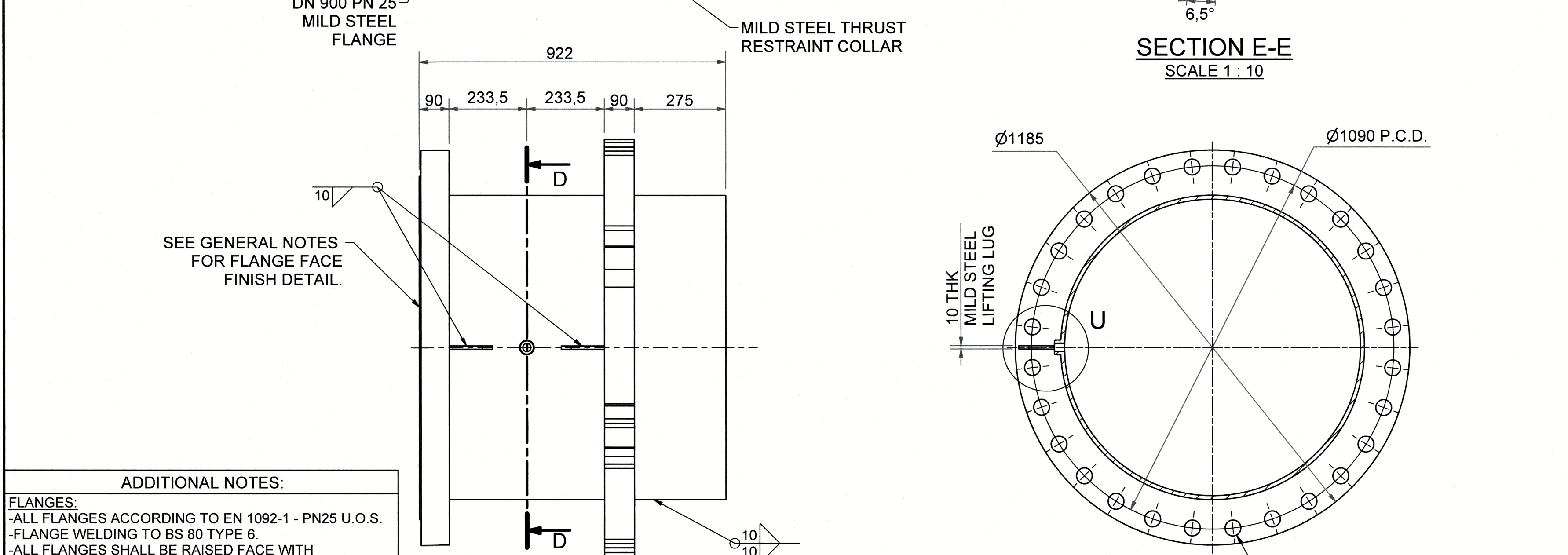
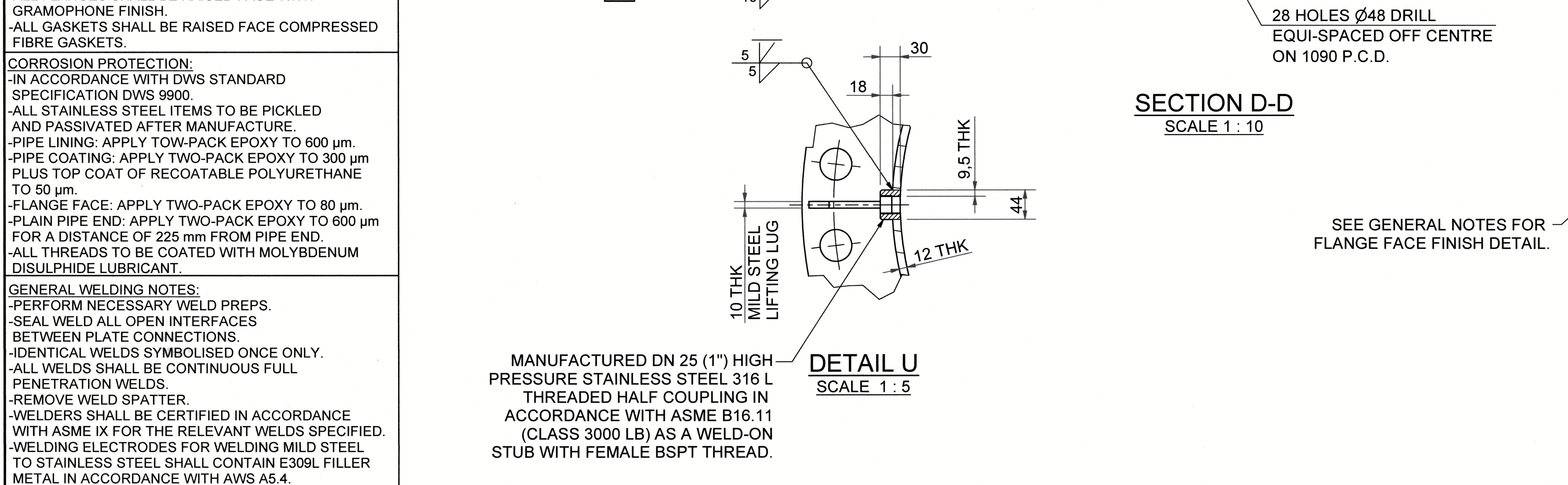


