

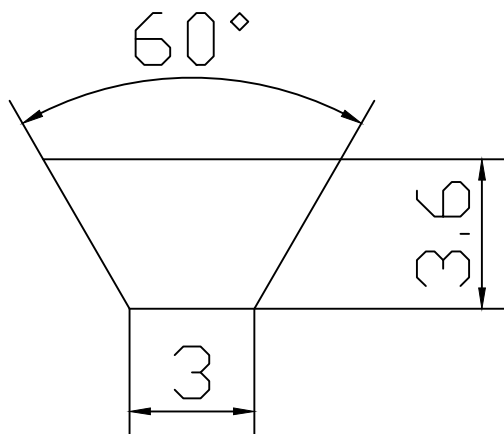
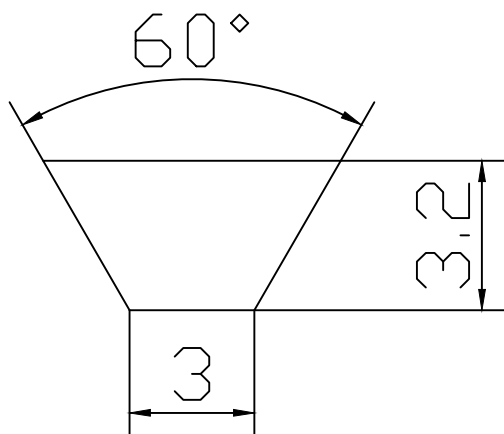
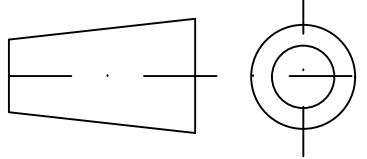
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Ref.Drawing No>

Sign & Date

Inventory No>

FIRST ANGLE PROJECTION															(ALL DIMENSIONS ARE IN mm)										FORM DG 38(B)						
00089-90001-3 DRAWING No.																															
SL. NO.	DRAWING NO.	LOCATION OF WELD	WELD SEAM LXW	WELD DETAILS		WELD CLASS & CSR	NO. OF WELD PER UNIT	QTY. OF WELD METAL IN Kg. (APPROX.)	MATERIAL SPECIFICATION		ELECTRODE	PRE-HEAT TREAT.	POST-HEAT TREATMENT	PROCESS OF WELD AND SPECIFICATION																	
				TYPE	SIZE																										
1.	LP CASING UPPER PART 01074058000	DETAIL F	720X20	F	∇ 20	CS,CK CSR-1	1	1.13	AA10401	AA10401	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
		SEC G-G	560X20	F	∇ 20	-DO-	1	0.880	AA10401	AA10401	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
		SEC E-E	9656X20	F	∇ 20	-DO-	1	15.16	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
			9656X8	F	∇ 8	-DO-	-DO-	2.43	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
2.	COMPENSATOR FOR CASING GUIDE 11077558000	SEC A-A	5052X12	F	∇ 12	ISO 5817-B CSR-2(4)																									
	4713X5		F	∇ 5	-DO-	-DO-	3.57	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
	4336X10		F	∇ 10	-DO-	-DO-	0.462	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
	ITEM 1 11077556000	SEC A-A	10053X12	F	∇ 12	-DO-	-DO-	1.70	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
			9425X8	F	∇ 8	-DO-	-DO-	5.68	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
			8039X10	F	∇ 10	-DO-	-DO-	2.36	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
	ITEM 2 11077558100	SEC A-A																													
3.	LP CASING ASS. 01074458000	VIEW Y	(3.14XDXW)	B		BS,CSR-3																									
	358.9X3.2		-DO-			2	0.172	AA10455	AA10455	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
	ITEM 37 21074458600	DETAIL C	279.14X3.2	B		-DO-	-DO-	0.15	AA10455	AA10455	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
	ITEM 34 31074458300																														
				-GMS No./- C B O M-		STATUS OF DRG		TYPE OF PRODUCT STEAM TURBINE OR NAME OF CUSTOMER/PROJECT																							
				ACREED DEPT		NAME										SIGN		DATE													
NOTE :- F = FILLET WELD, B = BUTT WELD SCE = SURFACE CRACK EXAMINATION. WELD CLASSIFICATION GROUP ACC. TO HW0620099. WELDING TEST SCOPE ACC. TO HW0850199.				GRADE OF UNTOL. DIM		WT		S.K.THAKUR		sd/-		21.11.16																			
				M/CG.- AA0230208 m																											
				WELDING-CLASS 'B' OF AA0621104																											
				GAS CUTTING-TABLE 3 OF AA0621101																											
REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED	DEPT	STE	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.		ITEM No.	NO. OF ITEMS															
		CHECKED			CHECKED			CHECKED	CODE	4011																					
										TITLE : FIELD WELDING SCHEDULE				CARD CODE	DRAWING NO. 3-10005-58000																
														SHEET No. 01		No. OF SHEETS 09															

