

DATE 22-12-03

SHIFT B

GROUP COMBINATION

PRESENT S/R : MSS, AKY, RRC, JSD, SPY, AG, JS, RKJ, KKM

ABSENT/LEAVE S/R : TKG, SKM

SHIFT CHANGE : JS (R54), KKM (RGS)

O.T/C.O. : N/A

PRODUCTION/CONSUMPTION FIGURES

DESCRIPTION		FOR THE SHIFT	REMARK
FT-104 Reading (11/21)	M ³	448131 / 425142	CDR → 8.8 T/hr
FT-104 A Reading	M ³	5534895	CO ₂ & HG → NJ
Amm. Avg Temp	°C	0.8	
Amm. Draw (FT-104A)	Te		
Amm. Draw (A.P.)	Te	472	
Cold Amm. Draw	Te	8.474	
Total Amm. Draw	Te	480.474	
Urea Prod as per (FT-104A/P)	Te	—	
Change in Stock	Te	(-) 3.276	
Ammonia Stock	Te	1351.507	
K.S. Draw (11/21)	Te	369 / 401	
L.S. Export	Te	181	
H.S. Export	Te	51	
Boiler Load	Te/Hr.	53.5 / 44.37	

OPERATING CONDITIONS

DESCRIPTION		UNIT-11	UNIT-21	PROCESS CONDENSATE			
MV-1 Pressure	KG/CM ²	145.5	145.5	Time	Amm.	Urea	Alk
R-1 Bot/Outlet Temp.	°C	177.5/189.7	176.5/190	15.00	1.8	—	5.4
E-1 Out. Temp.	°C	208	208				
P-1 A/B	RPM	87	82				
P-2 A/B	AMP	70	68	PRODUCT QUALITY			
V-1 /V-3 Level	%	64 / 23.9	67 / 24.1	Time	Biu.	Moist	O.Size Fines
11V-5/V-6 Level	%	37.2 / 47		15.00	1.00	0.35	3-7 0-50
Steam Flow to 11 C-2/R-2	Te/Hr.	9.2 / 6.3		19.00	—	—	7.6 0.40

PUMP IN LINE

PUMP	P-1	P-2	P-3	P-4	P-5	P-7	P-8	P-17	P-21	P-24	P-27	P-37	P-38	K-2	P-54	P-55
UNIT-11	A	A	A	B	A	B	A	A	B	B	B	B	—	A	A	A
UNIT-21	A	B	B	A	B	B	B	B	A	A	A	B	—	A	A	B
PUMP	P-6	P-10	P-13	P-14	P-15	P-16	P-18	P-22	ME-8	Bucket No.	W/T	P-26, P-9B				
Common	B	B	B	A	B	B	B	B	B	9B-113	H/O					

11/21 H.V.-102 FLUSHING	☒	11/21 P-2 A/B OIL Centrifuging	☒	11/21 Stand By P-8 Free	☒
11/21 K1 Ist Suction Catch Pot Draining	☒	11/21 Stand by P-2 Flushing	☒	11/21 Stand By P-54 Free	☒
11/21 MV-25 Oil Draining	☒	11/21 MV-6/MV-7 Torr flushing	☒		

Abdul Kalam

11- UNIT

- Running normal normal @ 120% load.
- TK-1/K-1, P-1A and P-2A are in line and normal.
- HP/MP/LP/VPC/Vacuum sections are normal.
- P-17A crank case oil make up done.
- P-54B tripped at 19.06 hrs. P-54A taken in line at 19.08 hrs. MV-6/MV-7 vacuum was break in the mean time. HP drilling was diverted to V-5 from 19.08 to 19.20 hrs due to this reason. AKL, JS, AG, KKM handled the situation.
- AVI issued to E/M to check the reason of tripping of MP-54B. As per E/M pump was tripped due to MP-54B control fuse blown problem. Pump (P-54B) shaft was found free. P-54B is isolated and flushed. T/E/E/M job is U/P.
- MP-54A field current indication is stuck up at 49 amp current checked in substation found 24 amp. AVI issued to E/M to check mismatching.
- MP-54B control fuse replacement job is U/P.

21- UNIT

- Running normal @ 120% load.
- TK-1/K-1, P-1A and P-2B are in line and normal.
- HP/MP/LP/VPC/Vacuum sections are normal.
- LT-608 operation is normal.
- K-2A oil make up done.
- AVI issued to attend P-1A C.T. side seal packing outer line union leak. As per M/M it will be attended when P-1A will be standby.
- Side side and C.T. side P-1A LP packing dropwise water leak observed. AVI issued to M/M. Not attended.
- P-54B (standby) shaft was not free. Pump flushed. Now shaft is free.
- P-54A bearing oil make up done.

Common Section

- PCT is running normal. P-17/P-18 disks are being continued in DMP.
- MT-1/MT-3 C-S. dust dislodged.

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- MV-1 H₂ gas PSV LS injection valve, E-1 H₂ gas PSV LS to jacket both are passing.
- P-55B to be tested in presence of N₂.
- // - V-7 air sample to be analysed for manometry.
- // - Production interrupted as P-54A left load. Pump drained, vented and again taken in line.

