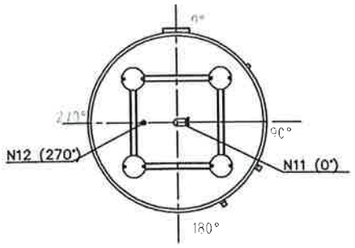
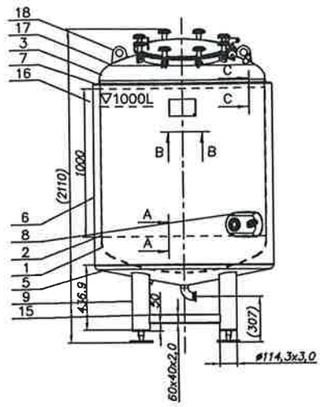
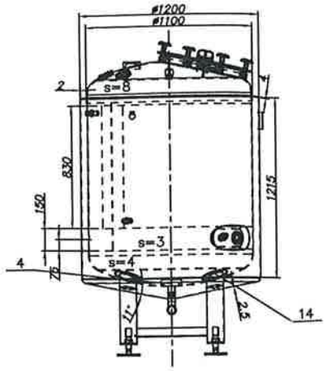
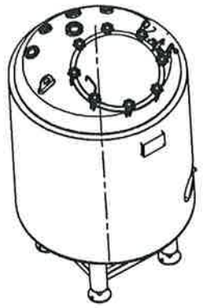
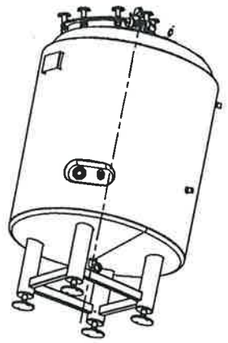


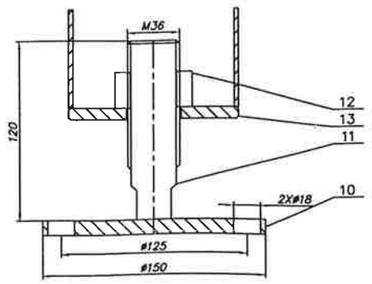








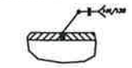
Detail A
M 12



Hersteller:	SK GROUP Skrlj d.o.o. Dunajska cesta 156 1000 Ljubljana Slovenija www.sk-group.biz
Bezeichnung:	Prozesstank 1000L
Fabrik Nr.:	12100497
	Behälter:
Volume:	1280 l
Betriebsdruck:	0/3,0 bar
Prufdruck:	4,29 bar
Betriebstemperatur:	+5/+130°C
Produktgruppe:	Fluid Gruppe 2
Werkstoff:	W.Nr.1.4404
Baujahr/Druckprobe am:	2012/03-2012

CE 0531

Schnitt A–A:



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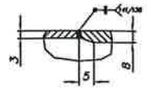

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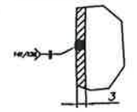
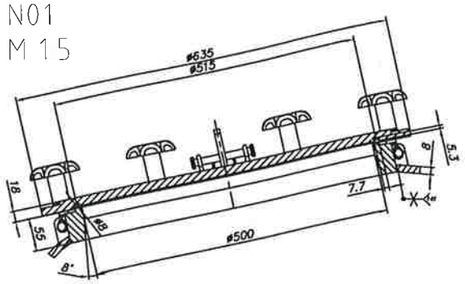
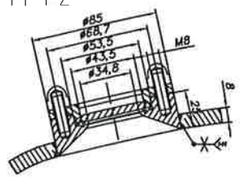


N01
M 1:5



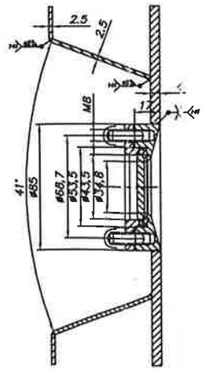
N02,N04
M 1:2



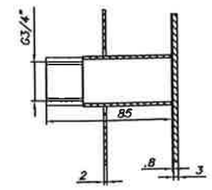
ANSCHLUS TABELLE:

Pos	DN	PN	Description	Standard No.	Type	Pos	Material	Smelter Nr.	Atest Nr.	Acceptance Nr.
113	1/2"		Anschluss			1	W.Nr.1.4301			
111	40		Auslass	ISO2852	TC	1	W.Nr.1.4404			
110			Anschluss		Ingold	1	W.Nr.1.4404			
108	1/2"		Anschluss	BS4825	Na connect	1	W.Nr.1.4404			
106	1/2"		Austritt Kühlkreislauf			1	W.Nr.1.4301			
107	1/2"		Eintritt Kühlkreislauf			1	W.Nr.1.4301			
105	1"		Anschluss	BS4825	Na connect	1	W.Nr.1.4404			
103	50		Sprühkugel	ISO2852	Na connect	1	W.Nr.1.4404			
104	1/2"		Anschluss	BS4825	Na connect	1	W.Nr.1.4404			
101	1"		Anschluss	BS4825	Na connect	1	W.Nr.1.4404			
102	1/2"		Anschluss	BS4825	Na connect	1	W.Nr.1.4404			
181	500		Mannloch			1	W.Nr.1.4404			

