


- NOTES:-
1. MATERIAL
- 1.1 STEEL PLATES FOR THE TANK SHELL AND END PLATES TO BE AS PER BS4360 Gr. 43A OR ASTM A 36 OR ASTM A131
- 1.2 ALL PIPES SHOULD BE MS BLACK AS PER BS1387(LATEST) WITH BSPT.11TPI SCH 40
- 1.3 HORIZONTAL AND CYLINDRICAL SEAMS TO BE BUTT WELDED AND GROUNG SMOOTH.
- 1.4 STRUCTURAL STEEL USED SHOULD BE ASTM A 36 OR EQUIVALANT.
2. TANK TO BE SUPPLIED WITH MANHOLE COVER FITTINGS, ASBESTOS RING TO SUCTION PIPES AND BOLTS & NUTS AS SHOWN IN THE DRAWING.
- 2.1 10mm THICK RING TYPE IRON MANHOLE TO BE FITTED WITH 3mm HELID PACKING TO ENSURE THE TANK IS AIR TIGHT.
3. TESTING OF TANK
- 3.1 TANK TO BE HYDROTESTED TO 0.5KSC BY MAINTAINING WATER COLUMN OF 5.2M AND OBSERVING FOR A PERIOD OF 2HRS.PRESSURE GAGE READING INCLUDING WATER COLUMN TO BE FURNISHED AS PART OF TEST REPORT
4. SURFACE PREPARATION & PAINTING
- 4.1 SURFACE PREPARATION: MECHANICAL CLEANING BY POWER BRUSH TO SSPC SP2 OR BETTER
- 4.2 PAINTING : EXTERNAL SURFACE OF TANK AND ACCESSORIES TO BE WITH 2COATS OF ZINC PHOSPHATE PRIMER TO A DFT OF 30 TO 35 MICRONS, PER COATS FOLLOWED BY 2 COATS OF BITUMEN EMULATION FLINCOAT 3 FOR A COVERAGE OF 1.5LT/M2 FOR 2COATS
5. WELDER
- 5.1 SHALL BE CERTIFIED FOR SE POTION AS PER ASME 9
6. DIP ROD
- 6.1 THE SUPPLY OF ONE NUMBER DIP-ROD SHOULD BE MARKED IN CENTIMETERS AND CALIBRATION CHARTS IN DUPLICATE FOR EACH TANK SHOULD BE SUBMITTED WITH TANKS. (MM)
7. ALL DIMENSIONS ARE IN MILLIMETERS. (MM)

| S.NO. | CAPACITY OF THE TANK | 'D' (ID) | 'L' (OUTER) |
|-------|----------------------|----------|-------------|
| 1. | 9000 LITRES | 1840 | 3660 |

| REV.NO | DESCRIPTION | REV.BY | DATE |
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 **LANKA IOC PLC**

DRAWING TITLE :

FABRICATION DETAIL OF 9KL HORIZONTAL UNDERGROUND TANK. (GENERAL ARRANGEMENT)

| | | |
|----------|----------------------|--------------|
| DRAWN BY | CHECKED BY | APPROVED BY |
| DRG.Ref. | LIQC/TANK/9KL/1 OF 2 | SCALE: N.T.S |