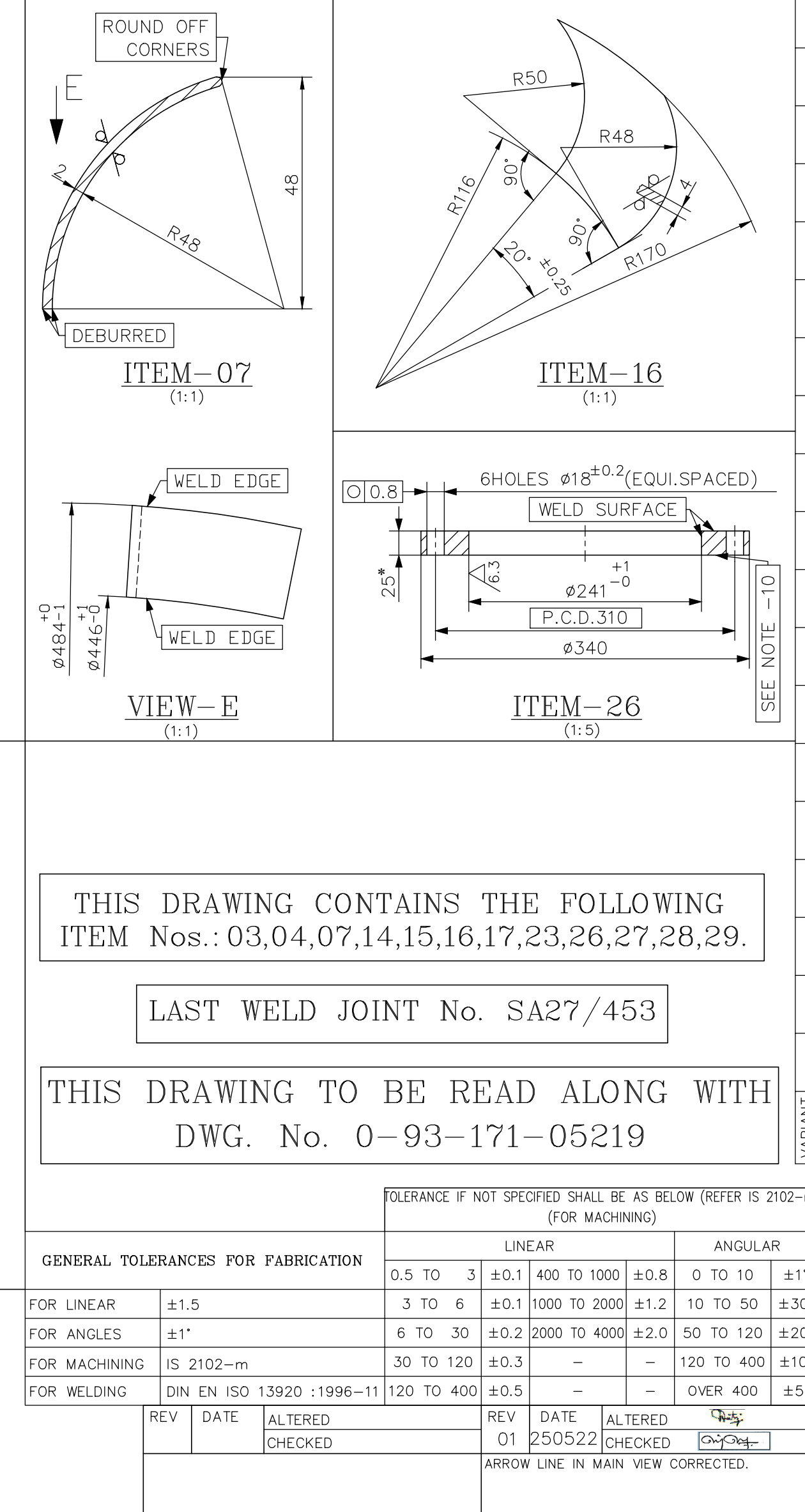
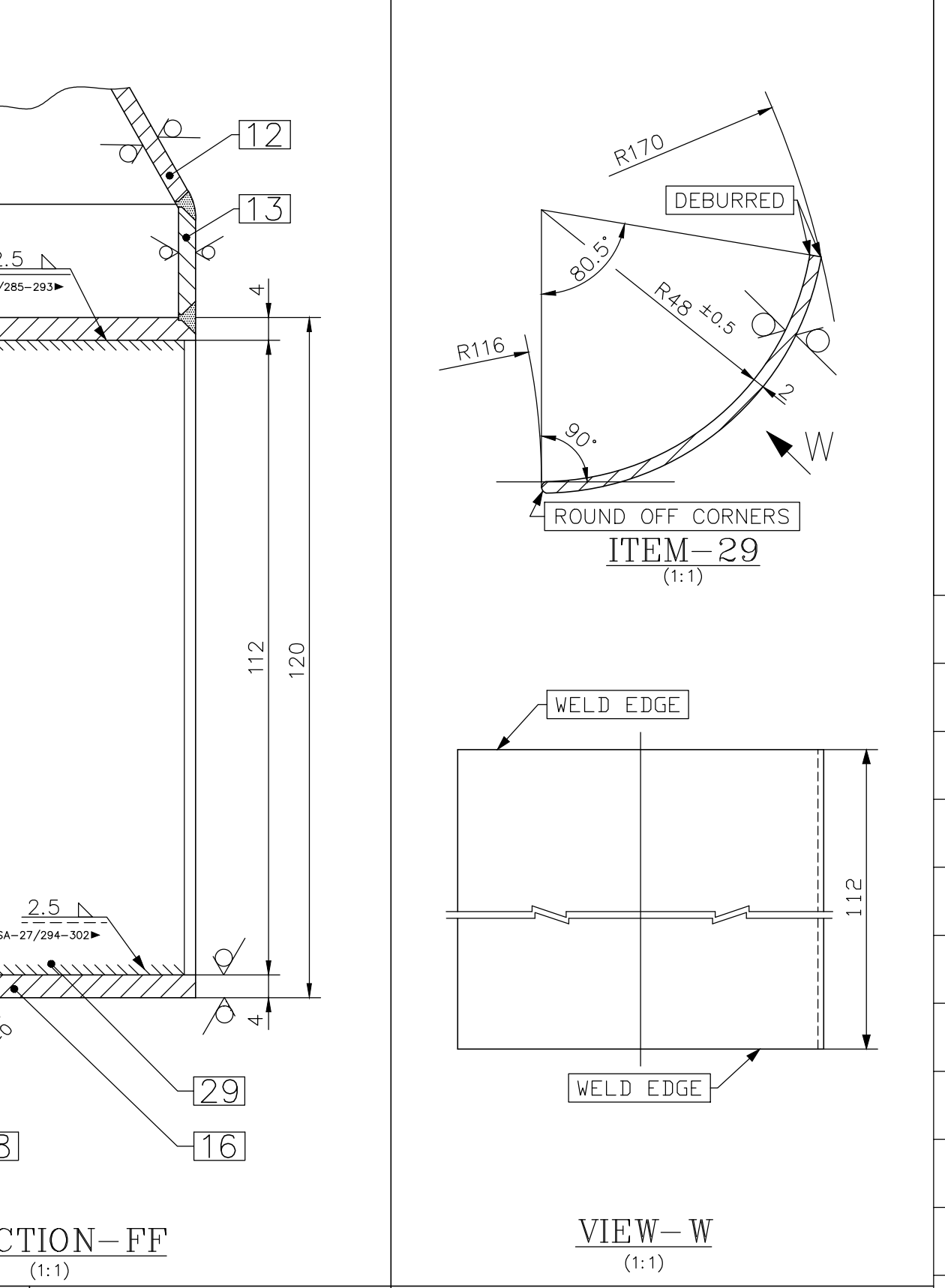
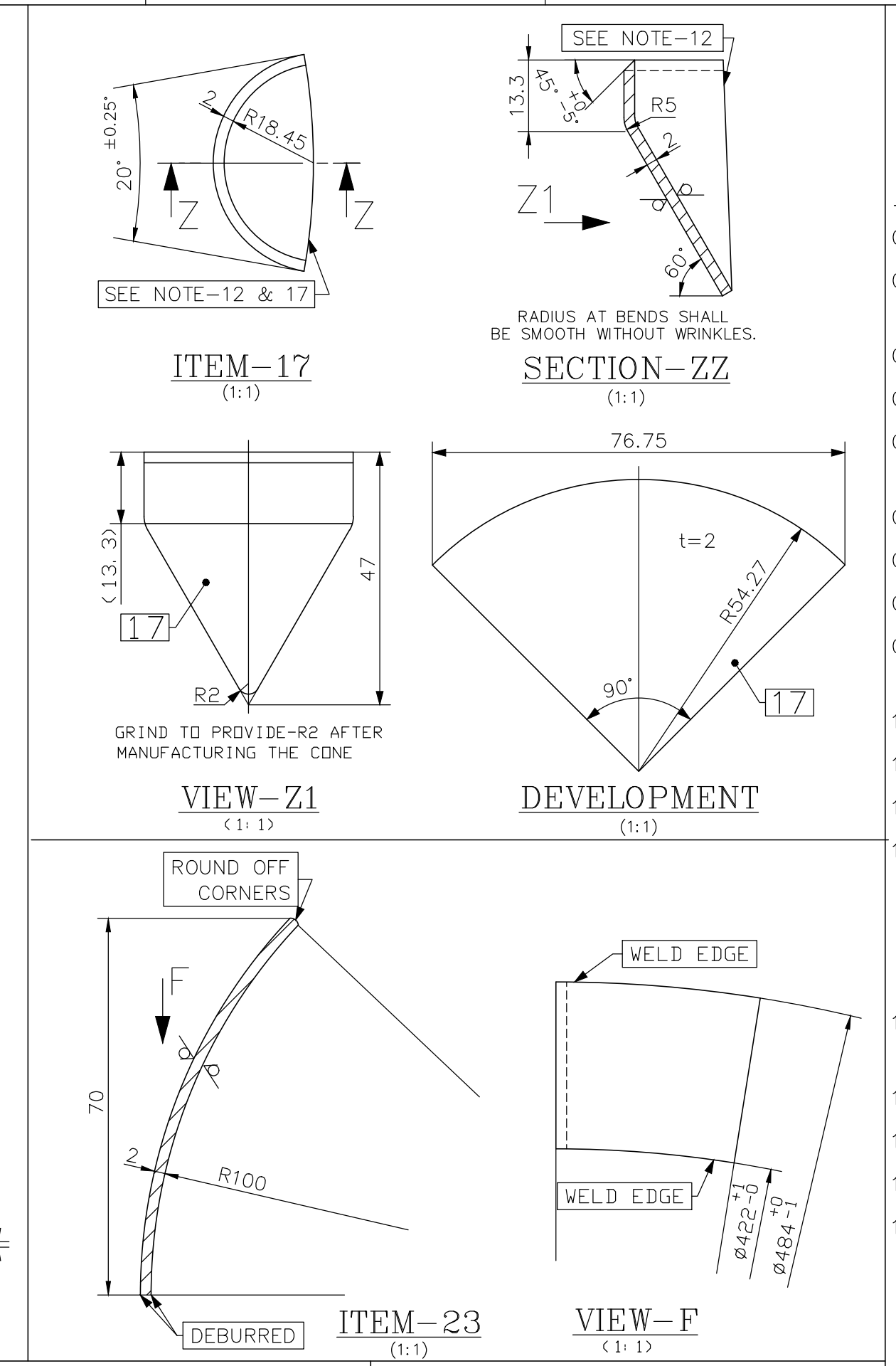
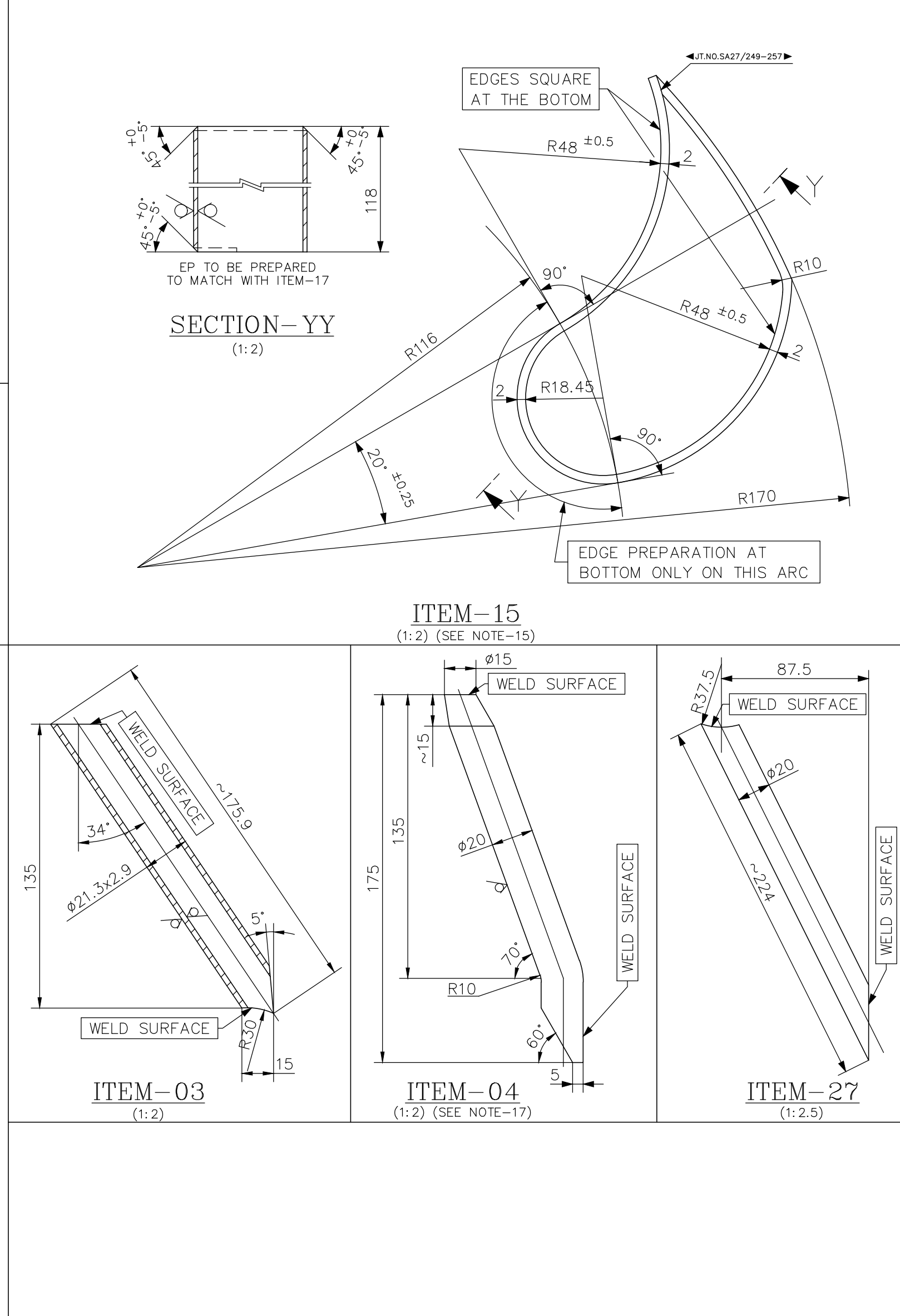
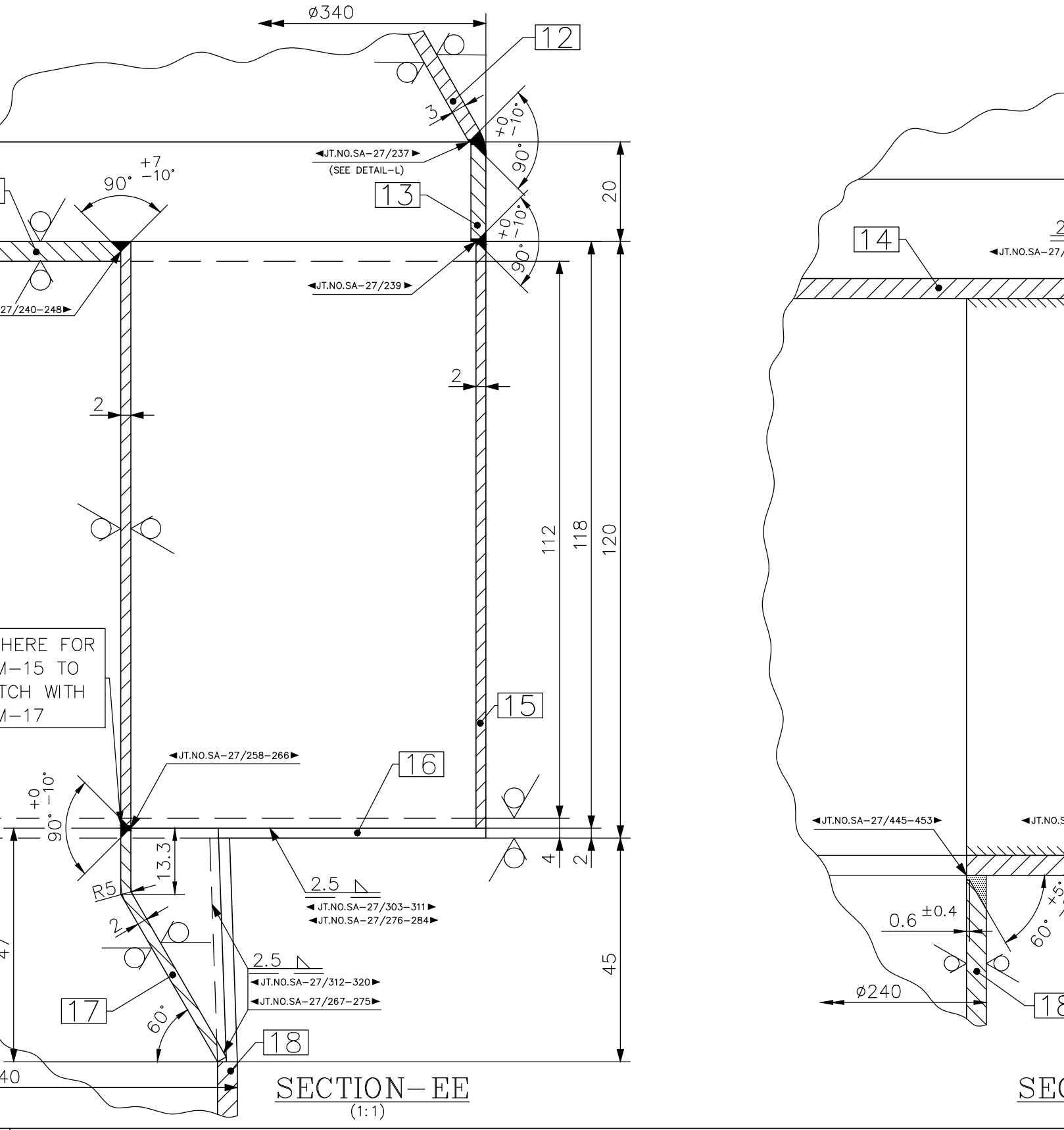
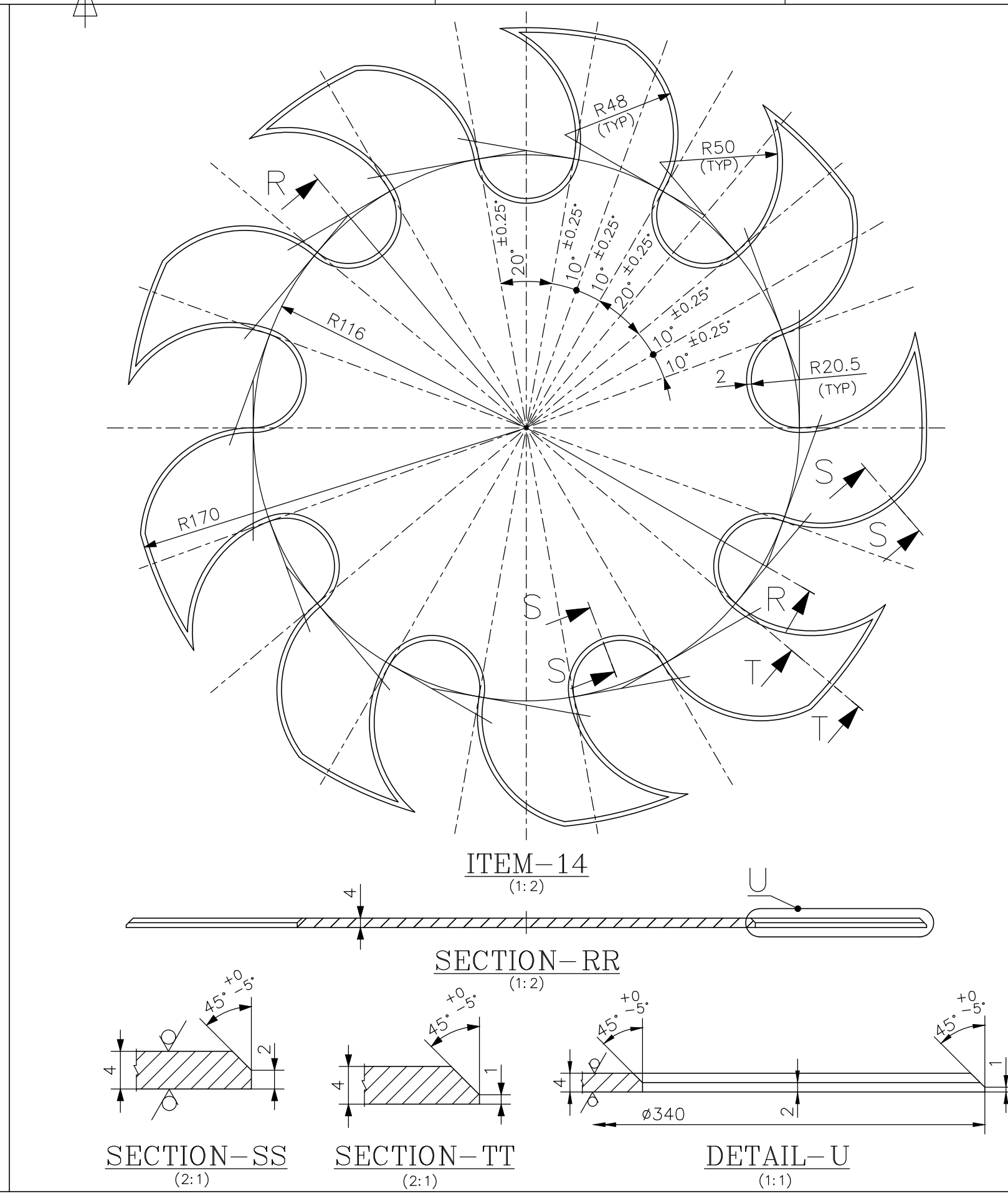
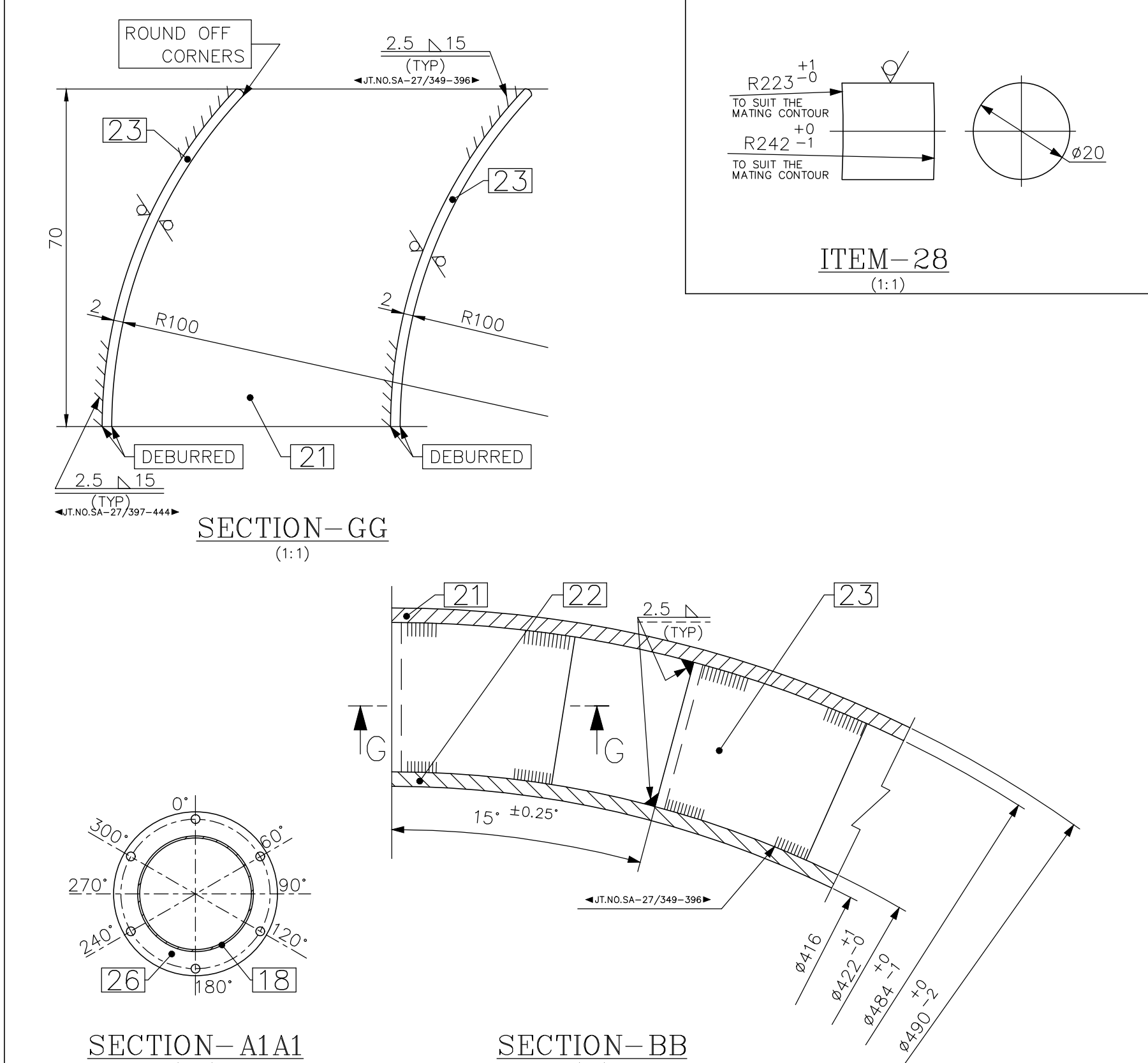
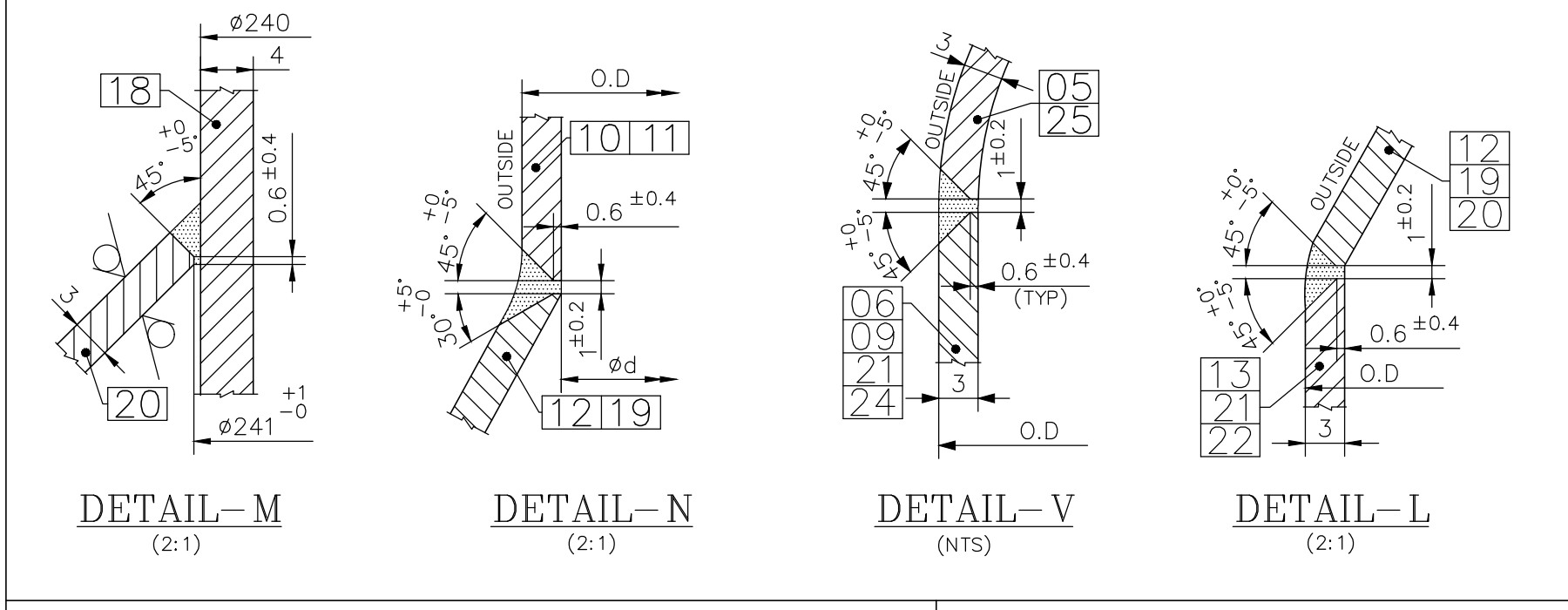
