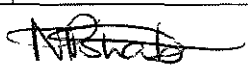

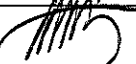
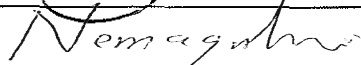


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PLANT AREA. Unit 1-6 Soot blowers					
TITLE: SOOT BLOWERS MAINTENANCE SOW					
REF. MEB-053000	Reference Rev No:1		MULTIDISCIPLINARY: No		Plant Level
COMPILED BY	Name NP Tshabane System Engineer	Signature: 	Date: 2021-04-28		
APPROVED	Name: John Makuleka Line Manager	Signature: 	Date: 28/04/2021		
REVIEWED	Name: Lele Masote Engineering Group Manager	Signature: 	Date: 28.04.2021		
REVIEWED	Name Quality Department Tshamano Nemaguvhu	Signature: 	Date: 29.04.2021		
REVIEWED	Name: Shapen Ramaboea Environmental Department	Signature: 	Date: 28.04.2021		
ACCEPTED	Name Outage Manager/Maintenance Manager	Signature: 	Date: 2022.11.01		
ACCEPTED	Name. AIA	Signature	Date		

NB: Do not tamper with the template.


GENERAL

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- Data books, reviews, reports and diagrams/drawings shall be submitted to Engineering after the completion of the work. Engineering to forward the data books to Quality Department (Document Control)
- All QCP's to be submitted to Engineering and Quality for approval prior to outage/project or maintenance work commencement.


	SCOPE OF WORK DESCRIPTION / ACTIVITY	PROCEDURE, SPECIFICATION, ENG. REQUIREMENTS / DOCUMENTATION		HOLD POINTS, WITNESS, REPORTS	RESPONSIBLE PARTY
1.1	Safety	<ul style="list-style-type: none"> • All work is to be done in accordance with Matla plant procedures and safety regulations. (GGR 0992) • Matla power station induction must be done before any work commences. • Permit to work must be in place before any work commences. • Worker's register must be completed and daily risk assessment conducted before any work commences. 		Eskom to witness.	Contractor
1.2	Environmental Management	<ul style="list-style-type: none"> • All activities listed in the National Environmental Act 107 of 1998, EIA Regulations as amended, must have environmental AUTHORISATION before commencement of work. • The contractor shall comply with all applicable legal and other requirements. 		Eskom to witness.	Contractor

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		<ul style="list-style-type: none"> The polluter pays principle will be applied. The contractor manager shall ensure compliance with Eskom Matla Environmental procedures to ensure the prevention of pollution (refer OMOP 4090 and 4402). The last payment will be processed based on the status of the last housekeeping check sheet (Annexure C: OMOP 4402) of designated area EMS file based on ISO14001 will be required 			
1.3	Quality Management	<ul style="list-style-type: none"> The contractor/executioner of work will be responsible for drawing up all QCP documentation and this must be approved by engineering and authorised by the Quality Department before commencing with the work Contractors/executioner to adhere to QM 58 and OMOP4497 requirements Number of NCR issued can affect your next tendering process. The QCP shall be signed progressively by the Engineer/Supervisor, Eskom QC Inspector, Contractor QC Inspector and/or AIA No procuring of outage items without the approval of scopes by 		Hold point	Contractor
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		quality <ul style="list-style-type: none"> All outage scopes creep and scopes addition should be approved by quality No contractor should be in the possession of scopes for execution without the scopes approved by quality The contractor is subjected to quality auditing at any point in time during execution of scope 			
1.4	Inputs from other departments				
1.5	Commissioning reference				

Scope of Work


	SCOPE OF WORK DESCRIPTION / ACTIVITY	PROCEDURE, SPECIFICATION, ENG. REQUIREMENTS / DOCUMENTATION	HOLD POINTS, WITNESS, REPORTS	RESPONSIBLE PARTY
2.1	General (Scope Boundaries):			

