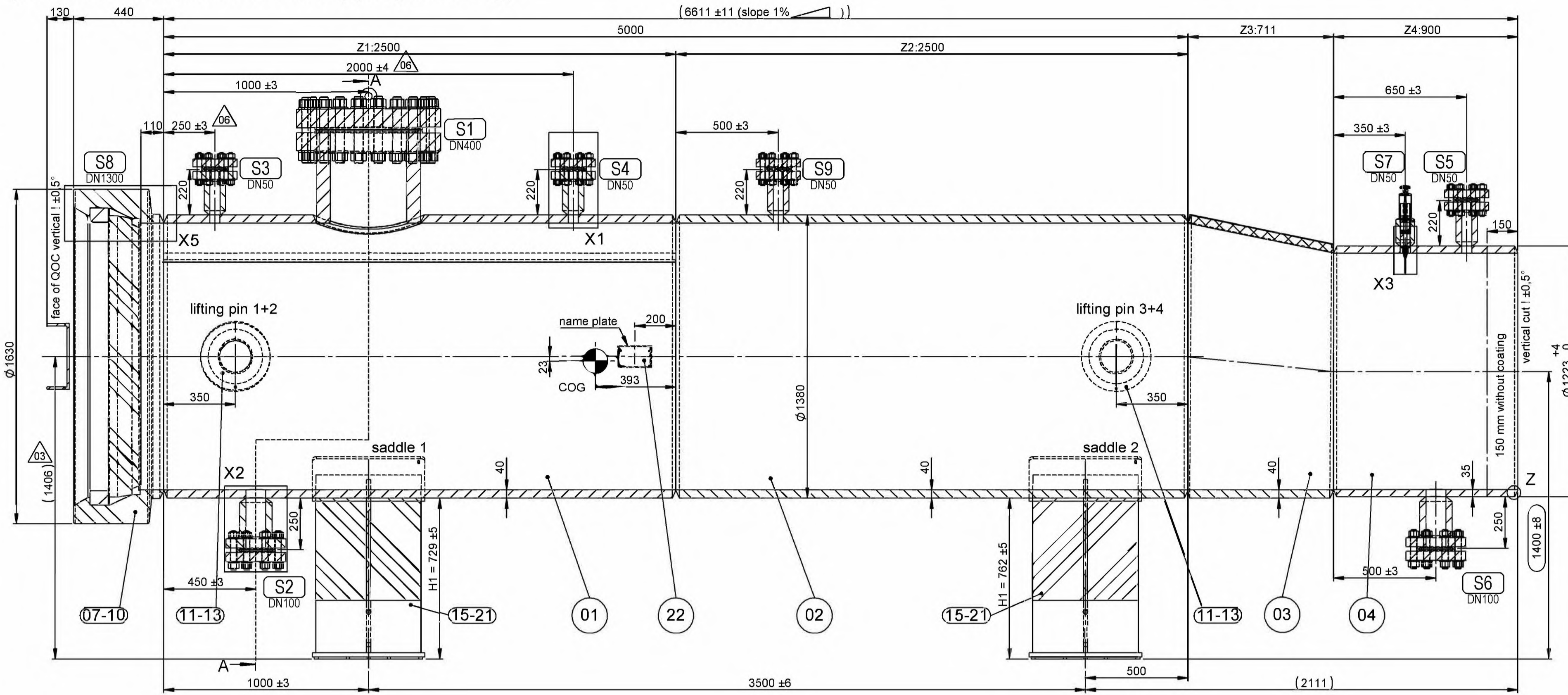


Launcher 1 - ITEM 30 - Tower #2

(serial no. : 10455 / volume: 8580 liters / empty weight: 16.140 kg)



Mantelbleche US-Prüfung EN10160 Klasse S2 für Flächenfehler, E2 für die Randzone. Auffächungen und Einziehungen der Mantelbleche zu minimieren. AD HP1 Abs. 3.6 ist einzuhalten! FE-Rissprüfung der beiden Rundnähte am Konus (innen) und am Stutzen S1.

Shell plates UT test EN10160 class S2 for surface defects, E2 for the edge zone. Roofing and retractions of the shell plates to be minimized, AD HP1 paragraph 3.6 to be observed! FE crack test of both circumferential welds at the cone (inside) and at the nozzle S1.

