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	<p>SECTION 3.8: SHELL AND BELLOWS INSPECTION</p> <p>Inspect stainless steel bellow on the outside and inside to determine condition, if damage found both bellows to be replaced Perform NDT on bellow to determine damage</p> <p>Note Engineering to confirm repairs after inspection but provisions to be made when doing planning and pricing to accommodate repairs</p> <p><u>Shell Repairs if crack or pin hole is found</u> Grid cracked are and re do crack test and submit report to engineering</p>	<p>Material of test block = as per new recommended material of section 3.5 Thickness = 55 mm</p> <p><u>Shell Side Specifications</u></p> <ul style="list-style-type: none"> • Sand blast to grade SA 2.5 • Pressure= 0.05 Mpa • Temperature = 400 degrees • Shell Material= H11 N • Bellow Material =Stainless steel (1.4541) • Bellow Thickness = 2.5 mm • Shell thickness = 8mm • Adhere to 240-83539994 Eskom NDT Personnel Approval (NPA) for Quality Related Special Processes on Eskom Plant Standard Personnel 		
	<p>SECTION 3.9: INSTALLATION OF TUBES</p> <p>Install tubes as per submitted procedure Expand tubes to tube sheet (use mock up results obtained)</p>			


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Weld back all pipes on both gland both vapour condenser that were cut off and conduct NDE on new welds	Related Special Processes on Eskom Plant Standard Personnel		
	<ul style="list-style-type: none"> WPS and WQR to be submitted to Eskom for review prior to work Submit NDE report to engineering 		
Calibrate all pressure gauges and temperature gauges	<ul style="list-style-type: none"> Submit test certificates to engineering 	R	Contractor
Submit data book to engineering		R	Contractor


BILL OF MATERIAL

Full description of Material/Spares/Equipment	Specifications of Material/Spares/Equipment	Stock No	Part Number	Required Quantity
Gland Steam Section	Tubes			
Vapor Section	Tubes 20mmx1 25mm wall thickness	591920		720
Gland and Vapour Steam Condenser		770968		2
Main turbine Gland steam condenser Tube sheet				2
Klinger's Gasket	3mm thickness KLINGERSil C4243			As required

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URS		X		
Philosophy (Outage)	X			
Condition Monitoring Report		X		
VA/PHD Viewer trends		X		
Corrective Actions		X		
CARAB reports		X		
Statutory Requirements		X		
Grid code requirements		X		
Waivers and Exemptions		X		
Calibration requirements		X		
Previous Outage SOW variations		X		
Post Mortems Actions from previous outages	X			
Pre-Outage plant walks		X		
Risk based inspection (RBI) report		X		
Simulation, TOIs, OON, SI		X		

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