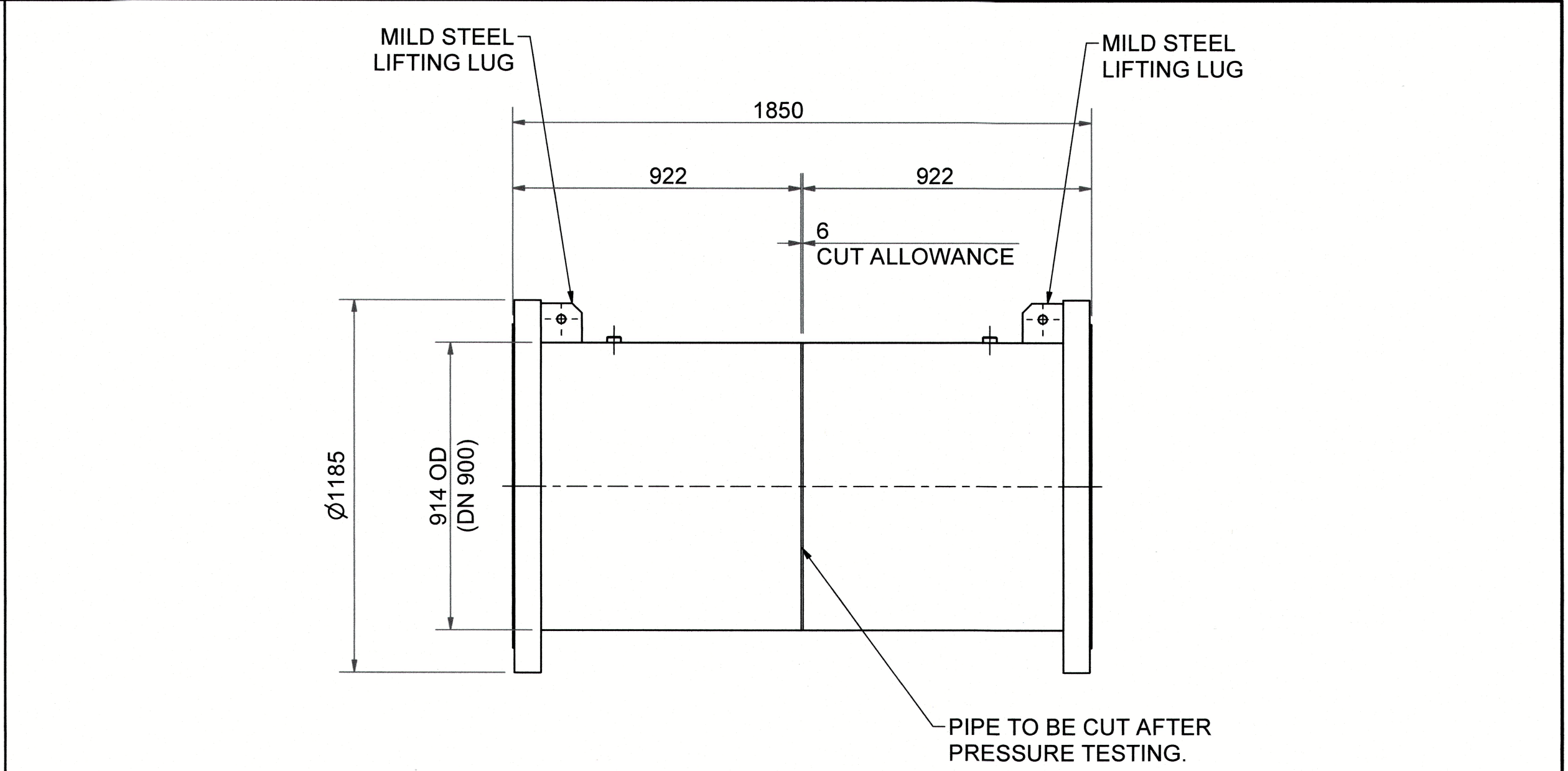
SECTION E-E
SCALE 1 : 10



SECTION D-D
SCALE 1 : 10



DETAIL U
SCALE 1 : 5



PRESSURE TESTING CONFIGURATION: ITEM 2
2-OFF ASSEMBLIES TO BE PRESSURE TESTED
SCALE 1 : 15

WORKING PRESSURE: 2500 kPa
HYDRAULIC TEST PRESSURE: 3750 kPa
PRESSURE TESTING CONFIGURATION MASS: ± 1510 kg
NOTE TO CONTRACTOR:
THE MANUFACTURING FOR PRESSURE TESTING MUST BE COMPLETED AND TESTED PRIOR TO THE CUT AND MANUFACTURING OF ITEM 2.
MANUFACTURING FOR HYDRAULIC PRESSURE TESTING (ITEM 2):
1. MANUFACTURE PIPE THAT IS 2X THE LENGTH OF ITEM 2 AS INDICATED.
2. WELD FLANGES AND LIFTING LUGS ONTO THE PIPE (SEE ITEM 2 DETAILS).
3. AFTER SUCCESSFUL PRESSURE TESTING, CUT PIPE TO THE CORRECT LENGTH (SEE ITEM 2 DETAILS).
