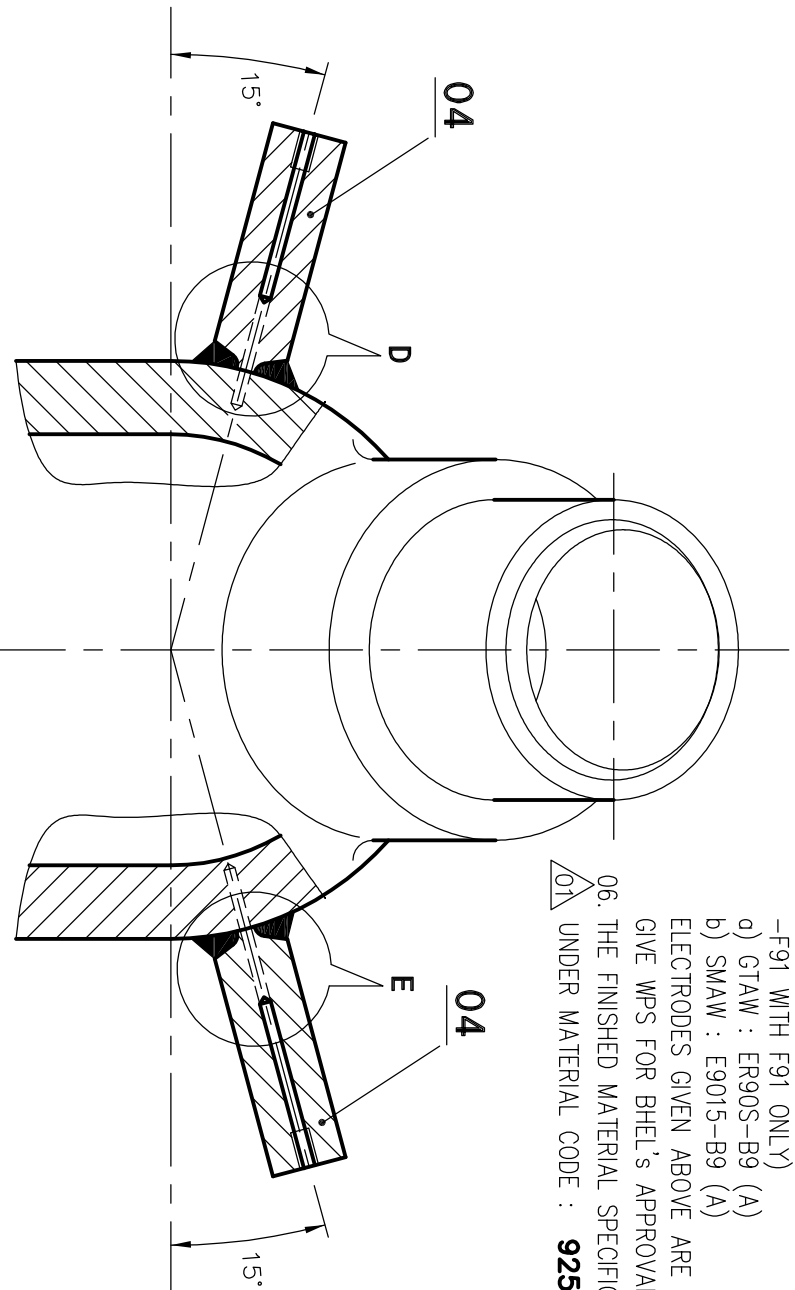


NOTES :-

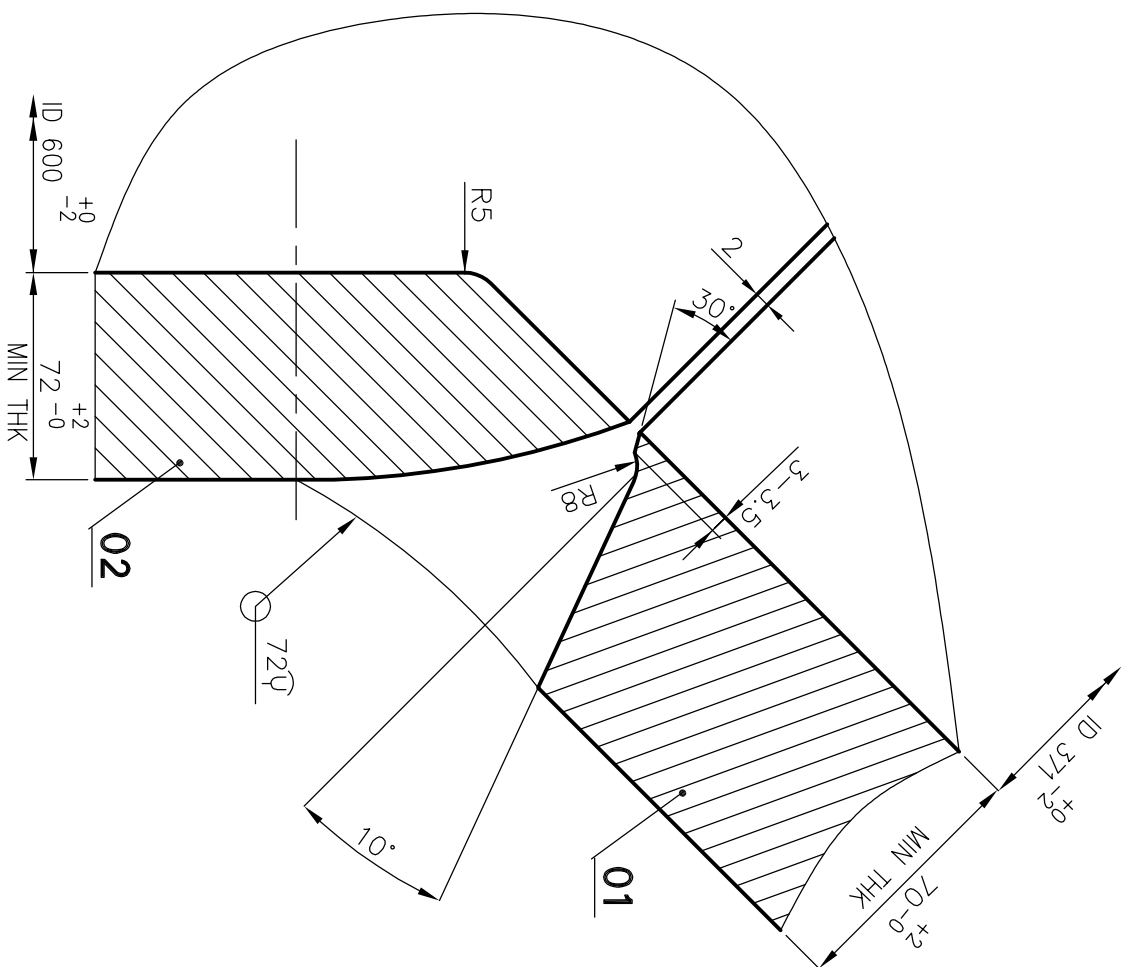
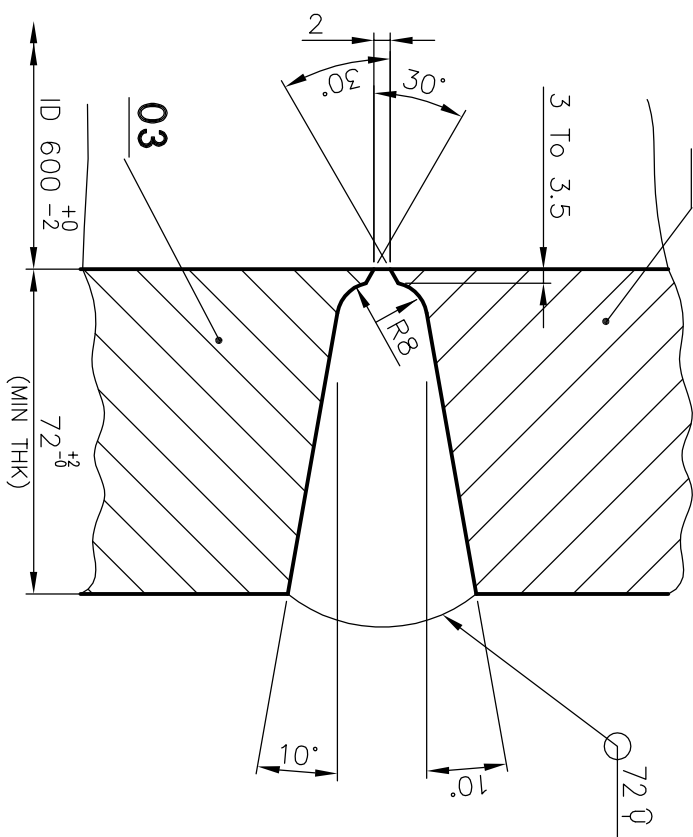
01. DESIGN PRESSURE : 188.6 Kg/Cm² (g)
02. DESIGN TEMPERATURE : 540° C
03. FOLLOW TDG: 108.
04. PIPE SA335P91(A) CAN ALSO BE USED IN PLACE OF SA182F91(A).
05. ELECTRODES TO BE USED ARE (FOR WELDING OF -F91 WITH F91 ONLY)
 - a) GTAW : ER90S-B9 (A)
 - b) SMAW : E9015-B9 (A)ELECTRODES GIVEN ABOVE ARE INDICATIVE. VENDOR TO GIVE WPS FOR BHEL's APPROVAL.
06. THE FINISHED MATERIAL SPECIFICATION WILL BE SA182F91(A) UNDER MATERIAL CODE : **925058150000**



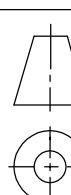
EP As Per DRG.
3-80-300-19825
FIG-X d1 =460



DETAIL-E



1

		BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, CHENNAI 600 017								
DEPT. CODE	GRADE OF UN TOL DIM C / M / F		SCALE N.T.S.	WEIGHT (Kg). 1632.000	BHD. PO REF. NO.	DRN	NAME	SIGN	DATE	NO
						CHD	PALANI		04-02-09	ITEMS
						APPD	VEKKAT		04-02-09	
							K.V.RAMANI		04-02-09	
TITLE Y-PIECE (OD559x54/OD457x43)		CARD CODE U 01		MSE DRAWING NO. 2-80-301-09376						REV 01

JOB NO.	VAR ITEM NO	DESCRIPTION	DRAWING NO	REL NO.	MATERIAL SPEC	DATE	
						A	QUANTITY
	04	TEMP. STUB. Ø50 L=150	2-80-301-09376		SA 182 F22 CL3	A	4 000 2
	03	OUTLET FORGING ID600 x THK 72 MIN / ID451 x 54 MIN THK	2-80-301-09376		SA 182 F91	A	445 000 1
	02	BODY FORGING ID 600 x THK 72 MIN	2-80-301-09376		SA 182 F91	A	555 000 1
	01	INLET FORGING ID 371 x THK 70 MIN	2-80-301-09376		SA 182 F91	A	312 000 2