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00089-90001-3 DRAWING No.																																																	
SL. NO.	DRAWING NO.	LOCATION OF WELD	WELD SEAM (LXW)	WELD DETAILS		WELD CLASS & CSR	NO. OF WELD PER UNIT	QTY. OF WELD METAL IN Kg. (APPROX.)	MATERIAL SPECIFICATION		ELECTRODE	PRE-HEAT TREAT.	POST-HEAT TREATMENT	PROCESS OF WELD AND SPECIFICATION																																			
				TYPE	SIZE																																												
	ITEM 35 21074458400	DETAIL X	279.14X3.2	B		BS CSR-3	2	0.15	AA10455	AA10455	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																																		
		VIEW Z	279.14X3.2	B	-DO-	-DO-	4	0.30	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																																		
	ITEM 36 21074458500	VIEW Y	358.9X3.96	B		BS CSR-3	2	0.18	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																																		
		ITEM 38 21074458700	MAIN VIEW	279.14X4	B		-DO-	4	1.13	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																																	
	VIEW Y		279.14X4	B	-DO-	-DO-	2	0.56	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																																		
	01074458000	SEC V-V	558X4	B		CS,CK,CSR-3	1	0.13	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																																		
		SEC W-W	840X4	B		CS,CK,CSR-3	-DO-	0.20	AA10455	AA10455	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																																		
		SEC G-G	558X4	B	-DO-	CS,CK,CSR-3	-DO-	0.13	AA10455	AA10455	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																																		
		SEC H-H	1320X12	F	∇12	CS,CK,CSR-3	1	0.75	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																																		
				1080X5	F	∇5	-DO-	-DO-	0.10	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																																	
				-GMS No./- C B O M-		STATUS OF DRG		TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT																																									
				AGREED DEPT		NAME		SIGN		DATE		STEAM TURBINE																																					
				WT		S.K.THAKUR		sd/-		21.11.16		BHARAT HEAVY ELECTRICALS LTD. RANIPUR, HARDWAR																																					
												DRAWING NO. 3-10005-58000																																					
												SHEET No. 02 No. OF SHEETS 09																																					
												SIZE A3																																					