4. WELD REMAINING LIFTING LUG AND THRUST RESTRAINT COLLAR TO PIPE PIECES AND CORROSION PROECT.
ITEMS REQUIRED FOR PRESSURE TESTING (ITEM 2):
(ITEMS LISTED BELOW DO NOT FORM PART OF SUPPLY AND DELIVERY BUT ARE REQUIRED FOR SUCCESSFUL PRESSURE TESTING)
2X DN 900 BLANK FLANGES COMPLETE WITH LINE FILLING OFF-TAKE, SUITABLE FOR PRESSURE TESTING TO 3750 kPa .
2X DN 25 (1") PLUGS IN ACCORDANCE WITH ASME B16.11 (CLASS 3000 LB) WITH MALE BSPT THREAD.

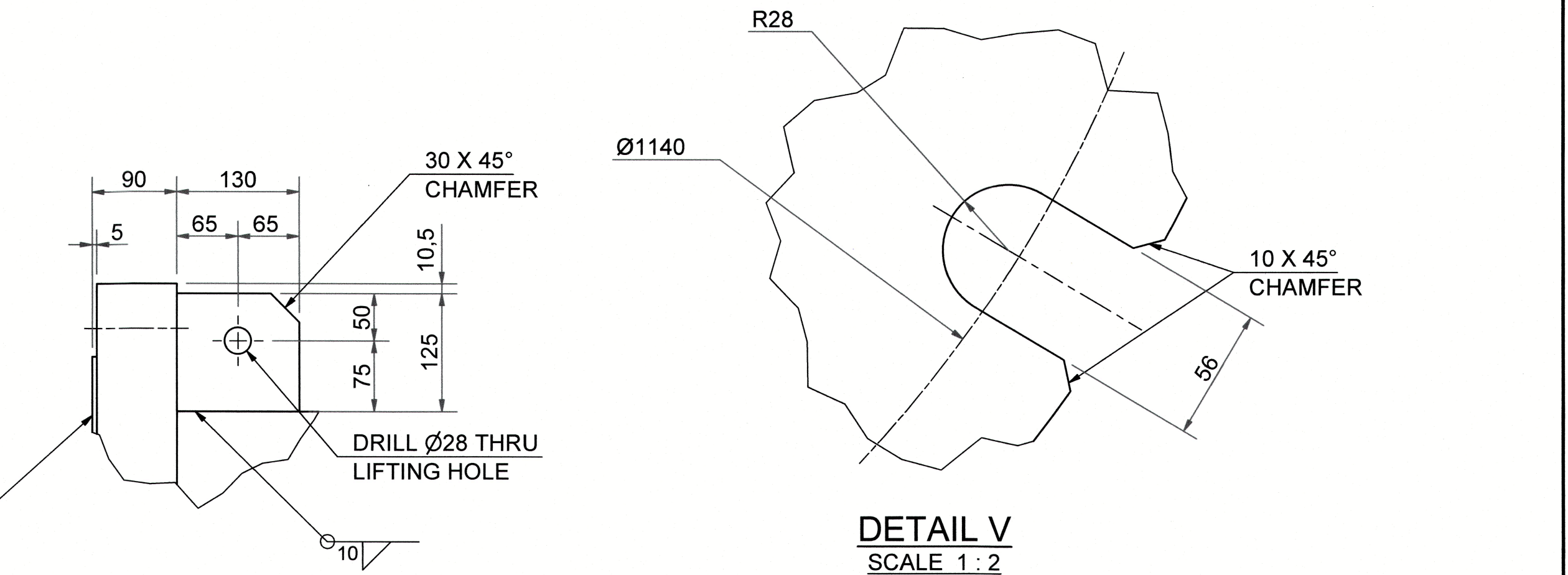
ADDITIONAL NOTES:

FLANGES:
-ALL FLANGES ACCORDING TO EN 1092-1 - PN25 U.O.S.
-FLANGE WELDING TO BS 80 TYPE 6.
-ALL FLANGES SHALL BE RAISED FACE WITH GRAMOPHONE FINISH.
-ALL GASKETS SHALL BE RAISED FACE COMPRESSED FIBRE GASKETS.

