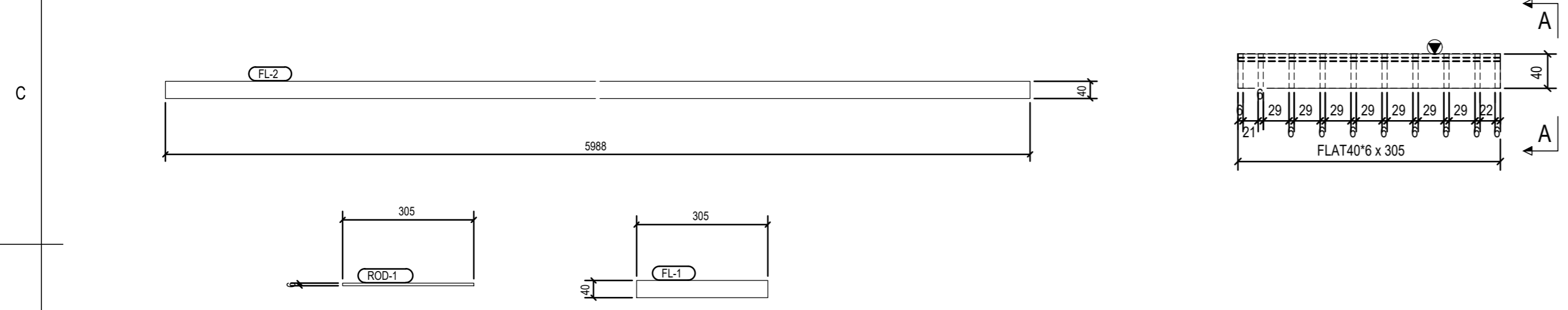


SECTION-AA



3D VIEW

TYPE & SIZE OF WELD	TYPE OF ELECTRODE
5 $\nabla$	E7018 (SMAW/GMAW)

NOTES: -

- FLOOR GRATINGS ARE TO BE GALVANISED BY HOT DIP PROCESS AFTER CLEANING BY PICKLING PROCESS. MINIMUM AVERAGE WEIGHT OF ZINC COATING SHALL BE 610 GRAMS PER SQ. METRE.
- STRUCTURAL STEEL CONFORMING TO SPECIFICATION IS 2062 E250A ONLY ARE TO BE USED
- GALVANISING TO BE DONE AFTER ALL WORKS ARE COMPLETED.
- ALL SCRATCHED SURFACES AND AREAS DAMAGED BY SITE WELDING SHALL RECEIVE ATLEAST TWO COATS OF COLD GALVANISING USING ZINC RICH PRIMER /PAINTS. THE TOTAL DRY FILM THICKNESS OF SUCH TOUCH UP COLD GALVANISING SHALL NOT BE LESS THAN 150 MICRONS.
- DESIGN LIVE LOAD FOR FLOOR GRILL = 1500 KG/SQ.M UPTO THE SPAN OF SUPPORTS (L) WILL BE 1.5M MAXIMUM.
- ALL GRATING MEMBERS ARE TO BE ELECTROFORGED EXCEPT BAND BARS.
- WEIGHT OF FLOOR GRILL INDICATED DOES NOT INCLUDE WEIGHT OF WELD, WHICH IS NEGLIGIBLE.
- FLOOR GRILLS ARE SUPPORTED BY INTERMITTENT FLOOR BEAMS SUCH THAT, FLOOR GRATINGS TAKE LIVE LOAD AS PER NOTE NO. 05 AND MAXIMUM DEFLECTION IS LIMITED TO  $L / 250$  OR 6MM WHICHEVER IS MINIMUM.
- FRAME AND LOAD BEARING BAR WELDING : ALL FOUR CORNERS TO BE FULL WELDED TO BAND BARS AND EVERY FIFTH LOAD BEARING BAR TO BE WELDED TO BAND BAR BY MANUAL WELDING FULL DEPTH, AT BOTH ENDS FROM ONE SIDE.
- TOLERANCE FOR LENGTH AND WIDTH OF GRATINGS SHALL BE  $\pm 5$  mm

NOTES:-

FOR ASSEMBLY DRAWING REFER PRINCIPAL DRAWING MENTIONED IN GMS

VARIANT NUMBER	ITEM NUMBER	DESCRIPTION	STD	PART MARK	ITEM NO	MATERIAL CODE	ACQ UNIT	UNIT WEIGHT	QTY	ZONE
	3	SQ. BAR 6.0x6.0x305.0		ROD-1		IS2062 E250A	No	0.086		
	2	FLAT-6 40.0x5988.0		FL-2		IS2062 E250A	No	11.281		
	1	FLAT-6 40.0x305.0		FL-1		IS2062 E250A	No	0.575		
							DI	2		

REV 01	DATE 21.06.2022	ALTERED : RGOVINDASAMY
		CHD & APPD : M.PADMANABAN
ZONE 01	BEARING BAR & CROSS ROD SPACING CHANGED DUE TO MANUFACTURING REQUIREMENT.	

<p>CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.</p>	TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT						
	<p><b>Bharat Heavy Electricals Ltd</b> UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI - 620014</p>		DRN	S.SETHUPATHI	SIGNATURE	DATE	
			CHD	M.PADMANABAN		20.04.2022	
			APPD	K.RAJIVGANDHI		20.04.2022	
DEPT	ST	ALL DIMENSIONS ARE IN MM	PROJECTION	SCALE	WEIGHT (Kg)	MATERIAL CODE:	
CODE	122		NTS	NTS	119.048	961710150000	
TITLE					DRAWING NO.:		REV
LONG SPAN FLOOR GRILL (40 X 305 X 6000mm)					2-FM-811-00180		01