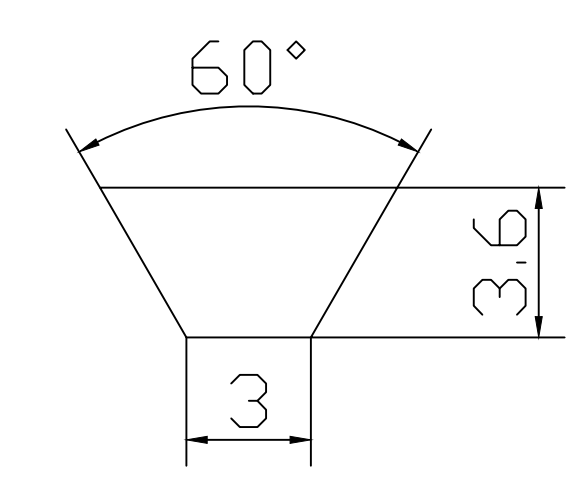
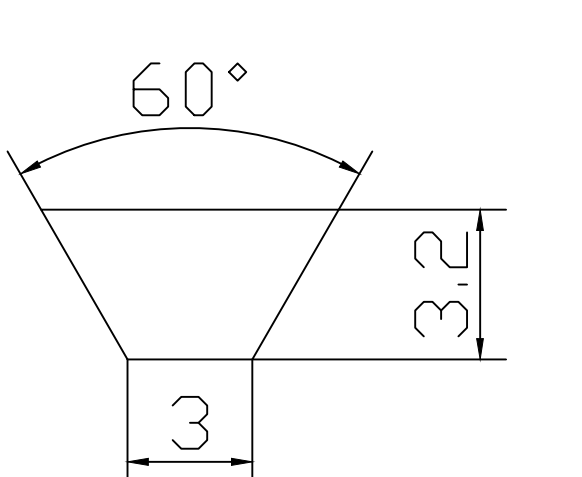
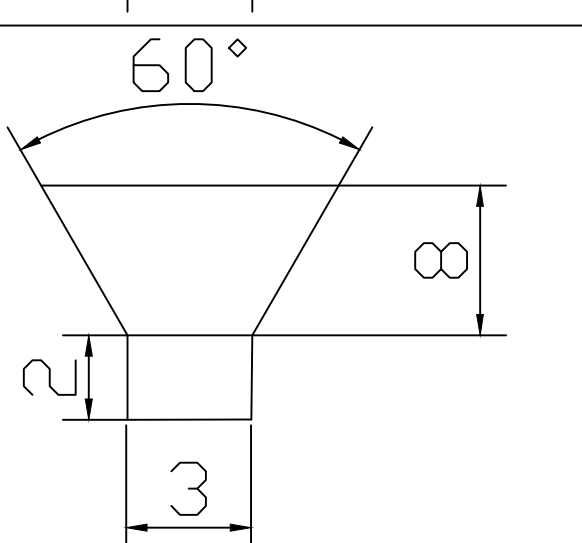
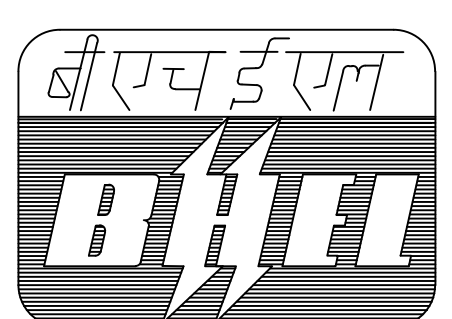
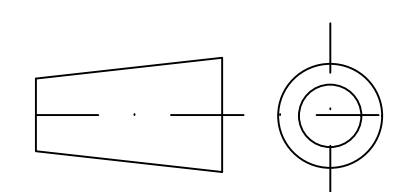
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00089-90001-3															DRAWING No.																				
SL. NO.	DRAWING NO.	LOCATION OF WELD	WELD SEAM (LXW)	WELD DETAILS		WELD CLASS & CSR	NO. OF WELD PER UNIT	QTY. OF WELD METAL IN Kg. (APPROX.)	MATERIAL SPECIFICATION		ELECTRODE	PRE-HEAT TREAT.	POST-HEAT TREATMENT	PROCESS OF WELD AND SPECIFICATION																					
				TYPE	SIZE																														
		SEC H ₁ -H ₁	880X12	F	▽ 12	CS,CK CSR-3(2)	1	0.50	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																				
			720X5	F	▽ 5	-DO-	1	0.07	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																				
		SEC H ₂ -H ₂	880X12	F	▽ 12	-DO-	1	0.50	AA10119	AA10455	E7018	100°C LOCALLY	NO POST HEAT	SMAW	CS11294																				
			720X5	F	▽ 5	-DO-	-DO-	0.07	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																				
		DETAIL E1	520X20	F	▽ 20	-DO-	1	0.816	AA10119	AA10119	E7018	100°C LOCALLY	NO POST HEAT	SMAW	CS11294																				
		SEC E ₂ -E ₂	480X20	F	▽ 20	-DO-	-DO-	0.75	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																				
		SEC G ₁ -G ₁	362X9	F	▽ 9	-DO-	-DO-	0.05	AA10119	AA10455	E7018	100°C LOCALLY	NO POST HEAT	SMAW	CS11294																				
		SEC O-O	8000X13.5	F	▽ 13.5	-DO-	-DO-	5.72	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																				
		SEC Y-Y	15520X30	F	▽ 30	-DO-	-DO-	54.82	-DO-	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																				
		DETAIL V ₁	480X20	F	▽ 20	-DO-	-DO-	0.75	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																				
		SEC K ₁ -K ₁	1440X20	F	▽ 20	-DO-	-DO-	2.26	AA10401	AA10401	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																				
		SEC K2-K2	800X13.5	F	▽ 13.5	-DO-	-DO-	0.57	AA10119	AA10401	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																				
		DETAIL A	719X3.6	B		-DO-	-DO-	0.10	AA10401	AA10401	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																				
		DETAIL-B	719X3.6	F	▽ 3.6	-DO-	-DO-	0.03	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																				
		SEC U-U	559X9	F	▽ 9	-DO-	-DO-	0.29	AA10455	AA10119	E7018	100°C LOCALLY	NO POST HEAT	SMAW	CS11294																				
			719X3.2	B		-DO-	-DO-	0.08	AA10455	AA10455	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																				
		4.	11076858000 LP EXTRACTION A1	MAIN VIEW	4493X10	B		BS,BK UT AS PER CSR-3	1	2.36	AA10401	AA10401	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																		
						-GMS No./- C B O M-			STATUS OF DRG	TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT																									
				AGREED DEPT			NAME	SIGN	DATE	BHARAT HEAVY ELECTRICALS LTD. RANIPUR, HARDWAR <table><tr><td>DRN</td><td>NAME</td><td>SIGN</td><td>DATE</td><td rowspan="3">NO. OF VAR</td></tr><tr><td>CHD</td><td>JAIVEER</td><td>sd/-</td><td>24.09.2016</td></tr><tr><td>APPD</td><td>M MITTAL</td><td>sd/-</td><td>24.09.2016</td></tr><tr><td></td><td>D.K.RAY</td><td>sd/-</td><td>22.11.2016</td><td>73 74</td></tr></table>								DRN	NAME	SIGN	DATE	NO. OF VAR	CHD	JAIVEER	sd/-	24.09.2016	APPD	M MITTAL	sd/-	24.09.2016		D.K.RAY	sd/-	22.11.2016	73 74
DRN	NAME	SIGN	DATE	NO. OF VAR																															
CHD	JAIVEER	sd/-	24.09.2016																																
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	D.K.RAY	sd/-	22.11.2016	73 74																															
				WT			S.K.THAKUR	sd/-	21.11.16																										
				GRADE OF UNTOL. DIM																															
				M/CG.- AA0230208 m																															
				WELDING-CLASS 'B' OF AA0621104																															
				GAS CUTTING-TABLE 3 OF AA0621101																															
REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED	DEPT	STE	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM No.	NO. OF ITEMS																				
		CHECKED			CHECKED			CHECKED	CODE		—	—	—	—	75 77																				
										TITLE :			CARD CODE	DRAWING NO.																					
										FIELD WELDING SCHEDULE				3-10005-58000																					
														7 22 23 24																					
													SHEET No. 03		No. OF SHEETS 09																				

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00089-90001-3 DRAWING No.																															
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				TYPE	SIZE																										
	LP EXCTRACTION A1		17970X12	B		BS,BK UT AS PER CSR-3 PT AS PER CSR-1	1	13.22	AA10401	AA10401	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
5.	11076958000	MAIN VIEW	4493X10	B		-DO-	-DO-	2.36	-DO-	AA10401	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
	LP EXCTRACTION A2		17970X12	B		-DO-	-DO-	13.22	-DO-	AA10401	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
6.	01077058000	VIEW PIPE SECTION A3/1	4807X10	B		BS,BK UT AS PER CSR-3 CS,BK UT AS PER CSR-1	-DO-	2.52	AA10401	AA10401	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
	LP EXTRACTION A3		1917X10	B		-DO-	-DO-	1.00	AA10401	AA10401	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
			4807X10	B	-DO-	-DO-	-DO-	2.52	AA10401	AA10401	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
		VIEW PIPE SECTION A3/2																													
				-GMS No./- C B O M-			STATUS OF_DRG	TYPE OF PRODUCT STEAM TURBINE																							
				ACREED DEPT			NAME	SIGN	DATE	OR																					
				WT			S.K.THAKUR	sd/-	21.11.16	NAME OF CUSTOMER/PROJECT																					
NOTE :- F = FILLET WELD, B = BUTT WELD SCE = SURFACE CRACK EXAMINATION. WELD CLASSIFICATION GROUP ACC. TO HW0620099. WELDING TEST SCOPE ACC. TO HW0850199.				GRADE OF UNTOL. DIM								NAME		SIGN	DATE	NO. OF VAR															
				M/CG.- AA0230208 m								DRN	JAIVEER	sd/-	24.09.2016																
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				GAS CUTTING-TABLE 3 OF AA0621101								APPD	D.K.RAY	sd/-	22.11.2016																
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		CHECKED			CHECKED			CHECKED	CODE 4011																						
										TITLE :		CARD CODE	DRAWING NO. 3-10005-58000																		
												SHEET No. 04		No. OF SHEETS 09																	

