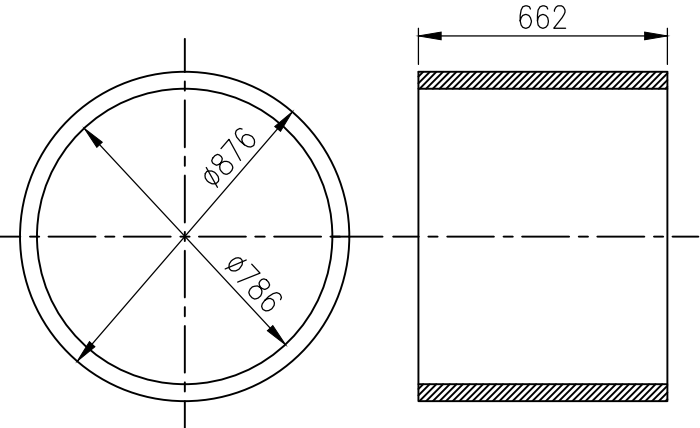
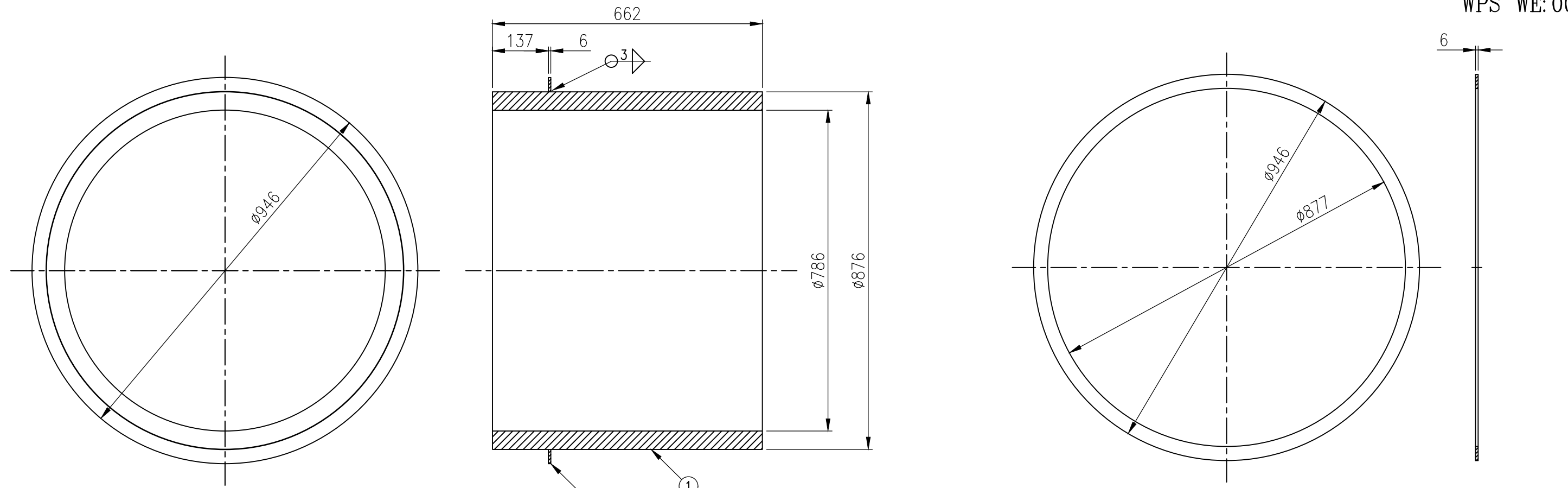