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<p>The scope refers to the provision of the mechanical maintenance at Matla Power Station for the boiler Sootblower system. The contractor shall be expected to perform routine mechanical repairs and inspection in accordance with the details indicated below.</p> <p>There are 54 Sootblowers installed on each boiler at Matla Power Station. Each Sootblower consist of the following main components per boiler:</p> <ul style="list-style-type: none"> • 54 x Poppet valve • 108 x drive chains • 54 x sleeve • 54 x lance <p>The sootblower system starts from the poppet valve flange and inclusive of all sootblower components (including sootblower supporting structure) up until the wall box and includes the sootblower sleeve. At the Airheater, the system also includes the rack and nozzle mechanism inside the Airheater. The scope will cover the front gas pass, rear gas pass and air heater sootblowers.</p> <p>The contractor shall be required to perform routine mechanical repairs and inspections in accordance with the maintenance strategy. The contractor will perform the following maintenance tasks:</p> <ul style="list-style-type: none"> • Routine Maintenance Tasks: These tasks are in accordance with the Matla PM system. This particularly refers to all the PM's relating to sootblowers. • Daily Inspections: The contractor shall perform daily visual inspections on the soot blower system, noting any mechanical damage to any part of the system. These notes shall be submitted in a report to the relevant System Engineer and Eskom Maintenance Supervisor. 			
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	<ul style="list-style-type: none"> • Opportunity Outage Maintenance: These will be defects which cannot be attended to while the boilers are on load. These outages may also be over weekends and thus sufficient staff must be organized. • Operating Assistance: The contractor shall ensure that a reasonable number of people are available to ensure that there is always assistance with mechanical issues on the system while a unit is being blown 			
2 4	<p>Constraints on Performing Work on the Soot Blowers System:</p> <p>The contractor shall take his/her own permits as per the plant safety regulations and the permit to work system. He/she will have a responsible person on each shift and on standby. The contractor will be responsible for his/her own transport. No passengers will be allowed to be transported on the back of an LDV even if fitted with a canopy.</p> <p>The contractor is further expected to liaise on a daily basis with the Matla maintenance supervisor to plan his work so as to optimize the availability of the plant. The contract will have representation in the maintenance meeting as well as in the plant focus meeting.</p> <p>The contractor shall provide at least two persons at all times on each shift and one on standby who is authorized as a Responsible Person according to the Plant Safety regulation & High Voltage Regulations respectively for accepting of Plant Permits</p>			

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	The contractor shall conform to all rules and regulation applicable to Plant Safety & High Voltage Regulations and shall complete the Workers Register prior to working on the plant.			
2.5	<p><u>Maintenance Tasks</u></p> <p>The contractor shall perform maintenance tasks as per the PM's set out in the SAP system. These shall be performed during the required durations. It is important that all activities are signed off as per Matla Procedures. When the contractor isn't performing the routine maintenance tasks then the contractor shall be required to perform routine inspections on all the boilers. All defects noted shall be reported in the following matters:</p> <ul style="list-style-type: none"> • Reporting to plant operator to create a defect on the SAP system • Reporting defect to the maintenance supervisor to create defect on the system • Creating a defect on the SAP system <p>These defects shall be assigned to the contractor to correct. The contractor shall also advise as to when a defect can be performed online and when they cannot. All inspection reports will be signed off by the System Engineer and the Supervisor</p> <p>The contractor shall also be required to perform work during planned outages. These outages are known as IR (Interim Repairs), MGO and GO (Overall). The contractor shall ensure that the activities shown in Appendix C are performed. The work required for IR shall be the inspection and replacement (when required) of the following critical components</p> <ul style="list-style-type: none"> • Poppet valve, including air relief valve: Visual and MPI inspections. 	QCP to be submitted		