TECHNICAL DATA		room 1	room 2
Design data	Test pressure (water)	[bar]	192 (DVGW 469 A2)
	Design pressure	[bar]	120
	Design temperature	[°C]	-27 / +60
	Number of cycles		AD-S1 (1000)
	Safety factor		1,8
	Corrosion allowance	[mm]	1 mm
	Volume	[l]	see drawing
	Products		natural gas
	Material		P460NL2
	Weld factor		100%

Welding and Testing	Empty weight ca. [kg]:	see drawing
	Welding process	121, 135, 138, 141
	Welding preparation / evaluation	DIN EN ISO 5817 - Quality level B
	Weld inspection (AD-HP0, HP5)	LN: 100% / S1:100% / RN:100%
	Calculation, testing	AD2000 - Merkblätter + PED 2014/68/EU
	Category and modul acc. PED	IV, Modul G
	Testing	AD2000-Merkblätter HP
	Pressure test	TÜV-SÜD Design review 25.01.2023 / TÜV SÜD 2697747-25140233

Tolerances / Surfaces	Tolerance mechanical processing	DIN ISO 2768 mK
	Tolerance welding processing	DIN 28005
	Cleaning carbon steel	blasted ISO 8501-1 SA 2,5
	Carbon steel coating:	
	outside: layer 1: 2K-ethyl silicate zinc 60µm. layer 2: sealer 2K-Epoxy resin. layer 3: 2K-Epoxy 180µm. layer 4: 2K-PU 60µm RAL: 7032. Total: 300µm. In analogy to Norsok M-501 1A	
	inside: layer 1: 2K-EP zinc 80µm.	

Comments:
 Undimensioned filled weld a=0,5 to 0,7 x t, min.
 Nozzle position acc. to top view. Main axes of flanges without bore.
 Insulation by customer!
 Welding: rough. Surfaces: raw. Bolts and nuts are hot dip galvanized (ISO 10684)
 Flange faces horizontal! Main welding end 150mm without coating

