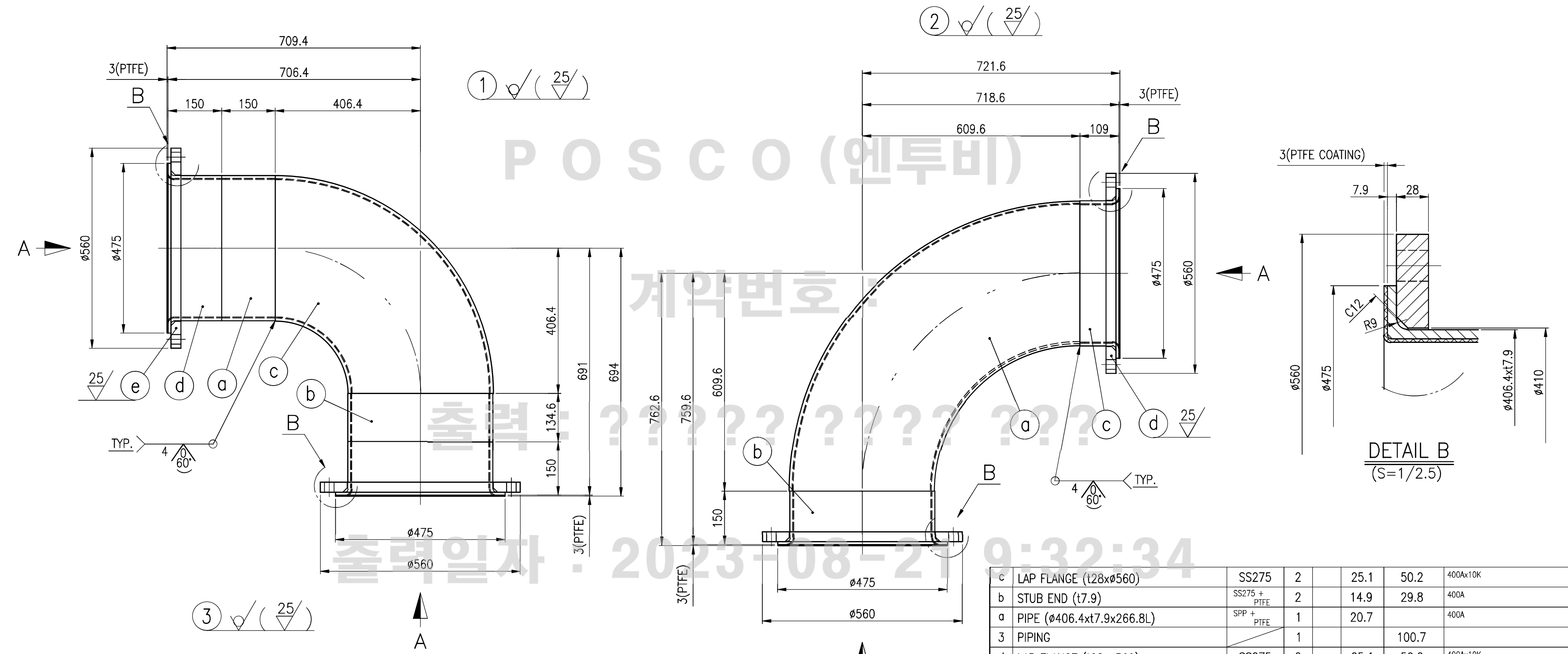
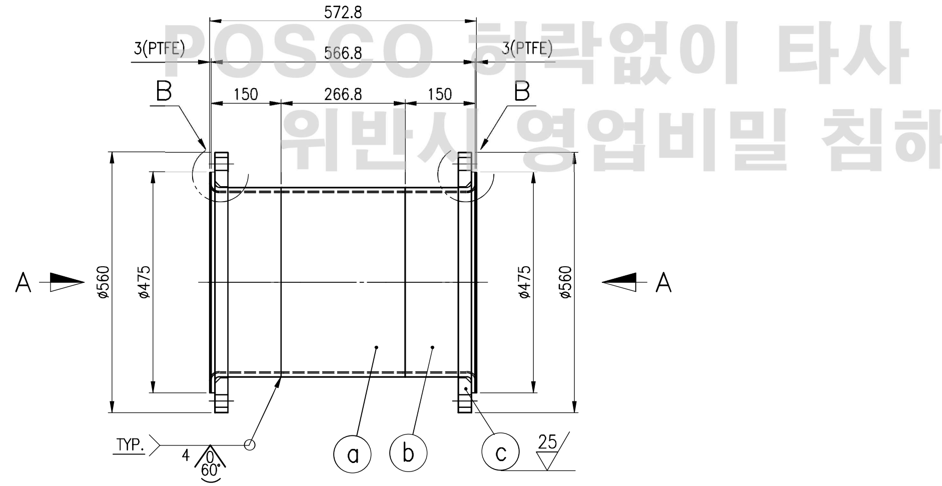
지시외 용접치수	지시외 모서리부분	지시외 일반치수 허용차 (KSB ISO 2768-1)								
a=	지시외 일반 모서리 제거 C = 0.3~0.8 R = 0.3~0.8	절삭 가공부	구 분	0.5 ~ 6	6 ~ 30	30 ~ 120	120 ~ 400	400 ~1000	1000 ~2000	2000 ~4000
			중간급	±0.1	±0.2	±0.3	±0.5	±0.8	±1.2	±2.0

