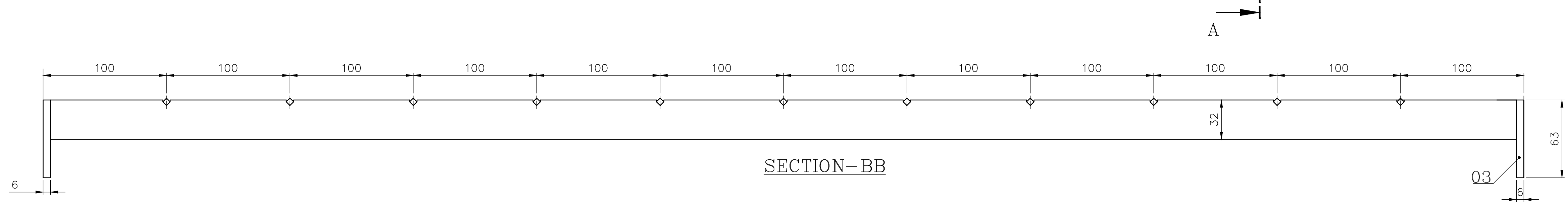
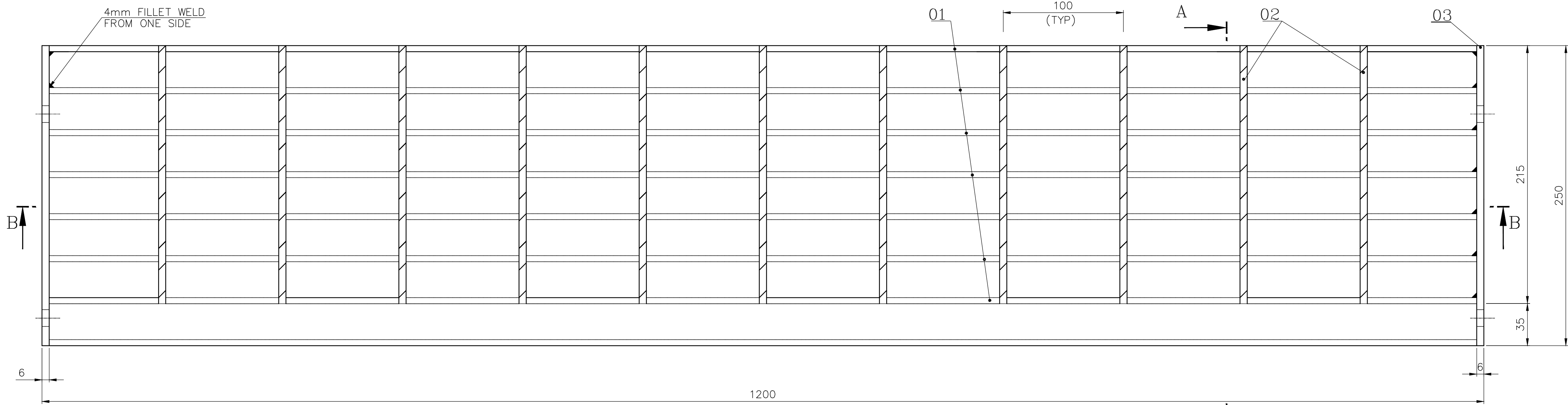


