

RAWMILL TRUNION HEAD CRACK REPAIRING

Job description	: Rawmill inlet trunion head crack repair
Parent equip & age	: Raw mill 25yers
Capacity of mill	: 150tph
Dia of mill	: 4600mm
Dia of trunion	: 1800mm
Thicknes of trunion	: 280mm
Cost of trunion	: 2.3crores
Length of crack	: 4500mm
Depth	: 120mm
Width:	: 90-100mm

Core Activites

- C-Clamps were welded along the crack ,on the outer periphery of the trunion head.
- Total weight of mill was decreased by lifting the mill by hydraulic jack.
- Total crack was divided into 9 parts each 500mm.
- Material was removed by using air gouging.
- Preheating up to 150 deg cent. Have done
- Welding was started at the two ends of crack simultaneously.
- Root run strated with 800ELH ,3.15mm.
- Two layers of welding over the root run & one layer side walls of the V groove.
- SS tube inserted over the root run, which is having the dia of 12mm & wall thickness 4mm.
- Joining of SS tube by using 925-4mm.
- Complete buildup of V-groove was done by using Superaloy-1770-3.15mm & 4mm.
- After completion of welding stiffners were provided on the welded portion.
- Post Heating up to 550 Deg Cent have done.
- Finally Ultrosonic Test have done



COST ANALYSIS: Total Material Consumption

Diffusaloy 800ELH	: 40 Kgs
Diffusaloy 925	: 25 Kgs
Superaloy 1770	: 100 Kgs

Total Cost Of Electrodes is 8.2 Lacks. Cost of New Trunion is 2.3 Crores Job completed in 7 Days.

Since last 3 months the repaired crack is found intact and till date, 2,40,000 production have taken successfully.

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