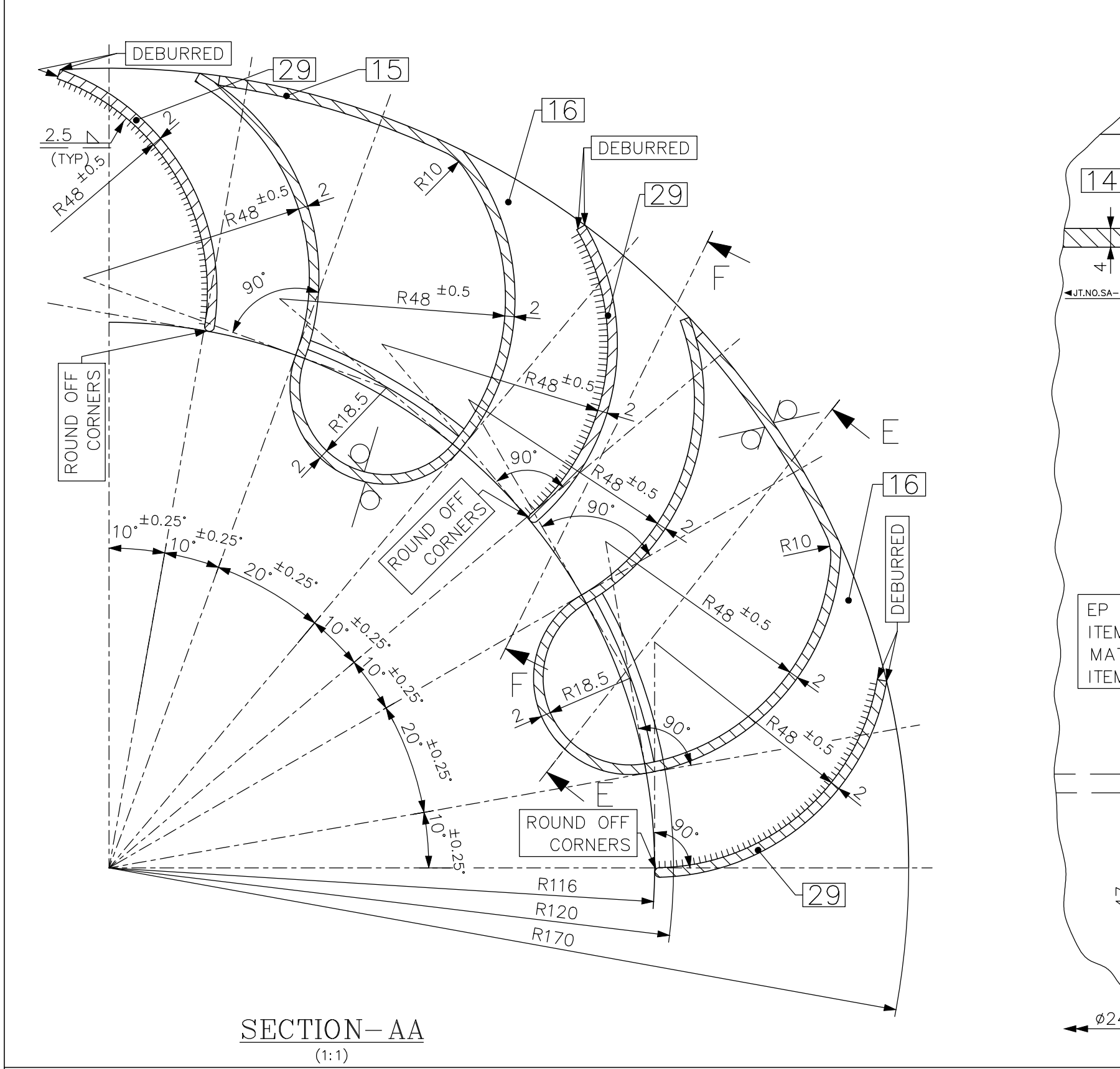
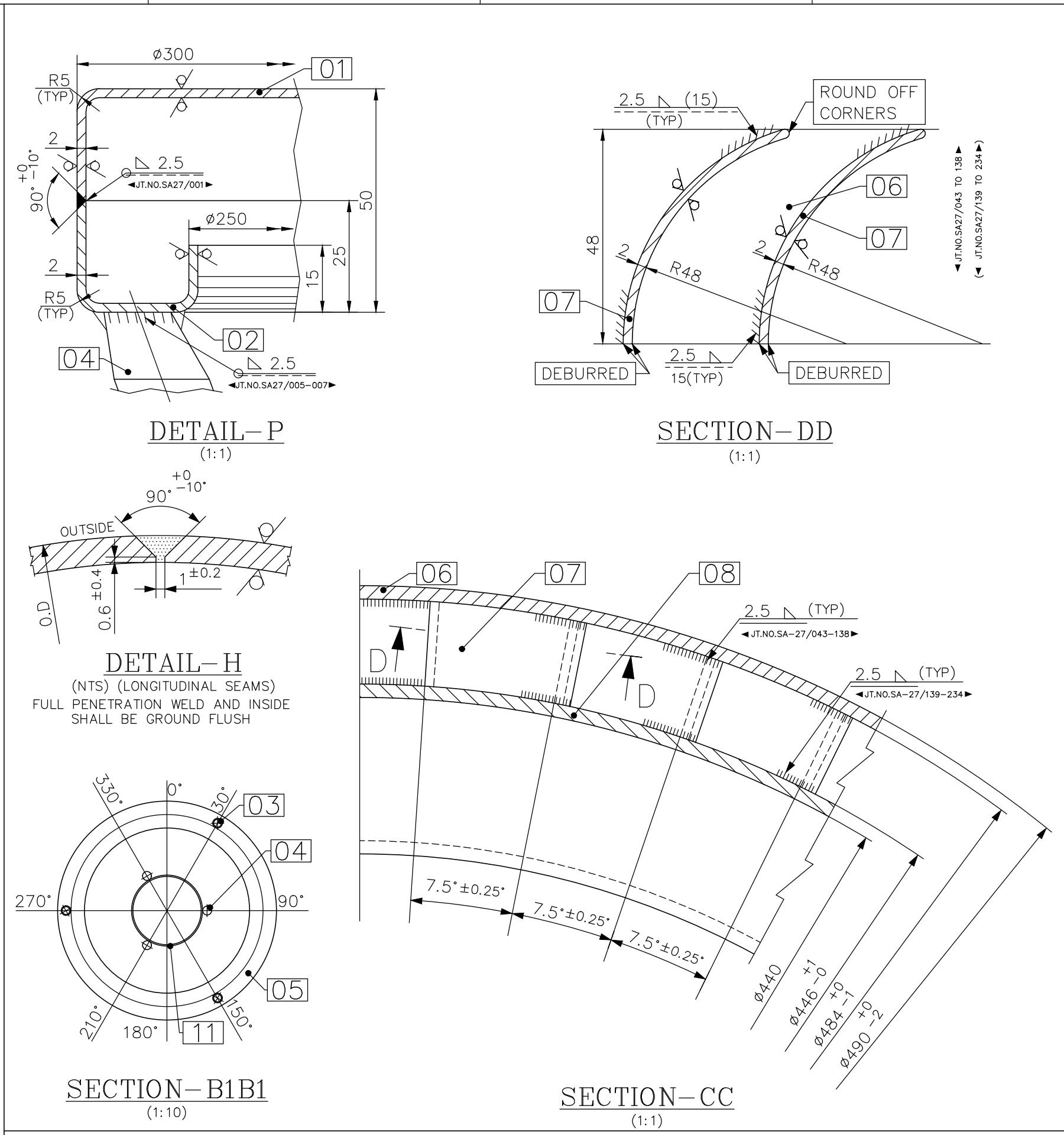
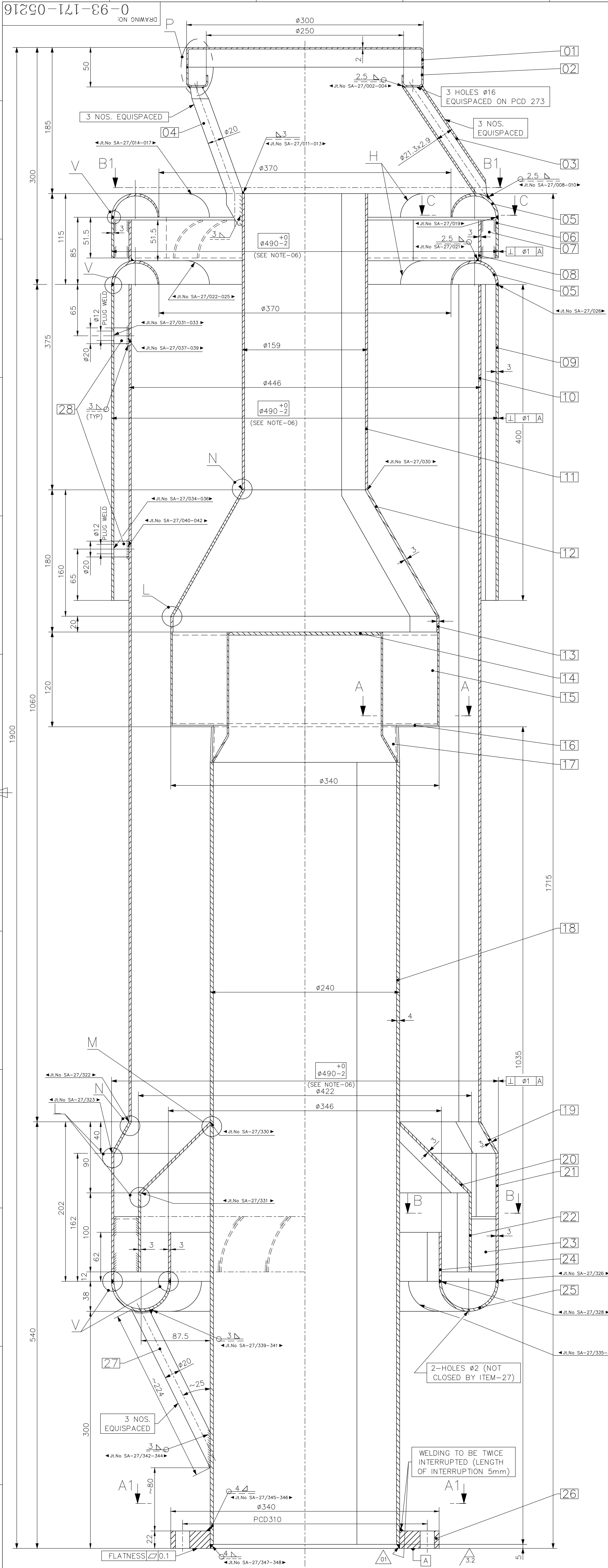




NOTE										ALL DIMENSIONS ARE IN MILLIMETERS									
01. ALL WELD EDGES SHALL BE SUBJECTED TO PT AS PER RELEVANT BH&L SPECIFICATION																			