document no.: **KEM-GLL-MEC-DWG-045501-06**

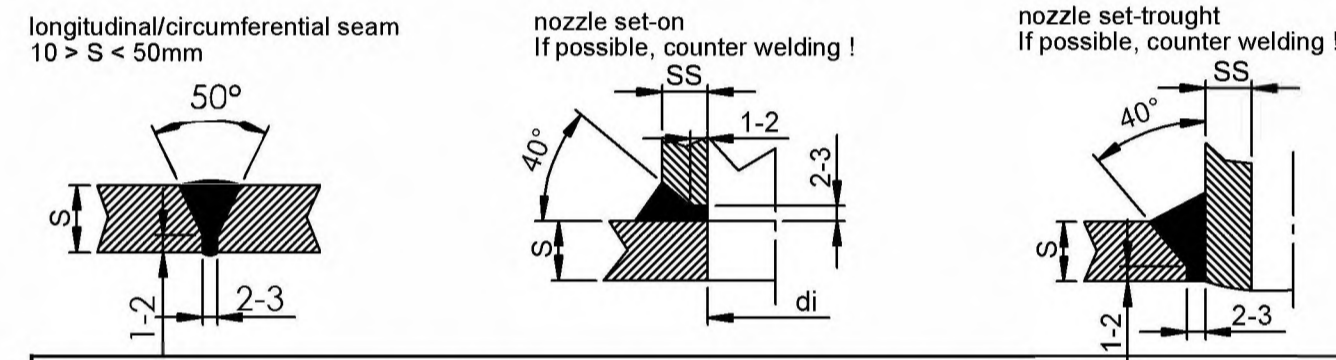
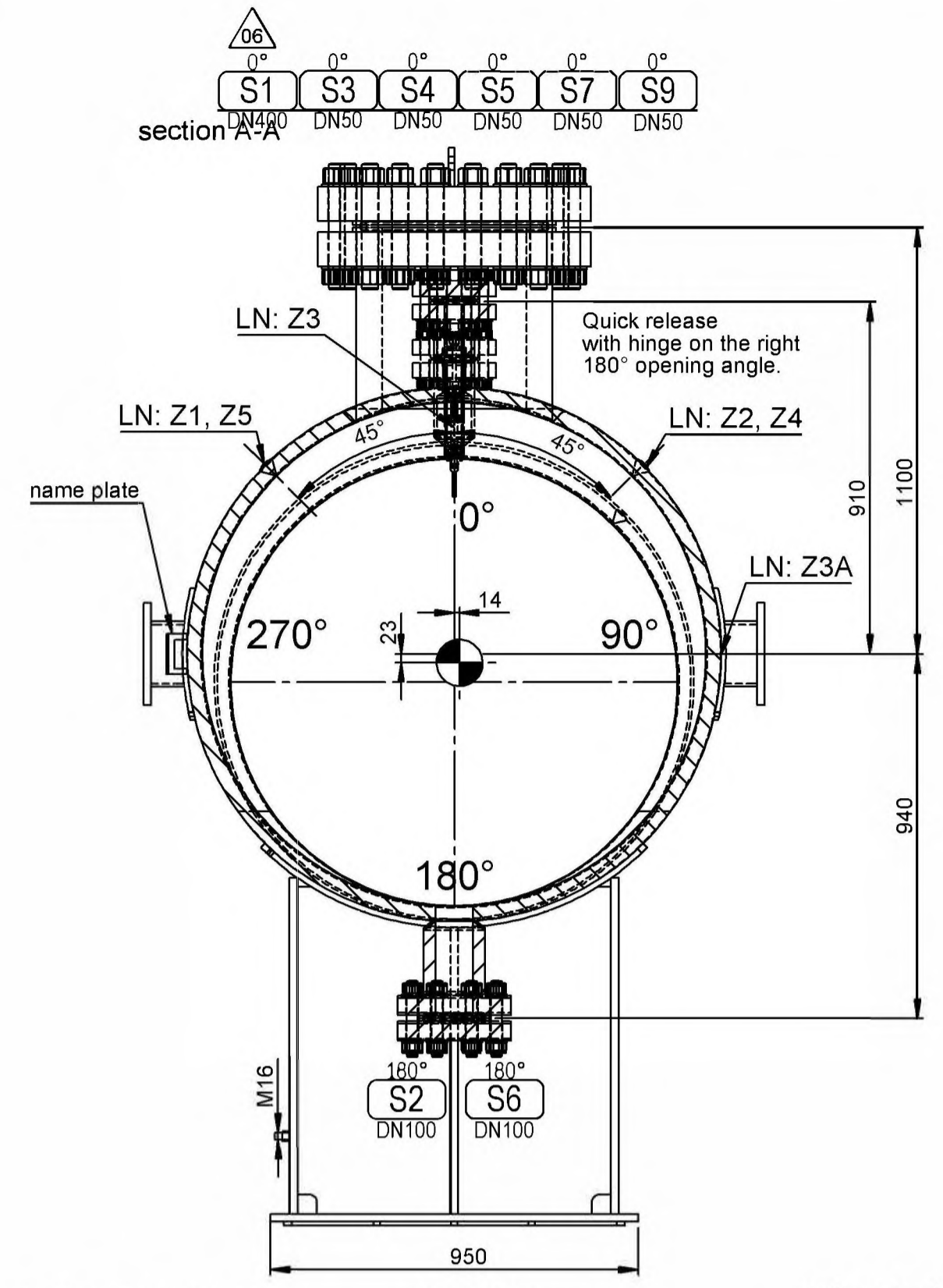
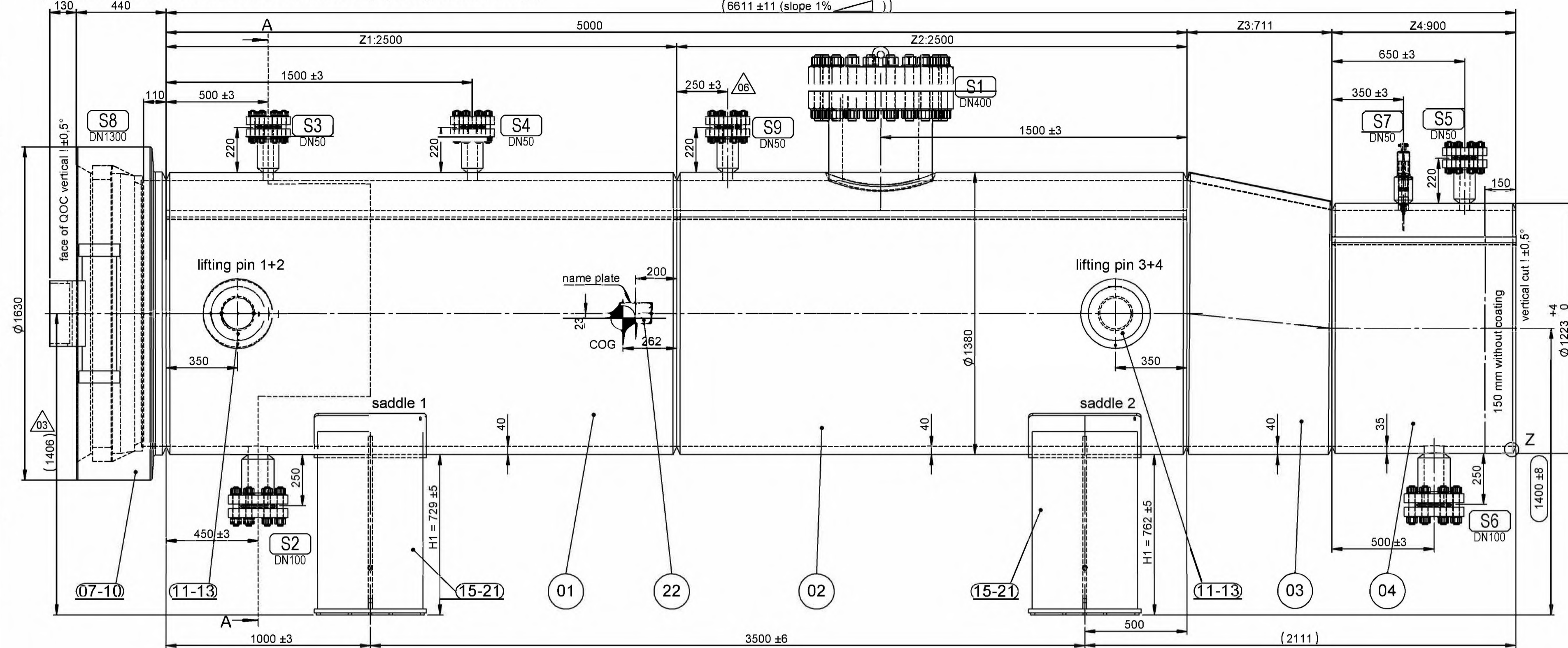
Siegfried Kempe GmbH Apparate- und Maschinenbau Steinhaldenweg 5 - 9 D-74193 Schwaigern - Germany		serial nr. x 10455	capacity y 8580
		10456	10300
max. zulässiger Druck PS 120 max. zulässige Temperatur TS -27 / +60 Volumen capacity V Y Medium medium Erdgas natural gas		Raum 1 chamber 1 Raum 2 chamber 2	
Leistung output Hersteller-Nr. X Herstellerjahr 2023 CE 0036		22	