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<ul style="list-style-type: none"> • Feed tube • Lance and nozzle • Front support rollers • Limit switches • Expander cable <p>The above mentioned activities shall be performed on all sootblowers and inspections reports shall be submitted to the System Engineer and Maintenance Supervisor. All work coming from the reports shall be accompanied by a QCP. During a GO all sootblowers shall be dismantled and all wearing parts shall be inspected and replaced (when required). This shall apply to the following</p> <ul style="list-style-type: none"> • Seals • Packing and lubricants • Wall sleeves and supporting steel work should be checked • All soot blowers should be inspected to check if they are traversing correctly and are correctly aligned in relation to the elements so that all the danger of soot blower erosion of the elements can be avoided <p>The required work will be accompanied by an approved QCP. Any additional work required will be communicated to the contractor through a SOW.</p> <p>All work which the contractor does shall be accompanied by a QCP which will be approved by the following parties</p> <ul style="list-style-type: none"> • System Engineer • Maintenance Supervisor 			
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	<ul style="list-style-type: none"> Eskom Quality Personnel <p>The above mentioned will have points in the QCP where they can have intervention points and the contractor will have to ensure that they call each party in time to witness certain activities.</p>			
2 6	<p><u>Personnel and Work Execution:</u></p> <p>The contractor shall ensure that as a minimum, the following personnel numbers are allocated to Matla Power Station for the duration of the contract</p> <ul style="list-style-type: none"> 6 qualified mechanical fitters 6 Assistance fitters 1 Supervisors 1 Safety Officer 1 QC Inspector 1 Rigger <p>All man hours, staff used, material used, corrective actions taken must be recorded and submitted to the relevant maintenance Matla supervisor on a monthly basis. Copies will be submitted to the System Engineer for amending the maintenance philosophy when required</p> <p>The contractor shall ensure that the required number of personnel are authorised to take permits for performing the work on Matla Power Station as highlighted in section 3.3</p>			
2 7				

Bill of Material


	Full description Material/Spares/Equipment	Specifications of Material/Spares/Equipment	Stock No	Part Number	Required Quantity
3 1	Eskom to supply spares.				

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Scope Compilation References				
SOURCE & Ref No.	Yes	No	N/A	Comments
Previous outage service reports			x	
Return to service data packages			x	
Maintenance Strategy with Rev number			x	
SAP defects (attach list as appendix)			x	
GHRMS (STEP) reports(Generation Heat Rate Management System)			x	
Online Condition Monitoring			x	
Pre-outage performance test results			x	
Post outage performance test results			x	
GPSS/ Plant Performance data on UCLF incurred			x	
OMS / IIRMS recommendations (Audits Reports)			x	
Risk controls (IRM system)			x	
Previous audits and reviews (e.g. ERAP)			x	
LOPP strategy reports			x	
URS			x	
Philosophy (Outage)			x	

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Condition Monitoring Report	X			
Corrective Actions			x	
Statutory Requirements			x	
Previous Outage SOW variations			x	
Post Mortems Actions from previous outages			x	
Pre-Outage plant walks	x			
Risk based inspection (RBI) report			x	
Simulation, TOIs, OON, SI			x	

COMMENTS

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Compiled by: Nolitha Tshabane

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Appendix A: Maintenance Strategy Outline

<u>Components</u>	<u>Functional Importance (C/NC/RTF)</u>	<u>Parts</u>	<u>Failure Mode</u>	<u>Strategy</u>	<u>Frequency (W/M/Y)</u>
Beam arrangement	RTF	Rack	Corrosion	Inspections	Y
			Wear	Inspections(backlash)	Y
		Casing	Corrosion	Inspect coating	Y
		Support lugs	Weld Cracking	Visual Inspection	Y
Carriage assembly(Gearbox)	C	Casing	Cracking	Visual Inspection	M
		Gears	Wear	Inspections(backlash)	M

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		Shafts	Wear	Internal inspection	M
		Seals	Leak	Visual Inspection	M
		Bearings	Seize	Inspect oil level	M
			Wear	Internal clearance inspections	M
Expander cable assembly	C	Cable support pin	N/A	Inspection	M
		Support bracket	Crack	Inspection	M
Feed tube	C	Tube	Crack	Inspection	M
		Gasket	Leak	Visual Inspection	M
Lance joint and packing assembly	RTF	Gland packing	Leak	Visual Inspection	Y
		Gland follower	Corrode	Inspect coating	M
Steam control assembly	C	Linkage rod	Break	Visual Inspection	M
			Bend	Inspections	Y
		Lever	Break	Inspections	M
			Bend	Inspections	M
Poppet valve	C	Air relief valve	Pass	Inspections	W
			Seize	Inspections	W
		Valve casing	Crack	Inspections	W
			Erode	Inspections	W