02. ALL BUTT WELDS SHALL BE SUBJECTED TO 100% RT INSIDE & OUTSIDE SURFACES SHALL BE SUBJECTED TO PT																			
03. ALL FILLET WELDS SHALL BE SUBJECTED TO PT																			
04. WELDS SHALL BE SMOOTHLY BLENDED WITH ADJACENT BASE METAL																			
05. FOR DETAILS H.V.L.&N, THE WELDS SHALL BE FULL PENETRATION & INSIDE SURFACES SHALL BE GROUND FLUSH																			
06. FOR #490 SHELLS, PERPENDICULARITY OF #1 mm SHALL BE MAINTAINED WITH RESPECT TO SURFACE-A																			
07. AFTER FORMING IT SHALL BE ENSURED THAT THE SURFACES SHALL BE SMOOTH & WITHOUT WAVINESS																			
08. ALL SHARP CORNERS / EDGES SHALL BE ROUNDED OFF																			
09. SOLUTION ANNEALING SHALL BE CARRIED OUT FOR ALL COLD WORKED COMPONENTS WHERE THE AMOUNT OF COLD WORKING EXCEEDS 10%																			
10. MACHINING OF THE FLANGE FACE SHALL BE DONE ONLY AFTER WELDING THE FLANGE WITH THE SHELL																			
11. RADIUS AT BENDS SHALL BE SMOOTH AND WITHOUT WRINKLES																			
