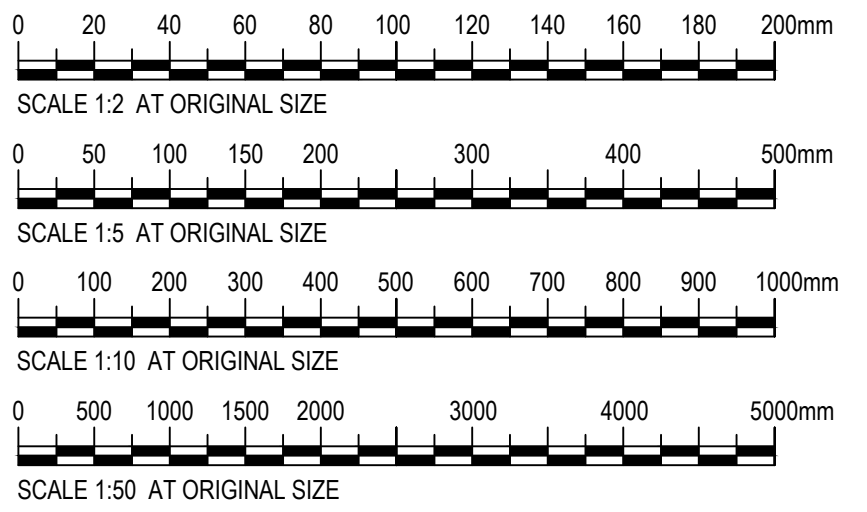
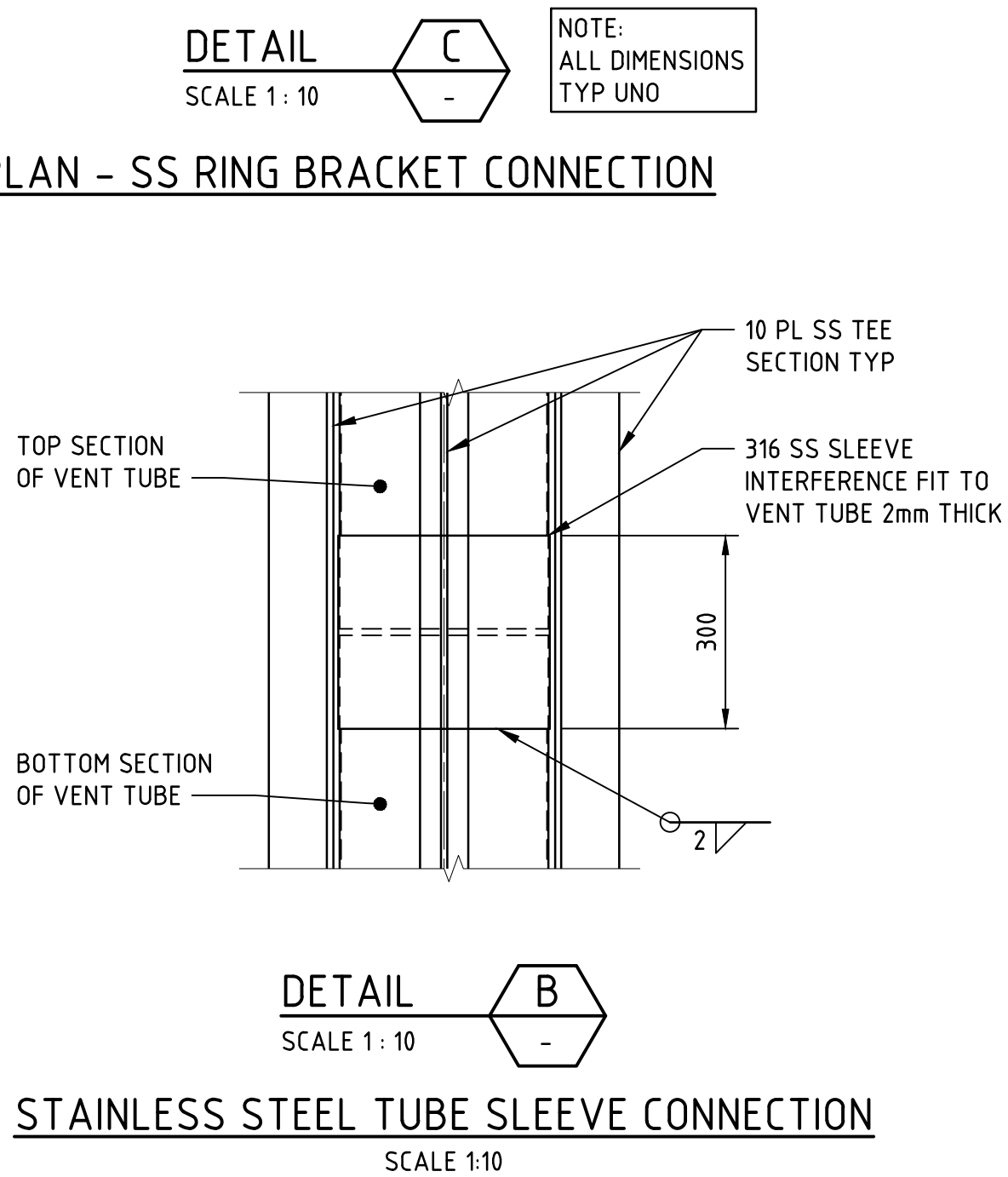
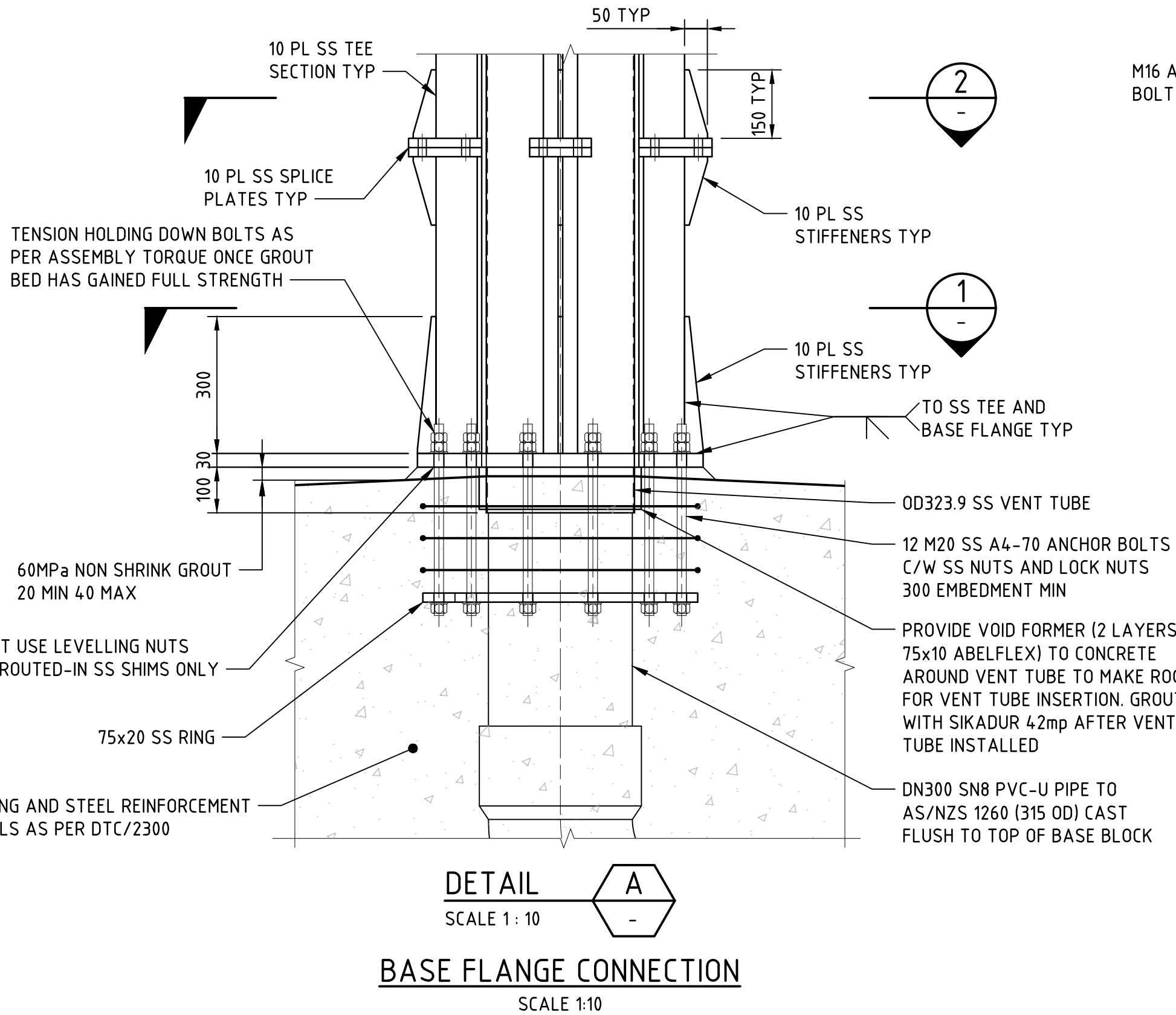
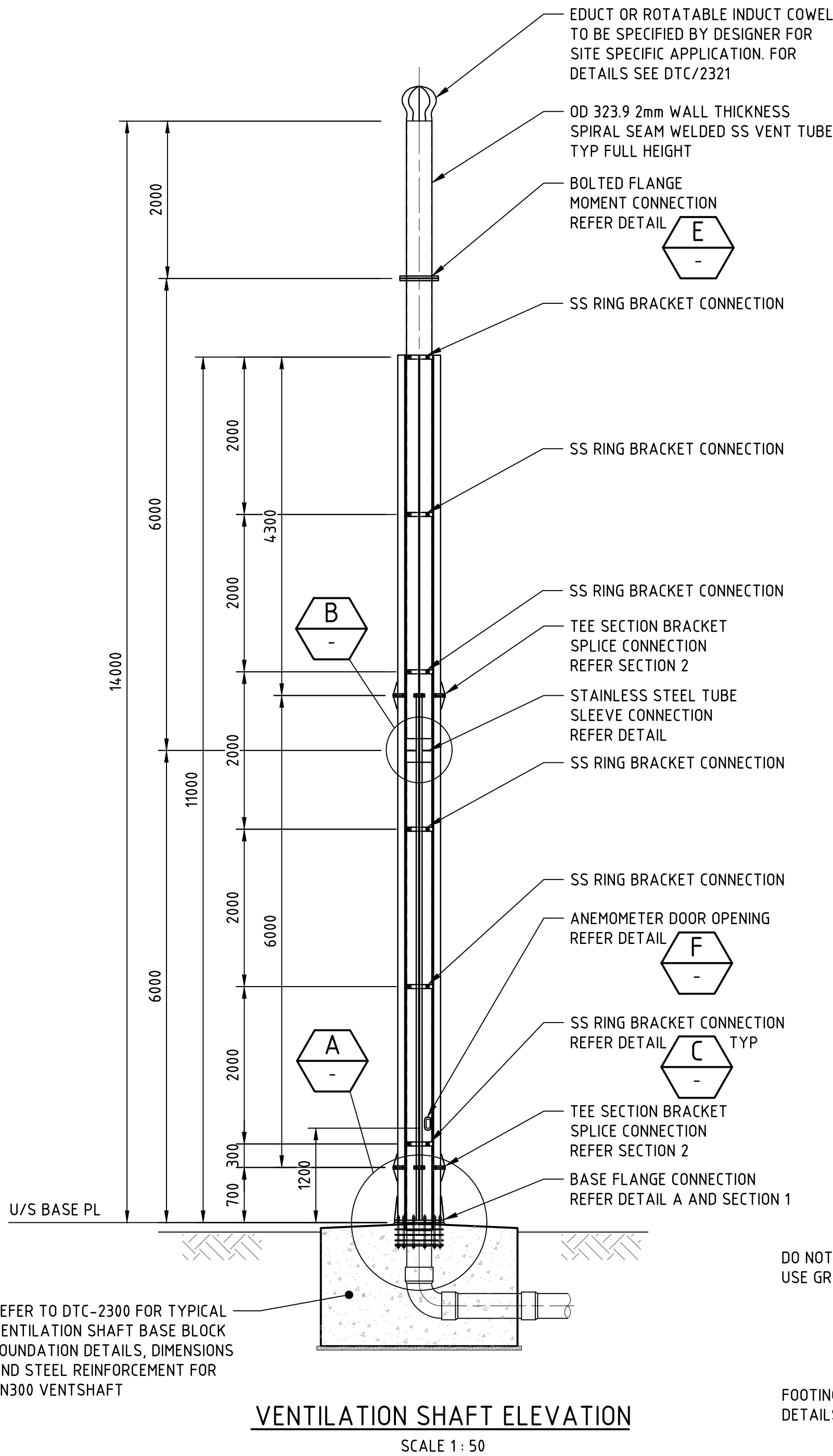
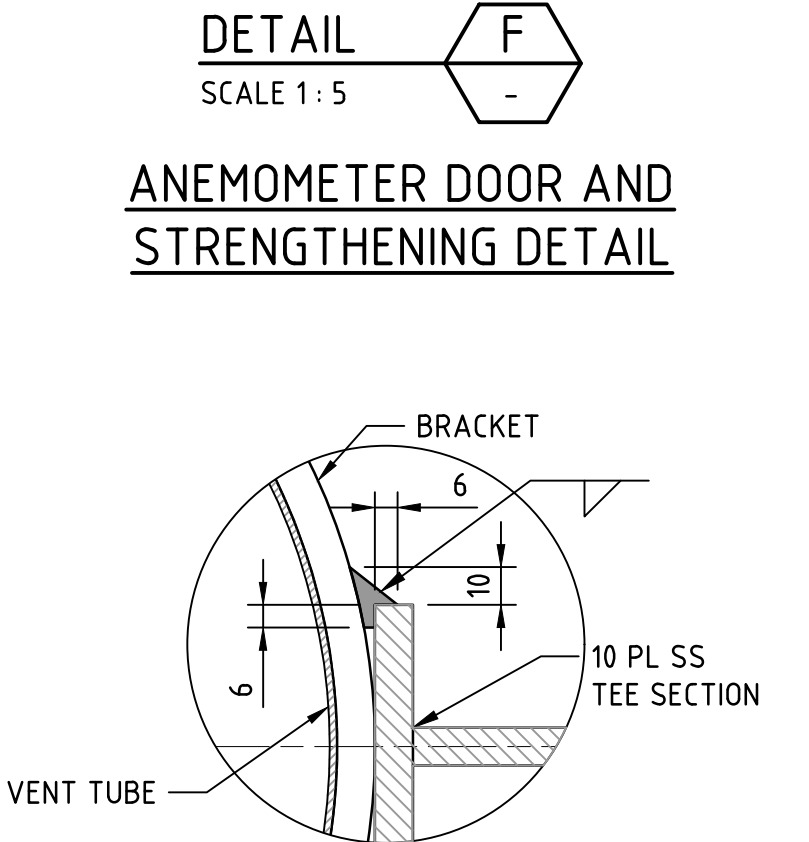
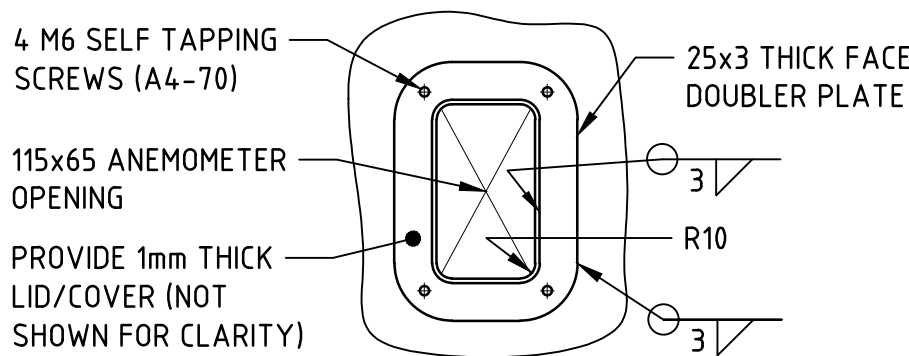
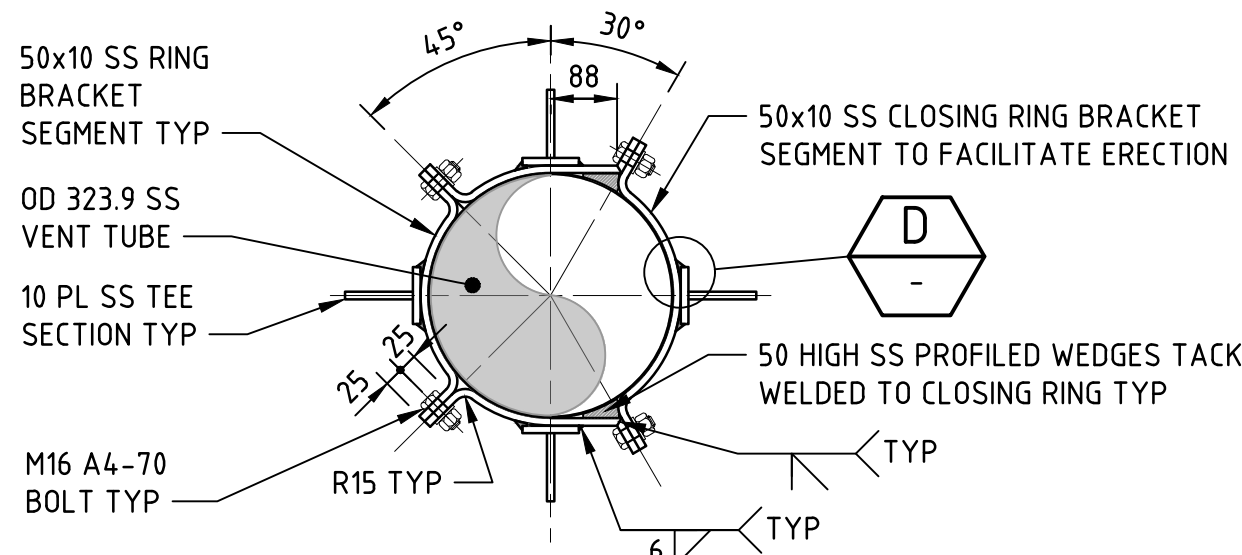