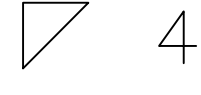
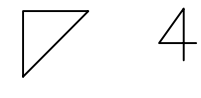
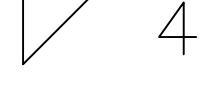
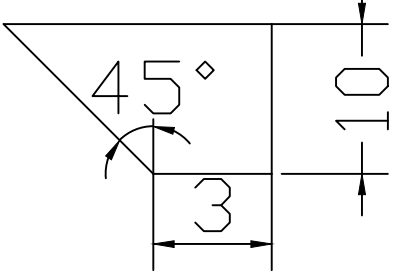
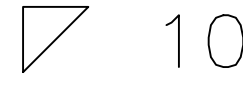
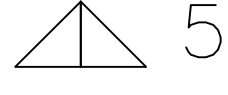
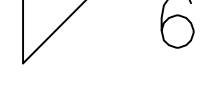
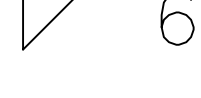
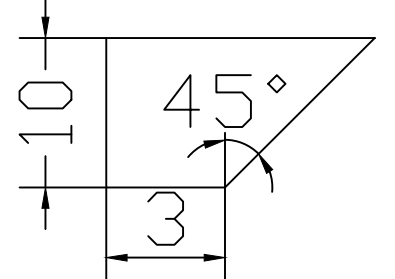
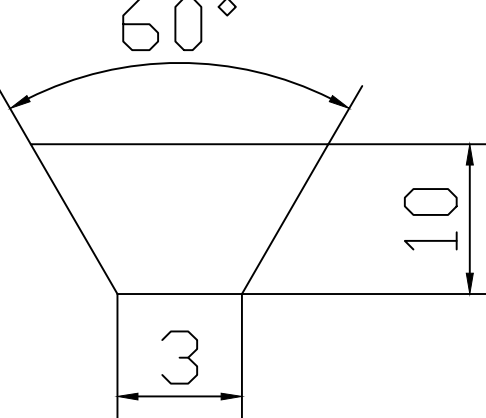
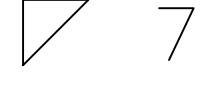
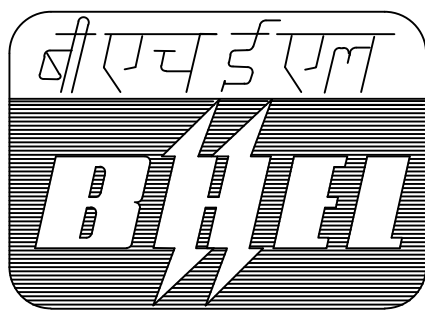
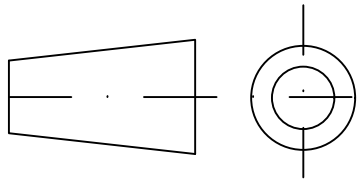
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				TYPE	SIZE																											
7.	SHEATING FOR EXTRACTION A3 LPI 01078058000	DETAIL D	2056X4	F		BS,BK CSR-3	1	0.13	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
			1280X4	F		-DO-	-DO-	0.08	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
			1120X4	F		-DO-	-DO-	0.07	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
			600X4	F		-DO-	-DO-	0.04	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
			943X4	F		-DO-	-DO-	0.06	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
		DETAIL G	2671X10	F		-DO-	-DO-	1.676	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
			4713X10	F	-DO-	-DO-	-DO-	2.95	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
		DETAIL J	1508X10	F	-DO-	BS,BK,CSR-3	-DO-	0.95	AA10401	AA10109	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
			3268X10	F		BS,BK,CSR-3	-DO-	1.29	AA10119	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
		SECTION E-E	1508X5	F		-DO-	-DO-	0.30	AA10119	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
			200X6	F		-DO-	-DO-	0.40	-DO-	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
			1440X6	F		-DO-	-DO-	0.20	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
			1058X6	F		-DO-	-DO-	0.15	AA10455	AA10119	E7018	100° LOCALLY	NO POST HEAT	SMAW	CS11294																	
		DETAIL H	1760X6	F		-DO-	-DO-	0.25	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
			1200X6	F		-DO-	-DO-	0.17	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
		DETAIL F	2671X10	F		BS,BK,CSR-3	-DO-	1.67	AA10109	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
			14834X10	B		-DO-	-DO-	10.21	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
		DETAIL M	275X10	B	-DO-	-DO-	-DO-	0.19	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
		DETAIL I	3600X7	F		-DO-	-DO-	1.09	AA10401	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
			8400X7	F		-DO-	-DO-	1.61	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
NOTE :- F = FILLET WELD, B = BUTT WELD SCE = SURFACE CRACK EXAMINATION. WELD CLASSIFICATION GROUP ACC. TO HW0620099. WELDING TEST SCOPE ACC. TO HW0850199.					GRADE OF UNTOL. DIM		-GMS No./- C B O M-		STATUS OF DRG		TYPE OF PRODUCT STEAM TURBINE OR NAME OF CUSTOMER/PROJECT																					
					M/CG.- AA0230208 m		ACREED DEPT	NAME	SIGN	DATE																						
					WELDING-CLASS 'B' OF AA0621104		WT		S.K.THAKUR		sd/-		21.11.16		 BHARAT HEAVY ELECTRICALS LTD. RANIPUR, HARDWAR		DRN		NAME		SIGN		DATE		NO. OF VAR							
					GAS CUTTING-TABLE 3 OF AA0621101												CHD		M MITTAL		sd/-		24.09.2016									
					REV		DATE		ALTERED		REV		DATE		ALTERED		DEPT		STE		SCALE		WEIGHT (KG)		REF. TO ASSY. DRG.		ITEM No.		NO. OF ITEMS			
									CHECKED										CODE		4011											
																	TITLE :		FIELD WELDING SCHEDULE		CARD CODE		DRAWING NO. 3-10005-58000		7		22		23		24	
																									SHEET No. 05		No. OF SHEETS 09					