Pos.	DN	PN	Norm	Benennung	Bemerkung
S1	400-16"	cl900	ASME B16.5 LWN RTJ	Treiber / kicker line	blindflange
S2	100-4"	cl900	ASME B16.5 LWN RTJ	Entleerung / drain - balance line	blindflange
S3	50-2"	cl1500	ASME B16.5 LWN RTJ	Entlüftung / vent	blindflange
S4	50-2"	cl1500	ASME B16.5 LWN RTJ	Entlüftung / local vent	blindflange
S5	50-2"	cl1500	ASME B16.5 LWN RTJ	Entlüftung / vent	blindflange
S6	100-4"	cl900	ASME B16.5 LWN RTJ	Entleerung / drain - balance line	blindflange
S7	80-1,5"	PN120	KEMPE	Molchmelder / pig signaller	mechanical
S8	1300	PN120	KEMPE	Schnellverschluss / quick opening closure	manual operation
S9	50-2"	cl1500	ASME B16.5 LWN RTJ	Sicherheitsventil / PSV	blindflange

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Draht: 01 12 2022 Name: Ribello	Datum: 01 12 2022 Name: Ribello	Benennung: Molchscheule / Launcher DN1200 PN120 P460NL2 / S.1,8	Revision: 06	Status:
Zeichnung: A1 Maßstab: 1:15	Technische No.: B-1200-120-062/1	Hersteller / Hersteller: 10455 Zusammenbau	Hersteller / Hersteller: 2023 / 10455-58	Blatt / von: 1 / 1

Receiver 1 - ITEM 40 - Tower #1

(serial no. : 10457 / volume: 8580 liters / empty weight: 16.140 kg)



Mantelbleche US-Prüfung EN10160 Klasse S2 für Flächenfehler, E2 für die Randzone. Aufdachungen und Einziehungen der Mantelbleche zu minimieren, AD HP1 Abs. 3.6 ist einzuhalten! FE-Rissprüfung der beiden Rundnähte am Konus (innen) und am Stutzen S1.