COMMON

- PCT is running normal. P-13/P-18 discharge is being continued at DMP ends.
- P-13/P-18 discharge water are being taken in DMP directly to filter by passing Tank T-950 & pump P. 950A/B. Due to this reason LV-164 opening is increased from 21% to 50%. & by pass of LV-164 is opened by 1 turn. In case P-18/P-13 discharge flow to DMP is restricted inform to DMP CR & R-3 for corrective action. Rough sketch is attached.
- C-2/P-2/V-8 PSV LS & LC taken in line. No passing of PSV found. V-8 PSV. LS valve is passing heavily.
- // - P.L. go through the restriction of DMP.
- // - Silo diversion to be avoided in view of stock checking.
- // - Man cooler to be shifted to electric wps for maintenance.
- ✓ // - H₂ pressure is 35 kg/cm².
- ✓ // - PV-180 gland is leaking. To be attended.
- ✓ // - Flood light inside P.T. is off.
- Light near MT-3 C-5 is very poor. Bulbs to be checked.
- P-18

Alekhargam

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PRESENT :
ABSENT/LEAVE :
SHIFT CHANGE :
O.T./C.O. :

PRODUCTION/CONSUMPTION FIGURES

DESCRIPTION	FOR THE SHIFT		REMARKS
	M ³	M ³	
FT-104 Reading (11/21)			
FT-104 A Reading			
Amm. Avg. Temp.	°C		
Amm. Draw (FT-104A)	Te.		
Amm. Draw (A.P.)	Te.		
Cold Amm. Draw	Ta.		
Total Amm. Draw	Te.		
Urea Prod. as per (FT-104A/A.P.)	Te.		
Change in Stock	Te.		
Ammonia Stock	Te.		
K. S. Draw (11/21)	Te.		
L. S. Export	Te.		
Boiler Load	Te./Hr.		

OPERATING CONDITIONS

DESCRIPTION	UNIT-11		UNIT-21		PROCESS CONDENSATE		
	KG/CM ²	°C	°C	RPM	AMP	%	%
MV-1 Pressure							
R-1 Bot./Top Temp.							
E-1 Out. Temp.							
P-1 A/B							
P-2 A/B							
V-1/V-3 Level							
11 V-5/V-6 Level							
Steam Flow to 11 C-2	Te./Hr.						
Steam Flow to 11 R-2	Te./Hr.						

PUMP IN LINE

PUMP	P-1	P-2	P-3	P-4	P-5	P-7	P-8	P-17	P-21	P-24	P-27	P-37/38	K-2	Any Other Pump
UNIT-11														
UNIT-21														
PUMP	P-6	P-10	P-13	P-14	P-15	P-16	P-18	ME-8	Bucket No.	W/T				

- CONSUMPTION
- H₂O. Present & arena is available in 4707, Page 303.
 - CO₂ compressor taken in partial venting as due to mal of LV-540 and ejection of load in PS4A Control valve taken in H₂O and open, Plant normalised after 15 minutes.
 - PET is running normal. P13/P18 disch. are being consumed in DM plant.
 - F1-B clearing not done as it was done yesterday.
 - SUT issued to M/M to attend P11A Pumping leave. M11A kept de-energise.
 - SUT issued to M/M to take measurement of 11/21 in support of 11/21 ME3 to V-5 line above P4A/B.
 - SUT issued to M/M for F1-1A/B back flushing line modification job. Job O/P.
 - V-5 Recovery remain in line towards 21 Unit.
 - TX-246 c/o to TX-247. 11/21 Pulling diverted to V-5 from 11:31 to 11:41 this due to Bucket c/o. AVI issued to M/M to drop TX-246 (stand by) bucket for clearing.
 - Return line got flush.
 - TX-246 bucket dropped. To be cleared.
 - P19B yet to be normalised. AVI issued to M/M.
 - M11/M13 C.S. dislodged.
 - Pulling was diverted to silo from 8:20 to 8:24 for side adjustment and again diverted to silo from 11:31 to 11:41 due to Bucket c/o.
 - Pulling was diverted to silo from 8:28 to 8:33 H₂O due to fill size adjustment.

11- UOII

- Unit is running normal at $\approx 120\%$ load.
- TK-1/K-1/P-1B/P-2A are in service
- H-E-5 drain line is clear. R-1 drain line is choked, tried to de-chuck. But didn't. R-1 drain line is chock in the U/S of HV-4. So two no. of steam hose laid to reach the line. to be cleared.
- P-12A is energised
- $1\frac{1}{2}$ K-1 1st $8\frac{1}{2}$ Str² Cond. Catch pot drained
- $1\frac{1}{2}$ MV-25 drained, no oil found.
- $1\frac{1}{2}$ HV-102 flushed.
- E-1 weep hole no 18 nozzle flushed & cleaned.
- || P-2B oil analysis to be done as ~~for~~ ~~of~~ NH₃ & ~~also~~ from in the water coming out of centrifuge.
- CO R load remains 8.8 Te1
- CO₂ in VG at 14.00/18.00 hrs is 2.17/1.85 % respectively.
- HP/HP/LP/Vac. normal.
- || E-5 block & bleed drain YV is defective i.e. it opens suddenly to be attended during S/D. Inform to Sr Mgr (Incs).

21- UOIP

- Unit is running normal at $\approx 120\%$ load.
 - TK-1/K-1/P-1B/P-2A are in service
 - R-1/E-5 drain line flushed and filled with water.
 - HP/HP/LP/Vac. normal
 - P-54A started cavitating, as a result of that - PV-3 was taken on vent - It 15 min. in order to reduce level
- COMMON

- P-9 is running normal. P-13/P-18 dish. are being consumed in DUF.
- P-17A dish flange leak attended.
- P-9 H/B dish line drain capped.
- || MT-1 cyclone separator $8\frac{1}{2}$ line from MT-1 broken from nozzle. to be attended.
- FL-1B cleaned & boxed up.
- P-9B $8\frac{1}{2}$ Str² cleaned & boxed up.
- Lab has reported high TAN. Dilution of UOIL is going on.

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