



NATIONAL PETROCHEMICAL COMPANY
STANDARDS

CONSTRUCTION STANDARD
FOR
INSTALLATION OF PRESSURE VESSELS & TOWERS
NPCS-CS-PV-01
REVISION : 0

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1 SCOPE

- 1.1 The work shall consist of local transportation of vessels, towers, drums and erection of foundations structures furnished by client, levelling, aligning and grouting; assembly and fixing of different types of trays, packings, demisters and other internals; filling of catalysts, and rasching rings, pall rings, etc., in all respects as per project drawings, specifications and instructions of client.
- 1.2 Towers, vessels, drums etc., will be supplied by the contractor in general in single pieces. The drawing gives details such as approximate dimensions, approximate erection weight and elevation at which the vessels, towers, etc., are to be erected.
- 1.3 Rigging procedures for all the major lifts and maximum crane capacity shall be submitted by the contractor to the client and this approval shall be obtained. Approval of client shall not relieve the contractor for his responsibilities.

2 ERECTION

2.1 GENERAL

While erecting the vessels, towers, etc., care should be taken not to damage nozzles, instruments connections, all clips, (structural, piping, insulation, etc.). After erection, the vessels, towers, reactors, etc., shall be levelled and properly aligned with necessary shims and wedges. Contractor will also take care of the orientation of the nozzles and other outlets of the towers, vessels, etc., while erecting the same and ensure compliance with project drawings and specification. Discrepancy, if any, in the number/ orientation of nozzles, cleats etc., should be brought to the notice of client before actual erection is started.

2.2 SLINGS FOR LIFTING

- 2.2.1 The slings used for lifting various loads shall be invariably tested by a test load before carrying out actual erection. The weight of test load shall be minimum 50% higher than the weight of equipment to be lifted. The duration of holding of test load shall be decided by the client. The test shall be carried out in presence of the representative of client.

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