12. EDGES SHALL BE GROUND TO SUIT THE MATING COMPONENT, REFER ITEM No.18																			
13. ALL MACHINED SURFACES UNLESS OTHERWISE SPECIFIED SHALL HAVE SURFACE ROUGHNESS VALUE AS GIVEN BELOW																			
a) WELD EDGES AND WELD SURFACES $\sqrt{10}$ ($\sqrt{10}$)																			
b) OTHERWISE SURFACES $\sqrt{3.2}$ ($\sqrt{3.2}$)																			
14. FOR LONGITUDINAL WELD SEAMS OF CONES (ITEM NO. 12,19 & 20) AND BENDS (ITEM NO. 05 & 25) DETAIL-H CAN BE REFERRED TO																			
15. AFTER FORMING, BENT PORTIONS OF ITEM No.15 SHALL BE PT EXAMINED																			
16. THE BUTT WELDS BETWEEN PARTS 19 & 21, 20 & 22 SHALL BE SUBJECTED TO INTER STAGE PT																			
17. SOLUTION ANNEALING SHALL BE CARRIED OUT FOR THE ITEM Nos. 01, 02, 04, 05, 15, 17 & 25																			
18. ITEM No. 05 & 25 (BEND-1 & BEND-2) SHALL BE MADE EITHER AS PER ALTERNATE-1 OR ALTERNATE-2																			