CORROSION PROTECTION:
-IN ACCORDANCE WITH DWS STANDARD SPECIFICATION DWS 9900.
-ALL STAINLESS STEEL ITEMS TO BE PICKLED AND PASSIVATED AFTER MANUFACTURE.
-PIPE LINING: APPLY TOW-PACK EPOXY TO 600 µm.
-PIPE COATING: APPLY TWO-PACK EPOXY TO 300 µm PLUS TOP COAT OF RECOATABLE POLYURETHANE TO 50 µm.
-FLANGE FACE: APPLY TWO-PACK EPOXY TO 80 µm.
-PLAIN PIPE END: APPLY TWO-PACK EPOXY TO 600 µm FOR A DISTANCE OF 225 mm FROM PIPE END.
-ALL THREADS TO BE COATED WITH MOLYBDENUM DISULPHIDE LUBRICANT.

GENERAL WELDING NOTES:
-PERFORM NECESSARY WELD PREPS.
-SEAL WELD ALL OPEN INTERFACES BETWEEN PLATE CONNECTIONS.
-IDENTICAL WELDS SYMBOLISED ONCE ONLY.
-ALL WELDS SHALL BE CONTINUOUS FULL PENETRATION WELDS.
-REMOVE WELD SPATTER.
-WELDERS SHALL BE CERTIFIED IN ACCORDANCE WITH ASME IX FOR THE RELEVANT WELDS SPECIFIED.
-WELDING ELECTRODES FOR WELDING MILD STEEL TO STAINLESS STEEL SHALL CONTAIN E309L FILLER METAL IN ACCORDANCE WITH AWS A5.4.

MANUFACTURED DN 25 (1") HIGH PRESSURE STAINLESS STEEL 316 L THREADED HALF COUPLING IN ACCORDANCE WITH ASME B16.11 (CLASS 3000 LB) AS A WELD-ON STUB WITH FEMALE BSPT THREAD.



DETAIL W
LIFTING LUG DETAILS (2-OFF)
SCALE 1 : 5

DETAIL V
SCALE 1 : 2

GENERAL NOTES:			REVISION			DEPARTMENT OF WATER AND SANITATION REPUBLIC OF SOUTH AFRICA			BERG RIVER WATER SUPPLY SCHEME		
GENERAL DIMENSIONAL TOLERANCES (U.O.S.)			REV No	DATE	DESCRIPTION	SIGNED	HEAD OFFICE M/E ENGINEERING PRIVATE BAG X313 PRETORIA 0001	SEDIBENG BUILDING 185 FRANCIS BAARD STREET PRETORIA (012) 336-7500	DRAKENSTEIN PUMP STATION		
DIMENSIONS UP TO 120: ± 0,3 mm			0	07/2024	ISSUED FOR CONSTRUCTION		CHECKED: FRANK DE BEER 13/08/2024 DATE	DESIGN: A VAN SCHALKWYK	DISCHARGE PIPEWORK:		
DIMENSIONS ABOVE 120 TO 400: ± 0,5 mm							ENGINEER: M. KARAKALLA 15/08/2024 DATE	DRAWN: A VAN SCHALKWYK	MODIFICATIONS TO DN 900 DISCHARGE PIPEWORK		
DIMENSIONS ABOVE 400 TO 1000: ± 0,8 mm							EXTERNAL APPROVAL: 2024/08/16 DATE		-DETAILS-		
DIMENSIONS ABOVE 1000: ± 2 mm									PROVINCE: WESTERN CAPE		
FLATNESS & SQUARENESS TOLERANCE: 3 mm/m WIDE									KEYCODES:		
PIPE END ROOT SHALL NOT DEVIATE FROM SQUARENESS TO THE PIPE AXIS BY MORE THAN 1,5 mm									OTHER NUMBER		
OUTSIDE DIAMETER TOLERANCE: FOR PIPES ≥ DN 250: +1,6 -0,8 OVER A DISTANCE OF 150 mm FROM PIPE END.									LOCALITY No.: G100-02		
									DISTRICT: WORCESTER		
									SHEET 3 OF 4		
									REG. No. 181620/24 ME		
									TENDER/ CONTRACT No.		
									DATE: 26/08/2024		
									REV. No. 0		