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Ref.Drawing No>

Sign & Date

Inventory No

FIRST ANGLE PROJECTION										(ALL DIMENSIONS ARE IN mm)										FORM DG 38(B)					
00089-90001-3 DRAWING No.																									
SL. NO.	DRAWING NO.	LOCATION OF WELD	WELD SEAM (LXW)	WELD DETAILS		WELD CLASS & CSR	NO. OF WELD PER UNIT	QTY. OF WELD METAL IN Kg. (APPROX.)	MATERIAL SPECIFICATION		ELECTRODE	PRE-HEAT TREAT.	POST-HEAT TREATMENT	PROCESS OF WELD AND SPECIFICATION											
		MAIN VIEW SHEATING SUPPORT FOR ITEM 9,10 FOR ITEM 11,12	3511X10 2873X10 4000X10	F F F	10 10 10	BS,BK,CSR-3 -DO- -DO-	1 -DO- -DO-	1.38 1.28 1.57	AA10455 -DO- AA10119	AA10119 -DO- AA10119	E7018 E7018 E7018	100° LOCALLY 100° LOCALLY NO PRE HEAT	NO POST HEAT NO POST HEAT NO POST HEAT	SMAW SMAW SMAW	CS11294 CS11294 CS11294										
8.	SHEATING FOR EXTRACTION A3 01078158000 LP 2	DETAIL D	1728X4 1040X4 960X4 1040X4 1169X4	F F F F F	4 4 4 4 4	BS,BK,CSR-3 BS,BK,CSR-3 BS,BK,CSR-3 BS,BK,CSR-3 BS,BK,CSR-3	-DO- -DO- -DO- -DO- -DO-	0.108 0.07 0.06 0.07 0.07	AA10119 AA10119 AA10119 AA10119 AA10119	AA10119 AA10119 AA10119 AA10119 AA10119	E7018 E7018 E7018 E7018 E7018	NO PRE HEAT NO PRE HEAT NO PRE HEAT NO PRE HEAT NO PRE HEAT	NO POST HEAT NO POST HEAT NO POST HEAT NO POST HEAT NO POST HEAT	SMAW SMAW SMAW SMAW SMAW	CS11294 CS11294 CS11294 CS11294 CS11294										
		DETAIL G	2671X10	F		-DO-	-DO-	1.70	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294										
		DETAIL J	1508X10 3268X10 1508X5	F F F	10 10 5	-DO- -DO- -DO-	-DO- -DO- -DO-	0.95 1.29 0.30	AA10119 AA10119 AA10401	AA10109 AA10119 AA10109	E7018 E7018 E7018	NO PRE HEAT NO PRE HEAT NO PRE HEAT	NO POST HEAT NO POST HEAT NO POST HEAT	SMAW SMAW SMAW	CS11294 CS11294 CS11294										
		SECTION E-E	1468X6 1040X6 500X4 1040X6 529X6 720X6	F F F F F F	6 6 4 6 6 6	BS,BK,CSR-3 BS,BK,CSR-3 BS,BK,CSR-3 BS,BK,CSR-3 BS,BK,CSR-3 BS,BK,CSR-3	-DO- -DO- -DO- -DO- -DO- -DO-	0.21 0.15 0.03 0.15 0.07 0.10	AA10119 AA10119 AA10119 AA10119 AA10455 AA10119	AA10119 AA10119 AA10119 AA10119 AA10119 AA10119	E7018 E7018 E7018 E7018 E7018 E7018	NO PRE HEAT NO PRE HEAT NO PRE HEAT NO PRE HEAT 100° LOCALLY NO PRE HEAT	NO POST HEAT NO POST HEAT NO POST HEAT NO POST HEAT NO POST HEAT NO POST HEAT	SMAW SMAW SMAW SMAW SMAW SMAW	CS11294 CS11294 CS11294 CS11294 CS11294 CS11294										
		DETAIL I	3600X7 8400X7	F F	7 7	BS,BK,CSR-3 BS,BK,CSR-3	-DO- -DO-	1.08 1.61	AA10401 AA10119	AA10119 AA10119	E7018 E7018	NO PRE HEAT NO PRE HEAT	NO POST HEAT NO POST HEAT	SMAW SMAW	CS11294 CS11294										
				-GMS No./- C B O M-		STATUS OF DRG		TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT																	
				ACREED DEPT		NAME		SIGN		DATE															
				WT		S.K.THAKUR		sd/-		21.11.16															
				GRADE OF UNTOL. DIM																					
				M/CG.- AA0230208 m																					
				WELDING-CLASS 'B' OF AA0621104																					
				GAS CUTTING-TABLE 3 OF AA0621101																					
				REV		DATE		ALTERED				DEPT		STE		SCALE		WEIGHT (KG)		REF. TO ASSY. DRG.		ITEM No.		NO. OF ITEMS	
				CHECKED				CHECKED				CODE		4011											
												TITLE :		FIELD WELDING SCHEDULE				CARD CODE		DRAWING NO.		3-10005-58000			
																				SHEET No. 06		No. OF SHEETS 09			

