

DISHED END SPECIFICATION

1	Type of Construction	Hemispherical
2	Material of Construction	SA 537 Cl.1
3	Code of Manufacture	ASME Sec VIII Div I, 2019
4	Third Party Inspection	BY IRS
5	Quantity Required – Nos.	8
6	Inside Diameter - mm	3452
7	Straight Face – mm	0 (Excluding provisions for cutting & finishing)
8	Minimum reqd. thickness after dishing - mm	19 mm (Nominal thickness: 24 mm)
9	Centre Hole Requirement	Not required
10	Raw Material Procurement for Dish	By Vendor
11	UT Examination of plates	UT of the plates before and after dishing to be done as per SA 578 Level B & supplementary requirements S1 and test certificate to be furnished
12	Charpy Impact testing of plates	Required, Min. avg. value shall be 27J at -40°C
13	Mfr TC/ Material Test Certificate (MTC)	Required
14	Tolerance	As per IS 4049 Part II/ ASME Sec VIII Div I as applicable
15	Radiography	Yes ,100%. The dished end can be formed from minimum number of petal joints and a crown. The welding electrode/ filler wire used shall have the same/ better impact property of the plates. The welding shall be carried out as per the WPQ/ WPS approved by FEW/ TPI in compliance with relevant ASME sections.
16	Dye Penetrant Test	For Edges etc. as applicable
17	PWHT	YES, AFTER FINAL ASSEMBLY WITH THE VESSEL.
	Specification Sheet No.	DES/ SPEC/ 119 REV: 0
	Equipment Name	AMMONIA BULLETS
	FEW Job Order No.	8673/19
	FACT Engineering Works, Palluruthy, Kochi	<div style="display: flex; justify-content: space-between;"> <div style="text-align: center;"> VIJAY Prepared by </div> <div style="text-align: center;"> VIMAL Approved by </div> </div>

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