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		Valve stem	Wear	Internal inspection	W
		Valve seat	Wear	Internal inspection	W
		Spring	Break	Visual Inspection	W
		Gasket	Leak	Visual Inspection	W
Rear support assembly	RTF	Support rods	Break	Visual Inspection	M
Roller assembly	RTF	Bearings	Seize	Inspect oil level	W

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Appendix B: Inspection Checklist

Each soot blower (furnace and air heater soot blowers) should be inspected by maintenance personnel and operating personnel once a week to ensure that:

- All mechanisms are functioning
- All moving parts are adequately lubricated
- There are no oil or steam leaks
- Feed tubes are in good condition (The feed tube can be seen when the soot blower is operated and the outer lance inside the boiler)
- Lance tube surfaces in good condition
- Nozzle in good condition

The inspection checklist and comment list below should be filled in by maintenance personnel and sent to work management for capture on the SAP system


Description	All Soot blowers eg (3&4)												
	1 Poppet Valve												
Check Poppet valve passing													
Check Poppet valve gland packing leaking													
Check Poppet valve leaking at flange													
Check Air relief valve passing													
Check Air relief valve leaking at joint													
Check Poppet valve lock pin washer leaking													
Check Poppet valve linkage for damage													
	2 Sootblower Carriage												
Check gearbox oil level low													

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Check gearbox leaking oil															
Check if gearbox noisy															
Check gear rack for wear															
Check carriage pinion for wear															
Check trip bar if bent															
Check drain plug leaking oil															
3 Sootblower Lance															
Check if lance tube is bent															
Check if feed tube is bent or scored															
Check for leaks on lance hub packing															
Check for leaks on feed tube packing															
Check if any hub bolts are loose															
4 Front Support Assembly															
Check front guide rollers not missing															
Check front shoulder bolts are secure															
Check free rotation of rollers															
5 Wall Box															
Check for escaping boiler gases															
Check purge air inlet connection not loose															
6 Electrical															
Check limit switch for defects															
Check pressure switch connections for leaks															
Check expander cable for damage															
Check cone for damage															
Check for loose or frayed wires															

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Appendix C: Planned Outages Work

A.1 UNIT – SCOPE OF WORK						
AIRHEATER SOOTBLOWERS						
1.	Soot blowers	Responsible Department	KKS	Procedure / Specification	Hold or Witness Points	Remarks
1.1	Conduct visual inspection on air heater soot blower expanders and report to Eng.				H	
1 1.1	Replace air heater soot blower expanders and flanges if necessary.					
1.2	Conduct wall thickness measurements on soot blower pipes in air heater and report to Eng.					Report to be generated and submitted to engineering
1 2 1	Replace worn soot blower pipes in air heaters					
FURNACE SOOT BLOWERS						

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2.1	Inspect the welds on the lances, nozzles and poppet valve - MPI or Dye-pen					
2.2	Lance wall thickness measurements to be taken and report to Engineering.					
2.2.1	Replace worn lances.					
2.3	Do dry run on each lance during commissioning to check for alignment INSIDE boiler				H	Lance to be checked from inside boiler to see if it's aligning and
2.4	Do dry run on each lance during commissioning to check for alignment OUTSIDE boiler					not scrapping or touching from both outside & inside boiler
2.5	Conduct sootblower lance travel test				H	
2.5.1	Verify that the pivot block and cam assemblies are correctly setup to ensure that the poppet valve only opens once the lance is through the boiler wall					
2.6	Verify the condition of the wall boxes					

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2.6.1	Inspect wall sleeves and boxes for correct length, damage and condition of refractory and rectify if required					
2.6.2	Replace all missing and worn wall sleeves					
2.7	Pilot valve links to be adjusted to correct position					
2.8	Inspect all pressure switches and limit switches					
PRESSURE GAUGES AND VALVES						
2.9	Record soot blower poppet pressures. Pre outage					
2.10	Repair all defects as per on SAP system					Draw latest defects list before outage

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