1-36-820-02543

FOR TOLERANCES OF UNTOLERANCED  
DIMENSIONS DURING MANUFACTURE  
REFER PLANT STD. NO TP 023 0299

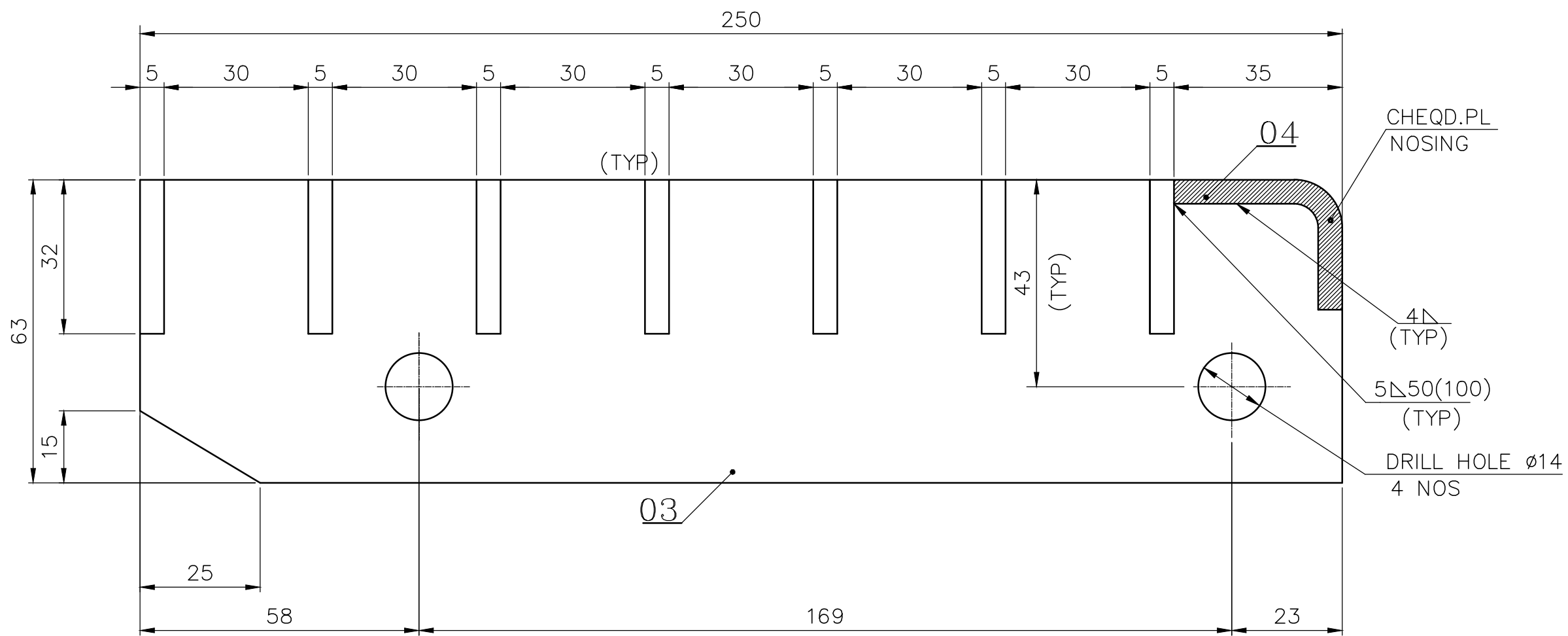
| TYPE & SIZE<br>OF WELD | TYPE OF<br>ELECTRODE | LENGTH OF<br>WELD IN 'M' |
|------------------------|----------------------|--------------------------|
| 5 $\nabla$             | E7018<br>(SMAW/GMAW) | 30.0                     |
| 4 $\nabla$             | E7018<br>(SMAW/GMAW) | 30.0                     |



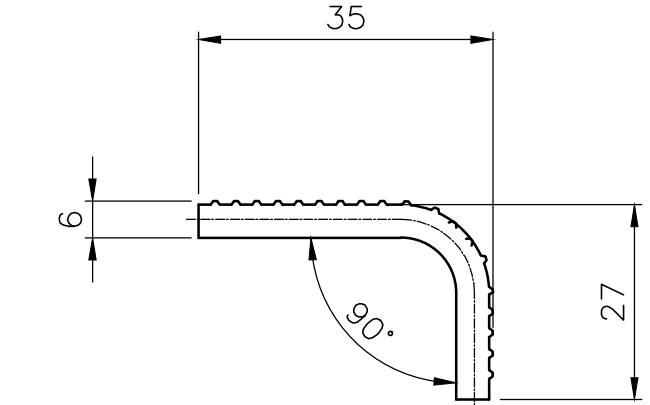
SECTION-BB

NOTES: -

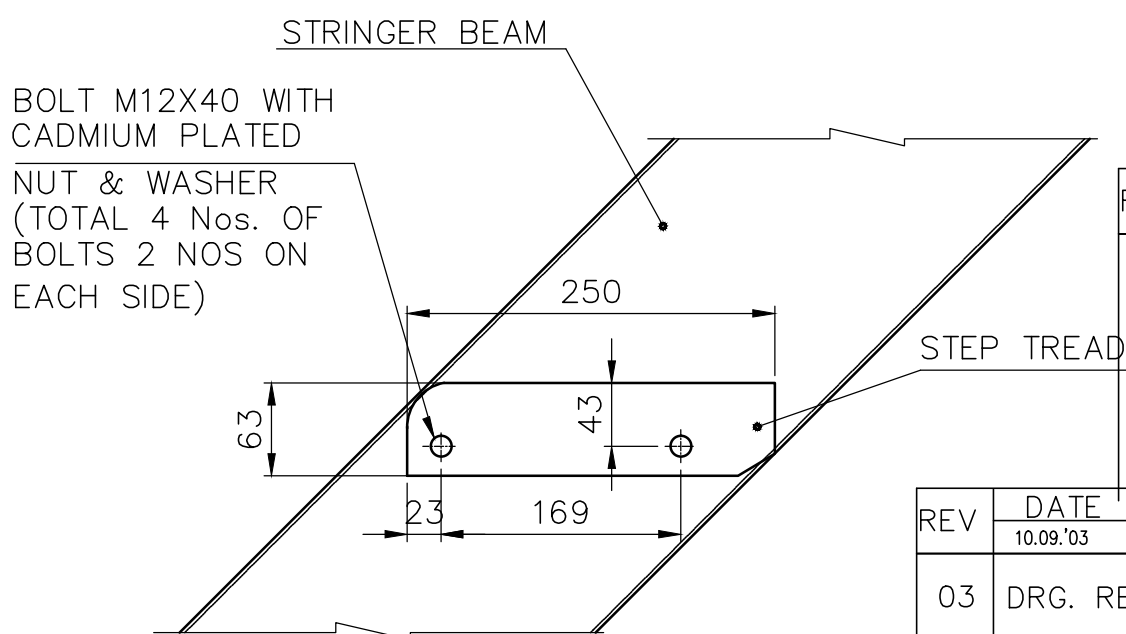
- STEP TREADS (ITEM NOS 01 TO 04) ARE TO BE GALVANISED BY HOT DIP PROCESS AFTER CLEANING BY PICKLING PROCESS , MINIMUM WEIGHT OF ZINC COATING SHALL BE 610 GM/SQ.M
- M.S MATERIALS CONFORMING TO SPECIFICATION IS:2062 E250A AND CHEQUERED PLATE CONFORMING TO I.S 3502 ARE TO BE USED.
- GALVANISING TO BE DONE AFTER ALL WORKS ARE COMPLETED.
- ITEM NOS 1 & 2 ARE TO BE ELECTRO FORGED WELDED.
- ITEM NOS 03 TO 04 ARE TO BE WELDED AS PER DETAILS SHOWN.
- ALL STEP TREADS ARE DESIGNED FOR A LIVE LOAD OF 1000 KG/SQ.M
- DEFLECTION SHALL BE LIMITED TO L/250 OR 6 mm WHICHEVER IS MINIMUM.
- ALL DIMENSIONS ARE IN MM.
- TOLERANCE FOR LENGTH AND WIDTH OF STEP TREADS SHALL BE +0 & -5.00MM
- STEP TREADS ARE FOR OUT DOOR APPLICATION.