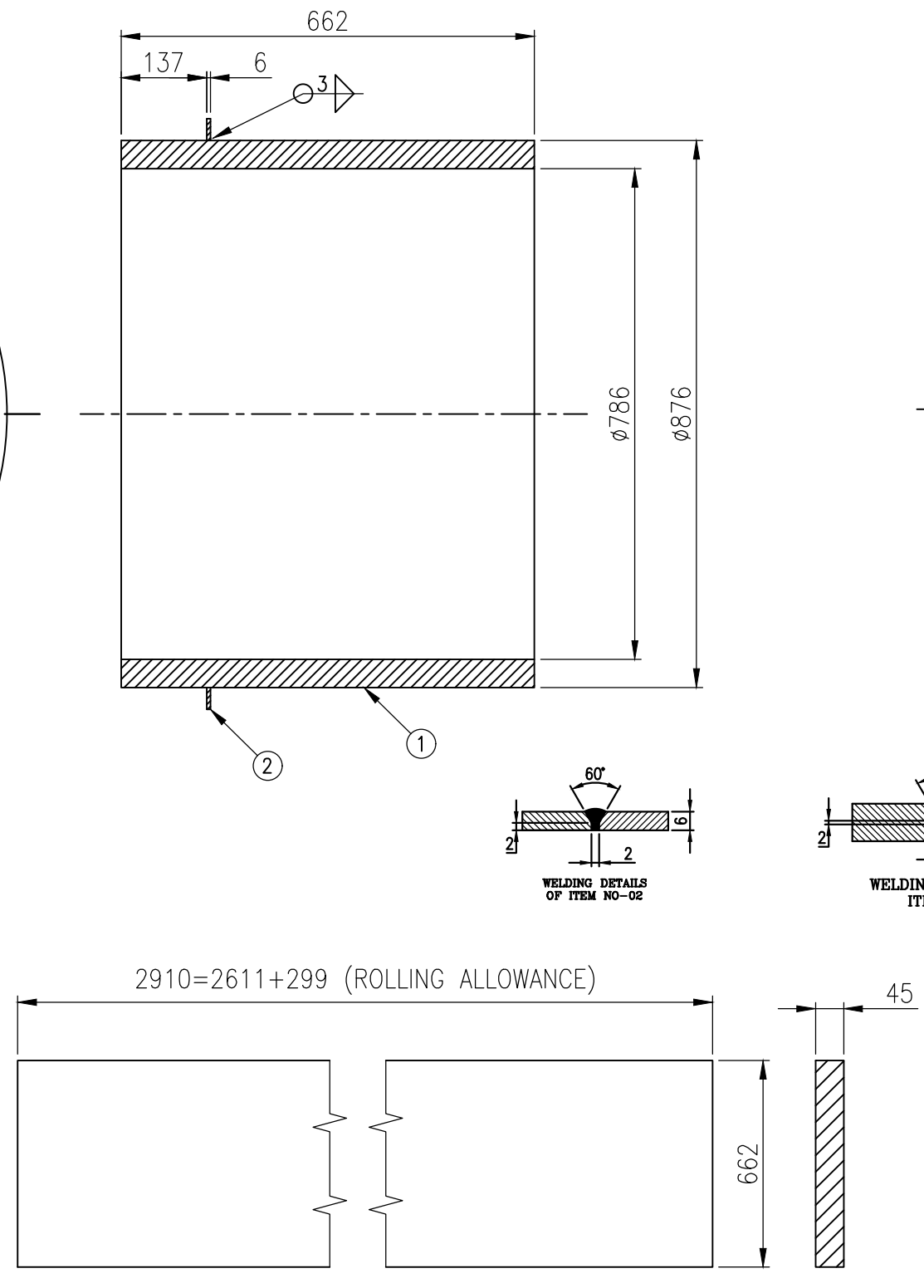


THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY

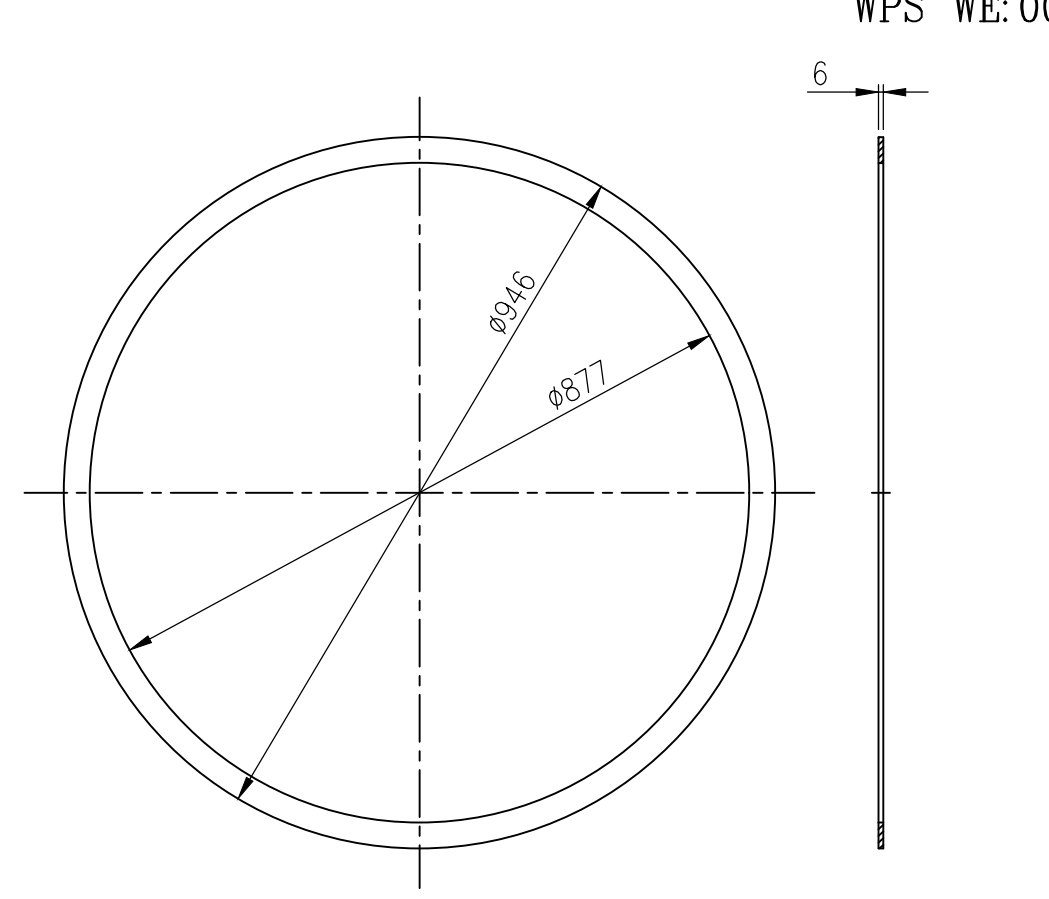
WPS WE: 001



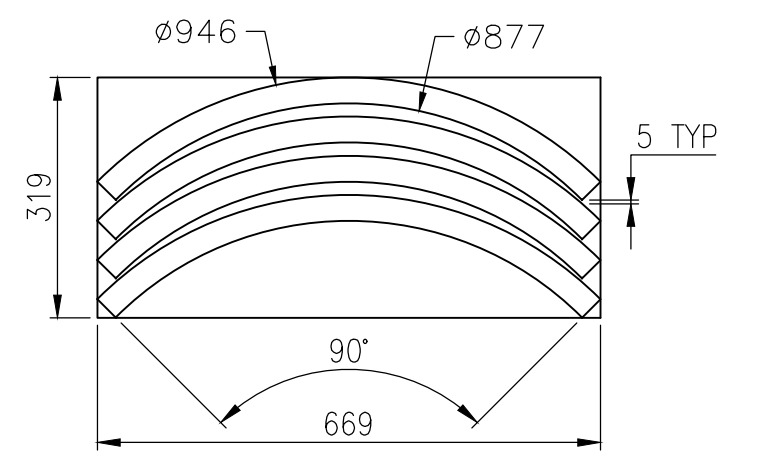
ITEM-01
SCALE 1:2



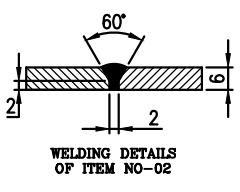
DEVELOPED LENGTH OF ITEM-01
SCALE 1:2



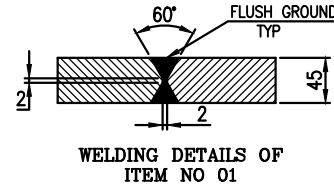
ITEM NO:2



ITEM NO:2 CUTTING PLAN



WELDING DETAILS
OF ITEM NO-02



WELDING DETAILS OF
ITEM NO 01

- NOTE:-
1. ALL BUTT WELDS TO BE FULL PENETRATION ' X ' WELDS.
 2. CARRY OUT LPI AFTER BACK CHIPPING OF ALL BUTT WELDS AS PER AA0850131
 3. ALL BUTT WELDS TO BE 10% SPOT RT TESTED AS PER HY0850170 ACCEPTANCE AS PER HY0850170

4. CARRY OUT LPI OF ALL FINISHED WELDS.

REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.	REV.	DATE	ALTERED	APPD.
ZONE		CHECKED		ZONE		CHECKED		ZONE		CHECKED		ZONE		CHECKED		ZONE		CHECKED		ZONE		CHECKED	
1				3				4				5				6				7			

2.	PLATE-2			PL. 6 X 324 X 674	AA1011808030	4.65	10.29
					AA10108		1
1.	PLATE-1			PL. 45 X 672 X 2910	AA1011819201	610.51	690.79
					AA10119		1
ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.
					MATERIAL SPECN.		QUANTITY

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED...

1. REF.TO HY0230261 FOR UNSPECIFIED TOLERANCES.
2. CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.
3. INTERNAL M/CD CORNER RADII 1 TO 0.7.
4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT										NAME		SIGN.		DATE		NO.OF VAR.	
		भारत हीवी इलेक्ट्रिकल्स लिमिटेड హైదరాబాద్ BHARAT HEAVY ELECTRICALS LTD. HYDERABAD								DRN.		ASHOK REDDY		05.11.12		NO.OF VAR.	
		CHD.		AMAN								05.11.12		NA-			
		APPD.		S.G.								05.11.12					
DEPT. PULV						SCALE		WEIGHT (KG)		REF. TO ASSY DRG.				ITEM NO.		NO.OF ITEMS	
CODE 446						1:5		615.16		1-61-310-01844				01		01	
TITLE BEARING HOUSING INNER (FAB) DYNAMIC CLASSIFIER - HP 1103										DRAWING NO.						REV.	
										2-61-310-03242						02	
										SHEET NO. 01				NO OF SHEETS 01			