표면 거칠기 (KSB 0161 , 0507 , 0617)										
Ra		0.1	0.2	0.4	0.8	1.6	3.2	6.3	12.5	25
Rmax		0.4S	0.8S	1.6S	3.2S	6.3S	12.5S	25S	50S	100S
다듬질	∼	▽▽▽▽		▽▽▽			▽▽		▽	

NO.	DATE	REVISION & DESCRIPTION	SIGNATURE CHECKED	REVIEWED
△				
△				
△				

P O S C O (엔투비)
계약번호 :
출력 : ????? ???? ???
출력일자 : 2023-08-21 9:32:34
POSCO 허락없이 타사 및 제3자에 제공을 불허하며
위반시 영업비밀 침해로 법적책임이 있습니다.





NO.	DESCRIPTION	MAT'(KS)	QUANTITY UNIT	QUANTITY TOTAL	WEIGHT(kg) PERUNIT	WEIGHT(kg) TOTAL	REMARK'S
c	LAP FLANGE (t28xø560)	SS275	2		25.1	50.2	400Ax10K
b	STUB END (t7.9)	SS275 + PTFE	2		14.9	29.8	400A
a	PIPE (ø406.4xt7.9x266.8L)	SPP + PTFE	1		20.7		400A
3	PIPING		1			100.7	
d	LAP FLANGE (t28xø560)	SS275	2		25.1	50.2	400Ax10K
c	STUB END (t7.9)	SS275 + PTFE	1		2.8		400A
b	STUB END (t7.9)	SS275 + PTFE	1		14.9		400A
a	90° ELBOW (L)	SPP + PTFE	1		74.3		400A
2	PIPING		1			142.2	
e	LAP FLANGE (t28xø560)	SS275	2		25.1	50.2	400Ax10K
d	STUB END (t7.9)	SS275 + PTFE	2		14.9	29.8	400A
c	90° ELBOW (S)	SPP + PTFE	1		49.5		400A
a	PIPE (ø406.4xt7.9x134.6L)	SPP + PTFE	1		10.5		400A
a	PIPE (ø406.4xt7.9x150L)	SPP + PTFE	1		11.6		400A
1	PIPING		1			151.6	

LEG OF CONTINUOUS FILLET WELD									
GRADE	THIN METAL THICKNESS (OVER~INCL.)								
	4	4~6	6~9	9~12	12~16	16~20	20~25	25~32	32~40
A	3	4	5	6	8	10	12	14	16
B	3	3	4	5	5	7	8	10	12
C	3	3	3	4	5	6	7	8	8

NOTE : UNLESS OTHERWISE SPECIFIED ALL JOINTS SHALL BE CONTINUOUS FILLET WELDED TO GRADE A

posco

SCALE	1/8	PROJECTION	⊕◁
SIZE	A2	DIMENSION	mm

TITLE	1화성	PLANT	AG SEPARATOR (1기)
	유황	FACILITY	PIPE LINE PIPING

POSCO EQUIPMENT	S
SHEET No.	
POSCO DWG. NO.	01K-AC14M003510001

		DRAWN	CHECKED	REVIEWED	APPROVED
POSCO	SIGNATURE		염대현		
POSCO	DATE		2023.05.26		
SUPPLIER	SIGNATURE	김상열	허선영	(signature)	송상용
SUPPLIER	DATE	2023.05.23	05/24	05/25	05/25

본 도면에 표기된 재질은 개정된 KS 강종기호(국가기술표준원 고시 제2016-0463호)로 대체하오니 계약/제작시 참고바랍니다.

도면번호 : 01K-AC14M003510001