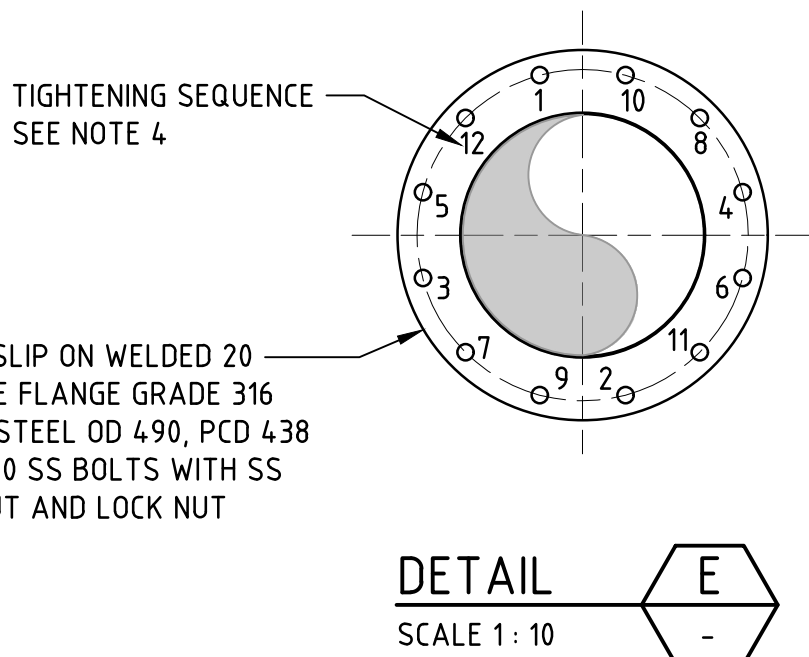
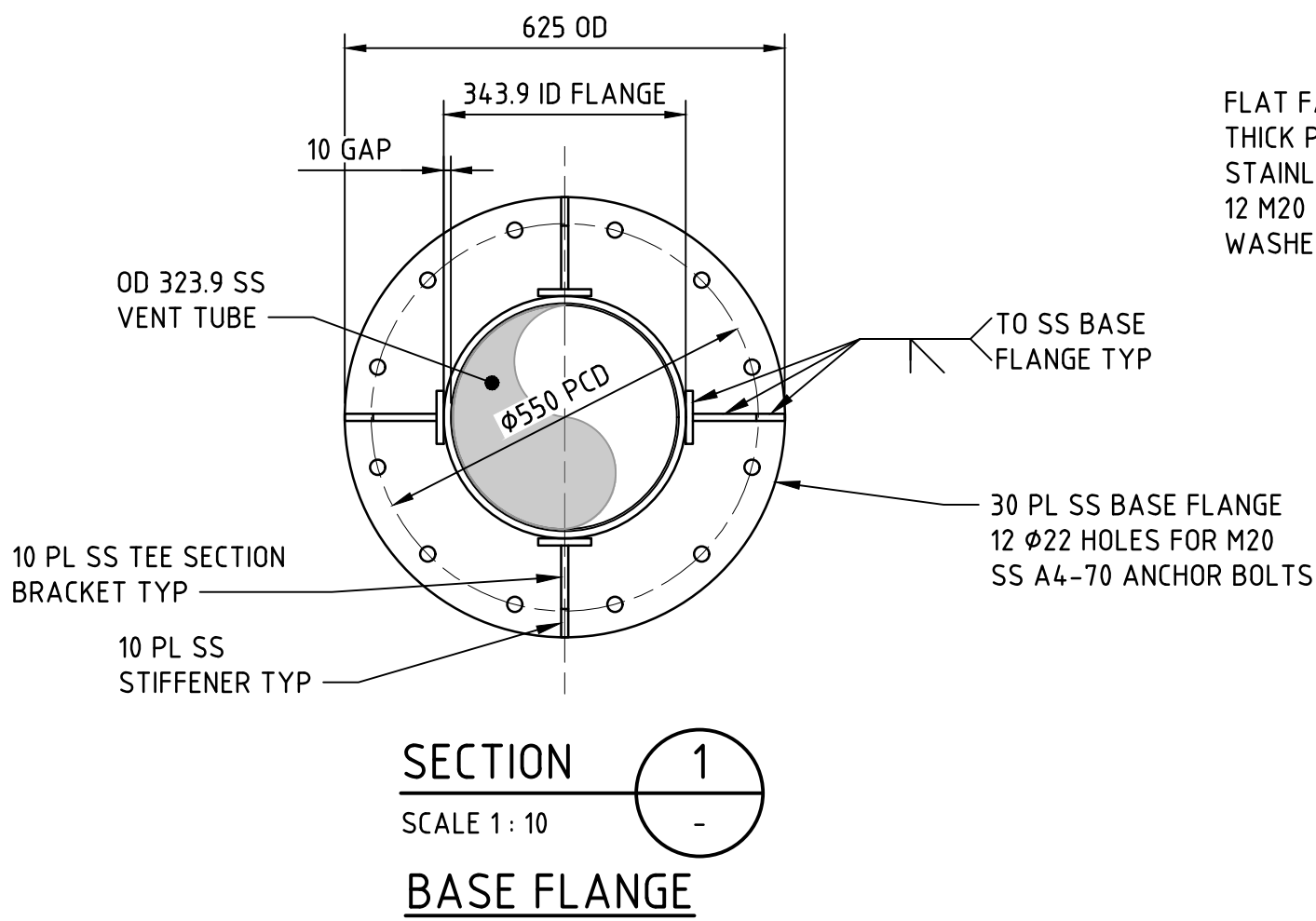
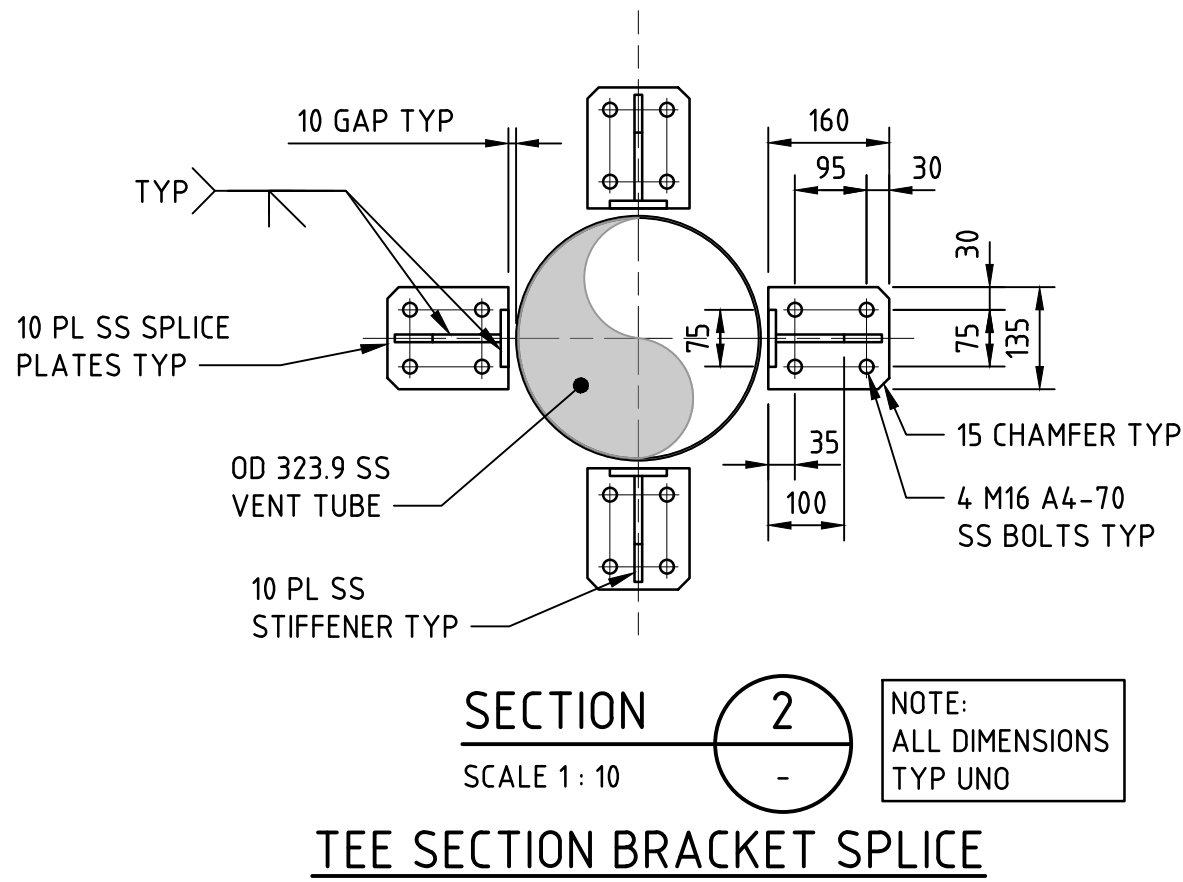


APPROXIMATE VENT SHAFT ITEM MASS	
ITEM	APPROX MASS (kg)
BASE FLANGE CONNECTION	70
6m TEE SECTION BRACKET (TYP PER BRACKET - 4 REQD))	84
4.3m TEE SECTION BRACKET (TYP PER BRACKET - 4 REQD)	62