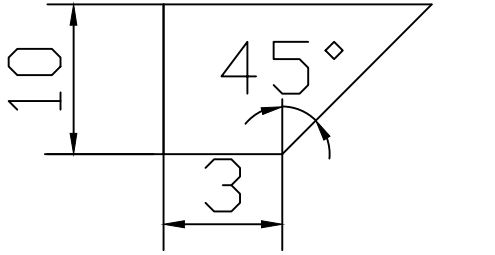
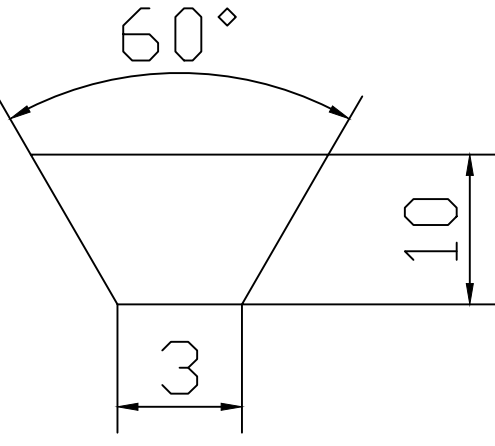
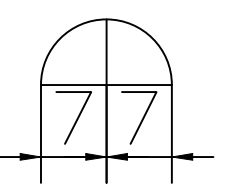
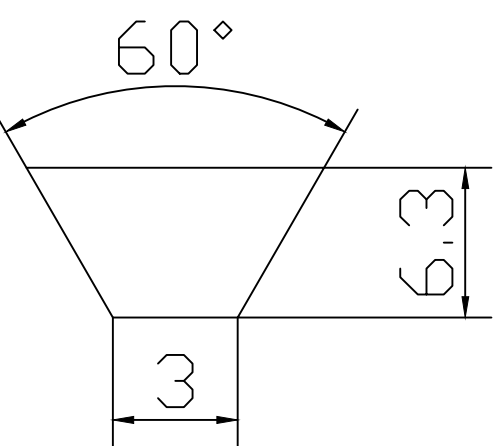
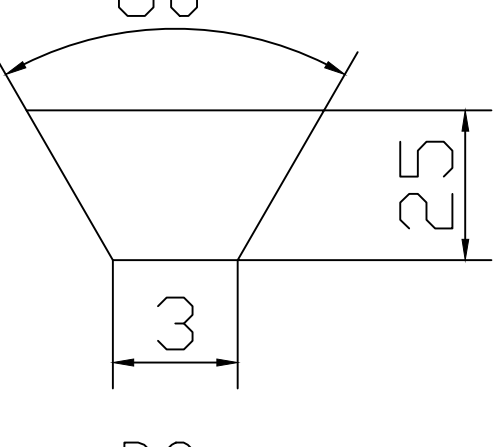
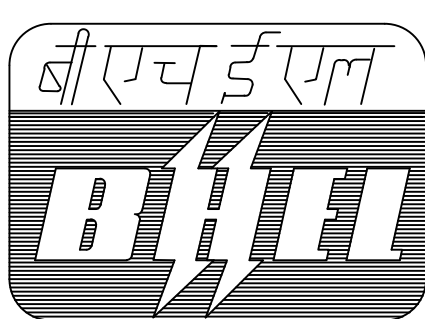
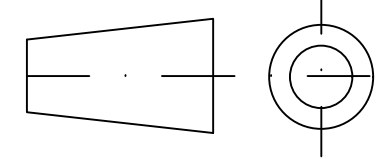
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Ref.Drawing No>