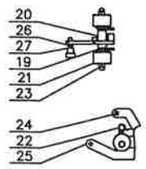
N09
M 1:2



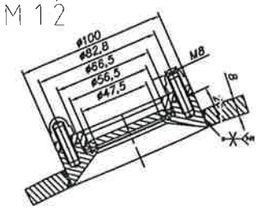
N07,N08
M 1:2



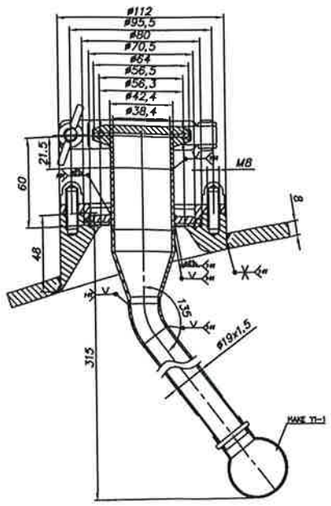
Federaufnahmehilfe und Sicherheitsarretierung



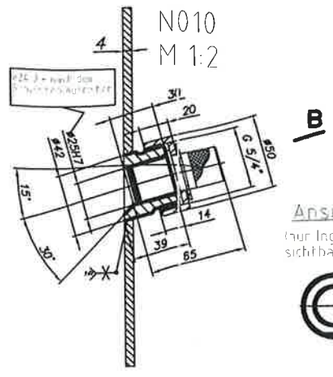
N03,N06
M 1:2



N05
M 1:2

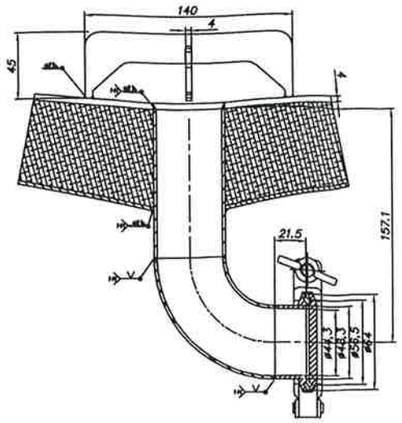


N010
M 1:2



Ansicht B
(nur Ingoldschutzen sichtbar)

N11
M 1:5



N12
M 1:2

Oberfläche innen* Ra<0,8 ganzflächig maschinell geschliffen ausgenommen Kehlnähte
Oberfläche aussen** Ra<1,2 poliert, Schweissnähte planverschliffen exkl. Stutzenanschweissnähten und Kehlnähte

		INNENRAUM INSIDE	AUSSENRAUM OUTSIDE
SURFACE DATA OBERFLÄCHE DATEN	ROUGHNESS Ra (ym)	<0,8	<1,2
	WORKING PROCESS	*	**
	REMARKS	/	/
WELDING DATA SCHWEIßDATEN		BEHÄLTER SHELL	ISOL. MANTEL ISOL. SHELL
	WELDING PROCESS	TIG–141/MAG–135	TIG–141/MAG–135
	MATERIAL OF WELDING WIRE	LINCOLN MECHALS/ARCALIS ULTRALIS	LINCOLN MECHALS/ARCALIS ULTRALIS
	WELDERS CERTIFICATE	SIST EN 287–1	SIST EN 287–1
	METHOD OF THE WELDED JOINTS TESTING	radiographic	/
	CROSS WELDS TEST (%)	2	/
	LONGITUDINAL WELDS TEST (%)	2	/
	CIRCUMFERENTIAL WELDS TEST (%)	2	/
	REMARKS	/	/
MATERIAL DATA WERKSTOFFDATEN		BEHÄLTER SHELL	ISOL. MANTEL ISOL. SHELL
	MATERIAL	W.Nr.1.4404	W.Nr.1.4301
	STANDARD	AD–W2	AD–W2
	REMARKS	/	/
DESIGN AND WORKING DATA KONSTRUKTIONS– UND BETRIEBSDATEN		BEHÄLTER SHELL	ISOL. MANTEL ISOL. SHELL
	DESIGN PRESSURE (bar(g))	0/3	/
	OPERATION PRESSURE (bar(g))	0/3	/
	TEST PRESSURE (bar(g))	4,29	/
	DESIGN TEMPERATURE (°C)	0/+150	/
	OPERATION TEMPERATURE (°C)	+5/+130	/
	TOTAL VOLUME (L)	1280	/
	WORKING VOLUME (L)	1000	/
	NUMBER OF LOAD CYCLES (N)	/	/
	MEDIUM (dangerous, non–dangerous)	Fluid Gruppe 2	/
	MEDIUM DENSITY (kg/m3)	1000	/
	TOTAL VESSEL WEIGHT (kg)	411	
	PERMISSIBLE DESIGN STRESS LEVEL IN JOINTS	v=0,85	
	VESSEL CLASSIFICATION – TEST GROUP	III	/
	REMARKS	/	/

PRESSURE VESSEL DATA DRUCKBEHÄLTER DATEN			
	NAME	PROZESSTANK 1000L	
	TYPE	Vertikale Druckbehälter	
DESCRIPTION	FORM	Zylindrisch mit Klöpperboden Enden	
	SITUATION	Vertikal	
	DESTINATION	Druckbehälter	
SERIAL NUMBER		12100497	
CLIENT		ŠKRLJ d.o.o.	
PRODUCER		ŠKRLJ d.o.o.	
YEAR OF PRODUCTION/TEST		2011	
REMARKS		/	

DIN ISO 2768–1: m

Material W.Nr.1.4404/1.4301 | Scale M1: 20 | Mass–kg/piece 411

	Date	Name	Signature
Chief	19.1.12	ŠKRLJ T.	
Constructor	19.1.12	Kete I.	
Drew by	19.1.12	Kete I.	
Checked by	19.1.12	ŠKRLJ T.	

Title: PROZESSTANK 1000L

Drawing Nr.: 101836 | Sheet: 1/2

ANLAGA_1000L.dwg

Mark	Modification	Date	Signature