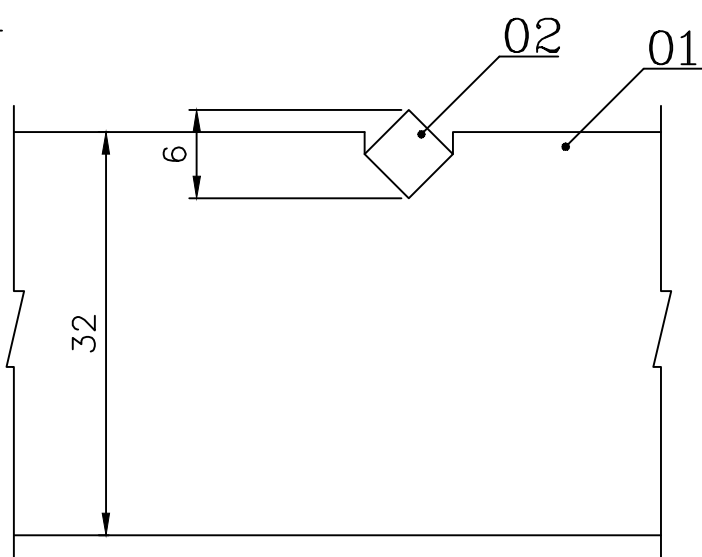
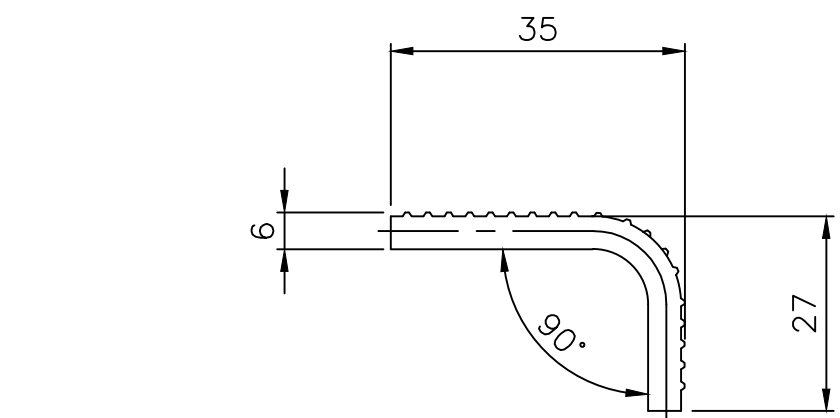


| TYPE & SIZE<br>OF WELD | TYPE OF<br>ELECTRODE | LENGTH OF<br>WELD IN 'M' |
|------------------------|----------------------|--------------------------|
| 5 $\nabla$             | E7018<br>(SMAW/GMAW) | 30.0                     |
| 4 $\nabla$             | E7018<br>(SMAW/GMAW) | 30.0               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