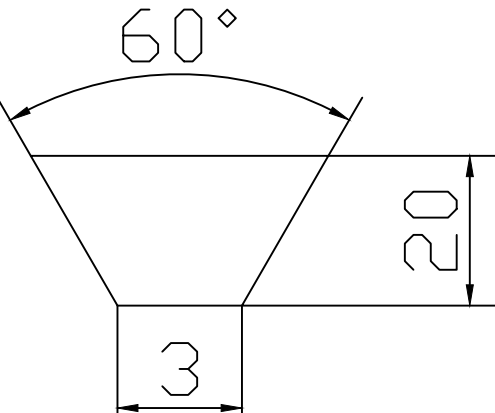
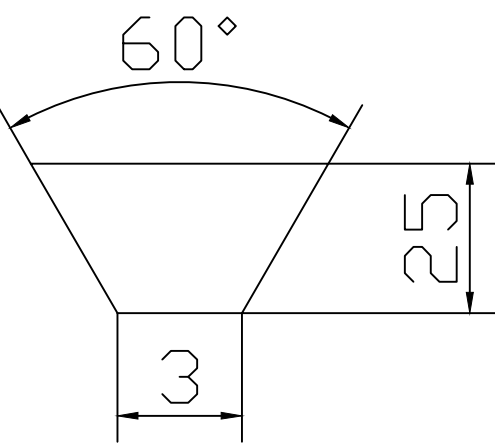
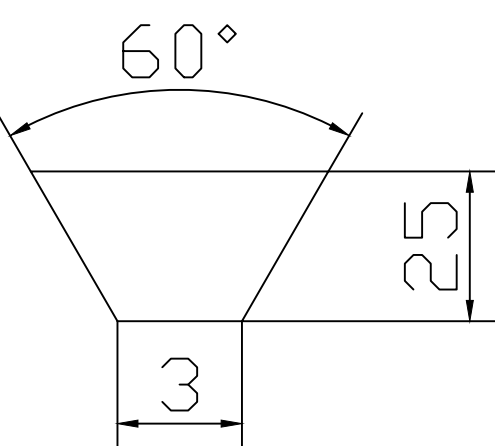
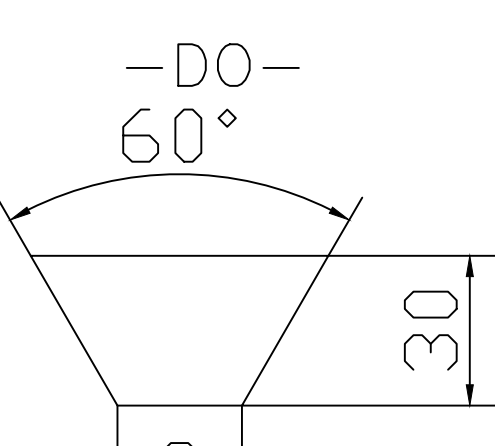
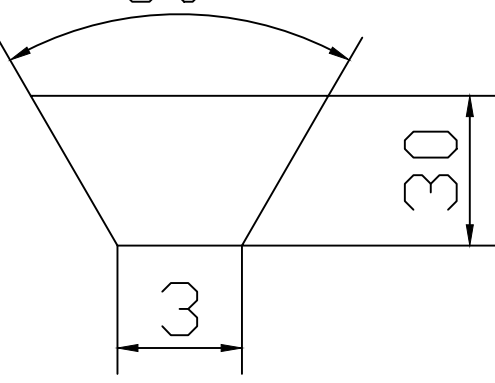
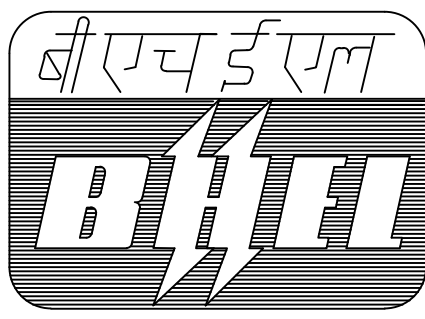
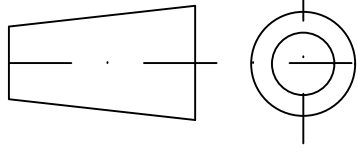
Sign & Date

Inventory No

FIRST ANGLE PROJECTION															(ALL DIMENSIONS ARE IN mm)										FORM DG 38(B)						
00089-90001-3 DRAWING No.																															
SL. NO.	DRAWING NO.	LOCATION OF WELD	WELD SEAM (LXW)	WELD DETAILS		WELD CLASS & CSR	NO. OF WELD PER UNIT	QTY. OF WELD METAL IN Kg. (APPROX.)	MATERIAL SPECIFICATION		ELECTRODE	PRE-HEAT TREAT.	POST-HEAT TREATMENT	PROCESS OF WELD AND SPECIFICATION																	
				TYPE	SIZE																										
		DETAIL F	2671X10	F		BS,BK,CSR-3	1	1.68	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
		DETAIL L	4713X10	F	-DO-	-DO-	-DO-	2.95	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
		DETAIL M	275X10	B		-DO-	-DO-	0.19	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
		DETAIL K	14834X10	B	-DO-	-DO-	-DO-	10.21	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
		MAIN VIEW SHEATING SUPPORT FOR ITEM 9,10	3511X10	F	▽ 10	BS,BK,CSR-3	-DO-	1.40	AA10455	AA10119	E7018	100° LOCALLY	NO POST HEAT	SMAW	CS11294																
		FOR ITEM 11,12	4000X10	F	▽ 10	BS,BK,CSR-3	-DO-	1.57	AA10455	AA10119	E7018	100° LOCALLY	NO POST HEAT	SMAW	CS11294																
	CROSS OVER PIPE 01071358000	SECTION J1-J1	528X7	F		BS,BK,CSR-2	-DO-	0.32	HW10568	HW10568	E7018 A1	100-150°C LOCALLY	NO POST HEAT	SMAW	AS112159																
		DETAIL X1	689X25	F	▽ 25	-DO-	-DO-	1.90	AA10119	AA10455	E7018	100° LOCALLY	NO POST HEAT	SMAW	CS11294																
		DETAIL X2	689X6.3	B		-DO-	-DO-	0.23	AA10455	HW10570	E7018 A1	100-150°C LOCALLY	NO POST HEAT	SMAW	AS112159																
		DETAIL L5	6283X25	B		-DO-	-DO-	21.5	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																
		DETAIL H	1127X25	B	-DO-	-DO-	-DO-	3.9	HW10568	AA10455	E7018 A1	100-150°C LOCALLY	NO POST HEAT	SMAW	AS112159																
						-GMS No./- C B O M-		STATUS OF DRG	TYPE OF PRODUCT STEAM TURBINE OR NAME OF CUSTOMER/PROJECT																						
NOTE :- F = FILLET WELD, B = BUTT WELD SCE = SURFACE CRACK EXAMINATION. WELD CLASSIFICATION GROUP ACC. TO HW0620099. WELDING TEST SCOPE ACC. TO HW0850199.				GRADE OF UNTOL. DIM		AGREED DEPT	NAME	SIGN	DATE	 BHARAT HEAVY ELECTRICALS LTD. RANIPUR, HARDWAR					DRN	NAME	SIGN	DATE	NO. OF VAR												
				M/CG.- AA0230208 m		WT	S.K.THAKUR	sd/-	21.11.16						CHD	PRADEEP	sd/-	23.09.2016													
				WELDING-CLASS 'B' OF AA0621104											APPD	D.K.RAY	sd/-	22.11.2016													
				GAS CUTTING-TABLE 3 OF AA0621101																											
REV	DATE	ALTERED	REV	DATE	ALTERED	REV	DATE	ALTERED	DEPT STE		SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.		ITEM No.	NO. OF ITEMS															
		CHECKED			CHECKED			CHECKED	CODE 4011																						
										TITLE : FIELD WELDING SCHEDULE			CARD CODE	DRAWING NO. 3-10005-58000																	
													SHEET No. 07		No. OF SHEETS 09																