VENT TUBE BOTTOM SPOOL PIECE	102
VENT TUBE MIDDLE SPOOL PIECE	116
VENT TUBE TOP SPOOL PIECE	52

- NOTES:**
- ALL VENT SHAFTS - CLASS 1 STAINLESS STEEL VENT PIPE SHALL BE TO ASTM A312. ALL STAINLESS STEEL COMPONENTS ARE GRADE 316.
 - ALL BOLTS TO BE GRADE A4-70 AND SHALL BE TIGHTENED AS PER 'TYPE TB' REQUIREMENTS UNO. ASSEMBLY TORQUE M16 = 180Nm, M20 = 350Nm.
 - ALL WELDS SHALL BE FSW TO AS1544.6 UNO.
 - BOLTS SHALL BE TIGHTENED USING A TORQUE WRENCH IN THE TIGHTENING SEQUENCE BELOW. SEQUENCE SHALL BE COMPLETED FIRST FOR 50% AND REPEATED FOR 100% OF FINAL TIGHTENING TORQUE. SEE NOTE 20 ON DTC/2320 FOR BOLT LUBRICATION REQUIREMENTS.
 - FLANGES SHALL BE FACTORY FILLET WELDED TO THE PIPES TO AS 1554.6.
 - ALL WELDS ARE TO BE FACTORY WELDED WITH:
 - SUB-SURFACE (INTERNAL) QUALITY: CATEGORY 1
 - SURFACE (EXTERNAL) WELD QUALITY: CLASS A
 - SURFACE CONDITION: SURFACE CONDITION II-CLEANED AS PER AS/NZS 1554.6 - WELDING STAINLESS STEELS FOR STRUCTURAL PURPOSES. THE ATMOSPHERE WITHIN VENTILATION SHAFTS IS CONSIDERED TO BE CORROSIVE IN REGARD TO AS1554.6.
 - E316LXX ELECTRODES TO BE USED.
 - NON-DESTRUCTIVE EXAMINATION OF WELDS SHALL BE TO AS1554.6 TABLE 7.4 FOR WELD CATEGORY 1A AND ALL FLANGE WELDS SHALL BE EXAMINED BY LIQUID PENETRANT OR RADIOGRAPHY/ULTRASONIC.
 - ALL WELDS ARE TO BE FACTORY PICKLED AND PASSIVATED IN ACCORDANCE WITH ASTM A380.



A	ORIGINAL ISSUE		N.S.	13.03.25	
LETTER	DETAILS OF ISSUE / AMENDMENT		APP'D	DATE	