SECTION-AA



DETAIL OF CHEQD.  
PLATE NOSING



FIXING ARRANGEMENT OF STEP TREAD  
WITH STRINGER BEAM

| VARIANT<br>NUMBER | ITEM<br>NUMBER | DESCRIPTION                          | STD | DRAWING NUMBER | ITEM NO<br>VAR NO | MATERIAL CODE<br>MATERIAL SPECN | UNIT<br>DI | UNIT WEIGHT<br>QUANTITY | ZONE |
|-------------------|----------------|--------------------------------------|-----|----------------|-------------------|---------------------------------|------------|-------------------------|------|
|                   | 04             | CHEQD.PLATE<br>1188X 62 X 6          |     |                |                   | IS3502                          |            | 3.469                   |      |
|                   | 03             | FLAT<br>250 X 63 X 6                 |     |                |                   | IS2062 E250A                    |            | 0.742                   |      |
|                   | 02             | SQ.TWISTED BAR<br>6mm Diagonal X 210 |     |                |                   | IS1786 Fe500                    |            | 0.029                   |      |
|                   | 01             | FLAT<br>1188 X 32 X 5                |     |                |                   | IS2062 E250A                    |            | 1.492                   |      |

| REV | DATE     | ALTD.    | CHD.    | APPD. | REV | DATE     | ALTD.    | CHD.    | APPD. |
|-----|----------|----------|---------|-------|-----|----------|----------|---------|-------|
|     | 12.02.13 | PRAKASH  | M.P.R   | M.P.R | 06  | 22.01.13 | CHIDRAPP | PENCHAL |       |
|     | 22.01.13 | CHIDRAPP | PENCHAL |       | 05  | 22.02.12 | PRAKASH  | M.P.R   | R.R.S |
|     | 22.02.12 | PRAKASH  | M.P.R   | R.R.S | 04  | 21.08.03 | SKR      | RRS     |       |
|     | 21.08.03 | SKR      | RRS     |       | 03  | 10.09.03 | SKR      | RRS     |       |
|     | 10.09.03 | SKR      | RRS     |       | 02  | 21.08.03 | SKR      | RRS     |       |
|     | 21.08.03 | SKR      | RRS     |       | 01  | 10.09.03 | SKR      | RRS     |       |

|              |  |
|--------------|--|
| JOB NO:      |  |
| STATUS:      |  |
| DISTRIBUTION |  |
| TO           |  |
| NO.OF        |  |
| REV          |  |
| DATE         |  |
| ALTD.        |  |
| CHD.         |  |
| APPD.        |  |

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BHARAT HEAVY ELECTRICALS LTD  
UNIT:HIGH PRESSURE BOILER PLANT  
TIRUCHIRAPPALLI-620 014

| DEPT<br>CODE | DRN<br>DESN | NAME<br>CHD  | SIGN | DATE     |
|--------------|-------------|--------------|------|----------|
|              |             | S.MANIVANNAN |      | 31/05/03 |
|              |             | S.K.RAMAN    |      | 31/05/03 |
|              |             | S.K.RAMAN    |      | 31/05/03 |
|              |             | R.RAMASAMY   |      | 31/05/03 |

STEP TREAD 250 X 1200  
(WITH CHEQD. PL NOSING)

BHEL DRG NO.  
1-36-820-02543

SCALE N.T.S

REV 06