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FIRST ANGLE PROJECTION										(ALL DIMENSIONS ARE IN mm)										FORM DG 38(B)												
00089-90001-3 DRAWING No.																																
SL. NO.	DRAWING NO.	LOCATION OF WELD	WELD SEAM (LXW)	WELD DETAILS		WELD CLASS & CSR	NO. OF WELD PER UNIT	QTY. OF WELD METAL IN Kg. (APPROX.)	MATERIAL SPECIFICATION		ELECTRODE	PRE-HEAT TREAT.	POST-HEAT TREATMENT	PROCESS OF WELD AND SPECIFICATION																		
				TYPE	SIZE																											
9.	CROSS OVER PIPE 01071358000	DETAIL K3	6283X20	B		BS,BK,CSR-2	1	14.35	AA10401	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
		DETAIL H1	1127X25	B		-DO-	-DO-	3.9	AA10455	AA10455	ER7018-6	NO PRE HEAT	NO POST HEAT	GTAW	CS110114																	
		SECTION G1-G1	3040X10	F	▽ 10	BS,BK,CSR-2	-DO-	1.2	AA10401	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
		DETAIL T	1280X10	F	▽ 10	BS,BK,CSR-2	-DO-	0.50	AA10401	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
		DETAIL U	3040X10	F	▽ 10	BS,BK,CSR-2	-DO-	1.20	AA10401	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
		DETAIL K2	6283X25	B		BS,BK,CSR-2	-DO-	21.5	AA19341	AA10119	E7018	100-150 °C LOCALLY	NO POST HEAT	SMAW	CS11294																	
		DETAIL H2	1127X25	B		-DO-	-DO-	3.85	HW10568	AA10455	E7018 A1	100-150 °C LOCALLY	NO POST HEAT	SMAW	AS112159																	
		DETAIL P1	8168X30	B		-DO-	-DO-	39.08	AA10119	AA10119	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
		SECTION A-A	1200X10	F	▽ 10	-DO-	-DO-	0.50	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
		DETAIL Y	7075X20	F	▽ 20	-DO-	-DO-	11.10	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
			7075X9	F	▽ 9	-DO-	-DO-	2.25	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
		10.	CASING FRAME SECTION 01072458000	SECTION E2-E2	692X17.5	F	▽ 17.5	BS,BK,CSR-1	-DO-	1.02	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294															
				SECTION E1-E1	692X17.5	F	▽ 17.5	BS,BK,CSR-1	-DO-	1.02	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294															
SECTION C1-C1	3760X10			F	▽ 10	BS,BK,CSR-1	-DO-	2.06	-DO-	-DO-	E7018	NO PRE HEAT	NO POST HEAT	SMAW	CS11294																	
Ref.Drawing No>					-GMS No./- C B O M-		STATUS OF DRG	TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT																								
	ACREED DEPT		NAME	SIGN	DATE																											
	NOTE :- F = FILLET WELD, B = BUTT WELD SCE = SURFACE CRACK EXAMINATION. WELD CLASSIFICATION GROUP ACC. TO HW0620099. WELDING TEST SCOPE ACC. TO HW0850199.				GRADE OF UNTOL. DIM		WT		S.K.THAKUR	sd/-	21.11.16	 BHARAT HEAVY ELECTRICALS LTD. RANIPUR, HARDWAR <table><tr><td>DRN</td><td>NAME</td><td>SIGN</td><td>DATE</td><td rowspan="3">NO. OF VAR</td></tr><tr><td>CHD</td><td>M MITTAL</td><td>sd/-</td><td>24.09.2016</td></tr><tr><td>APPD</td><td>D.K.RAY</td><td>sd/-</td><td>22.11.2016</td></tr></table>								DRN	NAME	SIGN	DATE	NO. OF VAR	CHD	M MITTAL	sd/-	24.09.2016	APPD	D.K.RAY	sd/-	22.11.2016
	DRN	NAME	SIGN	DATE	NO. OF VAR																											
CHD	M MITTAL	sd/-	24.09.2016																													
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REV		DATE	ALTERED	REV	DATE	ALTERED	DEPT	STE	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.		ITEM No.	NO. OF ITEMS																		
			CHECKED				CODE	4011																								
Inventory No									TITLE :				CARD CODE	DRAWING NO. 3-10005-58000																		
									FIELD WELDING SCHEDULE					SHEET No. 08 No. OF SHEETS 09																		