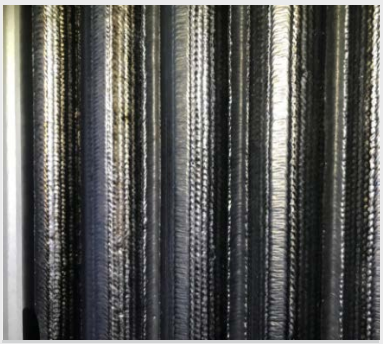
Tekniska Verken i Linköping AB

LINKÖPING, SWEDEN – ONSITE INCONEL® CLADDING

PROJECT CASE HISTORY



Project description

Babcock & Wilcox Renewable Service scope of supply included project management, engineering, design, purchasing, construction and documentation for onsite Inconel® cladding at boiler panel walls on an existing waste wood-fired boiler (Line 3) in Linköping, Sweden.

The cladding was performed in the bottom portion of the first pass, including part of the rear, left, right and front walls.

The cladding area was approximately 260 m^2 (extended). The Inconel cladding was performed according to:

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

- Panel wall material P235GH, tube diameter 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 were cladded by robot. Corners and bent tubes were cladded with semi-automatic and manual processes.
- After cladding, testing included NDT, 100% penetrant testing on all start and stops (top and bottom) and 2% of the total cladded area.

Client: Tekniska Verken i Linköping AB
Year: 2019

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

Data
Fuel: Waste wood
Steam temp: 475 °C
Steam pressure: 56 bar

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