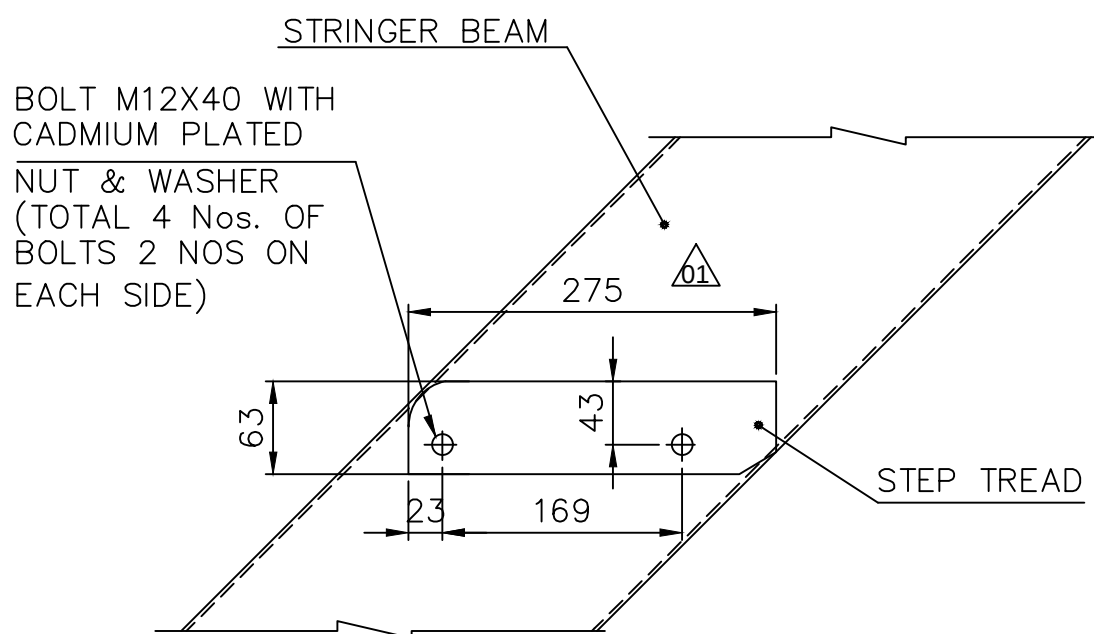


NOTES: —

01. 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
02. M.S MATERIALS CONFORMING TO SPECIFICATION IS:2062 E250A AND CHEQUERED PLATE CONFORMING TO I.S 3502 ARE TO BE USED.
03. GALVANISING TO BE DONE AFTER ALL WORKS ARE COMPLETED.
04. ITEM NOS 1 & 2 ARE TO BE ELECTRO FORGED WELDED.
05. ITEM NOS 03 TO 04 ARE TO BE WELDED AS PER DETAILS SHOWN.
06. ALL STEP TREADS ARE DESIGNED FOR A LIVE LOAD OF 1000 KG/SQ.M
07. DEFLECTION SHALL BE LIMITED TO L/250 OR 6 mm WHICHEVER IS MINIMUM.
08. ALL DIMENSIONS ARE IN MM.
09. TOLERANCE FOR LENGTH AND WIDTH OF STEP TREADS SHALL BE +0 & -5.00MM
10. STEP TREADS ARE FOR OUT DOOR APPLICATION.



## FIXING ARRANGEMENT OF STEP TREAD WITH STRINGER BEAM

[illegible]

CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be reproduced in any way detrimental to the interest of the company.

|                                                                                                  |                             |                                                                                                     |                |                       |                                |                   |           |                  |
|--------------------------------------------------------------------------------------------------|-----------------------------|-----------------------------------------------------------------------------------------------------|----------------|-----------------------|--------------------------------|-------------------|-----------|------------------|
| TYPE OF PRODUCT<br>OR NAME OF<br>CUSTOMER/PROJECT                                                |                             |                                                                                                     |                |                       |                                |                   |           |                  |
| <br>355-053 |                             | Bharat Heavy Electricals Ltd<br>UNIT: HIGH PRESSURE BOILER PLANT<br>TIRUCHIRAPALLI - 620014         |                |                       | DRN                            | NAME<br>K.KESAVAN | SIGNATURE | DATE<br>31/05/17 |
|                                                                                                  |                             |                                                                                                     |                |                       | CHD                            | N.V.V.RAGAVAN     |           | 31/05/17         |
|                                                                                                  |                             |                                                                                                     |                |                       | APPD                           | J.SOMU            |           | 31/05/17         |
| DEPT<br>ST                                                                                       | ALL DIMENSIONS<br>ARE IN MM | PROJECTION<br> | SCALE<br>N.T.S | WEIGHT (Kg)<br>17.400 | REF TO ASSY / OLD DWG          |                   |           |                  |
| CODE<br>122                                                                                      |                             |                                                                                                     |                |                       | DRAWING NO :<br>1-36-820-19691 |                   |           | REV<br>01        |
| TITLE<br>STEP TREAD 275 X 1200<br>(WITH CHEQD. PL. NOSING)                                       |                             |                                                                                                     |                |                       |                                |                   |           |                  |