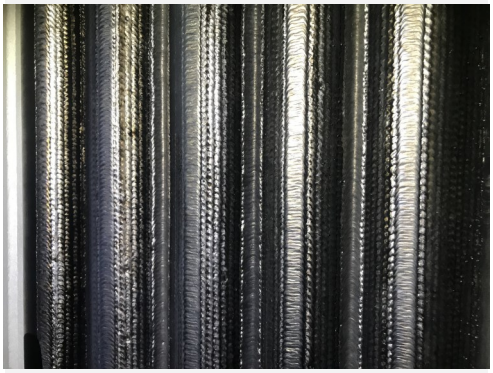

Tekniska Verken Linköping

LINKÖPING, SWEDEN — ON SITE INCONEL CLADDING—P3 KV1

Project Description:

VODA's scope of supply was project management, engineering, design, purchasing, construction and documentation for on-site Inconel cladding (Inconel 625) at boiler panel walls on an existing waste to energy fired boiler, Boiler 3, KV1, Tekniska Verken in Linköping.

The cladding was performed in the bottom part of the furnace/1. pass including , including part of the rear, left, right and front wall.

The cladding area was approx. 260 m^2 extended area. The Inconel cladding was performed according to:

- EN 12952
- PED 2014/68/EU
- EN-ISO 15614-1 and 7
- VdTÜV-Merkblätte 1156

Panel walls material P235GH, Tube 60,3mm, Pitch 80mm.
Cladding with Inconel 625 (2.4831) Thickness 2mm, minimum 50% overlapping.
Fe content for automatic process <8%
Fe content for semi automatic and manual process <10%
Vertical panel walls was cladded by robot. Corners and areas around bend outs was cladded with semi-automatic and manual processes.

After the cladding NDT was performed, 100% PT on all start and stops (top and bottom) and 2% of the total cladded area.

Client: **Tekniska Verken Linköping AB**
Project No: 210.214
Year: 2019

Milestones:
Contract: 25-06-2019
Production start: 20-07-2019
Start on site: 23-07-2019
Boiler ready for start-up: 21-10-2019

Data:
Fuel: Waste wood
Steam Temp: 475 °C
Steam Pressure: 56 bar

VODA™

VODA A/S
Fuglesangsalle 16, 6600 Vejen
Tlf.+45 7240 7465
info@voda.dk—www.voda.dk