Shell plates UT test EN10160 class S2 for surface defects, E2 for the edge zone. Roofing and retractions of the shell plates to be minimized, AD HP1 paragraph 3.6 to be observed! FE crack test of both circumferential welds at the cone (inside) and at the nozzle S1.

TECHNICAL DATA		room 1	room 2
Design data	Test pressure (water)	[bar]	192 (DVGW 469 A2)
	Design pressure	[bar]	120
	Design temperature	[°C]	-27 / +60
	Number of cycles		AD-S1 (1000)
	Safety factor		1,8
	Corrosion allowance	[mm]	1 mm
	Volume	[l]	see drawing
	Products		natural gas
	Material		P460NL2
	Weld factor		100%

Melding and Testing	Empty weight ca. [kg]:	see drawing
	Welding process	121, 135, 138, 141
	Welding preparation / evaluation	DIN EN ISO 5817 - Quality level B
	Weld inspection (AD-HP0, HP5)	LN: 100% / S1:100% / RN:100%
	Calculation, testing	AD2000 - Merkblätter + PED 2014/68/EU
	Category and modul acc. PED	IV, Modul G
	Testing	AD2000-Merkblätter HP
	Pressure test	TÜV-SÜD Design review 25.01.2023 / TÜV SÜD 2697747-2510233

Tolerances / Surfaces	Tolerance mechanical processing	DIN ISO 2768 mK
	Tolerance welding processing	DIN 28005
	Cleaning carbon steel	blasted ISO 8501-1 SA 2,5
	Carbon steel coating:	
	outside: layer 1: 2K-ethyl silicate zinc 60µm. layer 2: sealer 2K-Epoxy resin. layer 3: 2K-Epoxy 180µm. layer 4: 2K-PU 60µm RAL: 7032. Total: 300µm. In analogy to Norsok M-501 1A	
	inside: layer 1: 2K-EP zinc 80µm.	

Comments:
 Undimensioned filled weld a=0,5 to 0,7 x t, min.
 Nozzle position acc. to top view. Main axes of flanges without bore.
 Insulation by customer!
 Welding: rough. Surfaces: raw. Bolts and nuts are hot dip galvanized (ISO 10684)
 Flange faces horizontal! Main welding end 150mm without coating

document no.: **KEM-GLL-MEC-DWG-045502-06**

Siegfried Kempe GmbH
 Apparate- und Maschinenbau
 Steinhaldenweg 5 - 9
 D-74193 Schwaigern - Germany

kempe

serial nr.	capacity
x	y
10457	8580
10458	14820

Raum 1 chamber 1	Raum 2 chamber 2
max. zulässiger Druck PS (bar)	120
Prüfdruck PT (bar)	192
Zul. min./max. Temperatur TS (°C)	-27 / +60
Volumen (liters)	Y
Medium (medium)	Erdgas natural gas
Leistung (kW)	
Hersteller-Nr. (serial no.)	2023
Typ (type)	0036

TÜV

Pos.	DN	PN	Norm	Benennung	Bemerkung
S1	400-16"	cl900	ASME B16.5 LWN RTJ	Treiber / kicker line	blindflange
S2	100-4"	cl900	ASME B16.5 LWN RTJ	Entleerung / drain - balance line	blindflange
S3	50-2"	cl1500	ASME B16.5 LWN RTJ	Entlüftung / vent	blindflange
S4	50-2"	cl1500	ASME B16.5 LWN RTJ	Entlüftung / local vent	blindflange
S5	50-2"	cl1500	ASME B16.5 LWN RTJ	Entlüftung / vent	blindflange
S6	100-4"	cl900	ASME B16.5 LWN RTJ	Entleerung / drain - balance line	blindflange
S7	80-1,5"	PN120	KEMPE	Molchmelder / pig signaler	mechanical
S8	1300	PN120	KEMPE	Schnellverschluss / quick opening closure	manual operation
S9	50-2"	cl1500	ASME B16.5 LWN RTJ	Sicherheitsventil / PSV	blindflange

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 • Kemlock • Kemtight

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Reviz.	Datum	Name	Bemerkung
01	12.2022	Ribeiro	Molchschleuse / Receiver

Reviz.	Datum	Name	Bemerkung
06			

DN1200 PN120
 P460NL2 / S.1,8

Reviz.	Datum	Name	Bemerkung
A1	10.2023	Medeiros	B-1200-120-062/2

2023 / 10455-58