

52861-006-08-3

9N 5N1W1RD

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

NOTES:— 01. **APPLICABLE FOR P91/P92**
i) **STRAIGHT WITH STRAIGHT/FITTING**
03. **BEND WITH BEND/FITTING**

02. FOR OD MISMATCH, REFER FIGURE-Xa

03. REFER STYLE-DL FOR THICKNESS <14.2mm (FOR ALL OD/ID)

04. REFER STYLE-PL (FOR ALL OD/ID)

i) WHEN THICKNESS IS ≥ 14.2 mm & <20mm (FOR ALL OD/ID)

ii) WHEN THICKNESS ≥20mm & OD <219.1mm, 05. α = 6° FOR WALL THICKNESS ≥20MM AND ≤ 30 mm

06. α = 10° FOR WALL THICKNESS > 30 mm

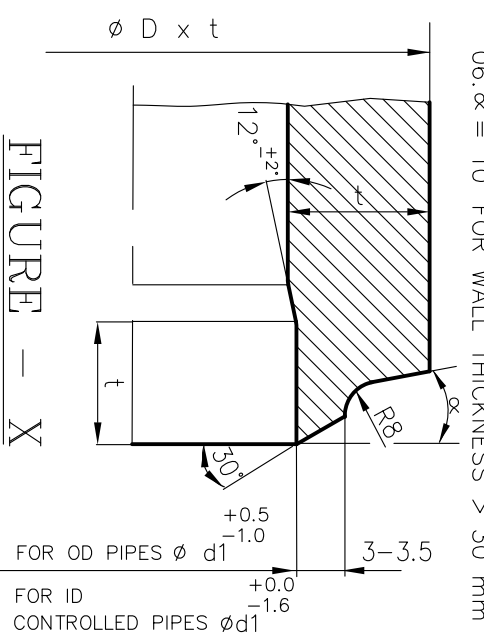


FIGURE – X

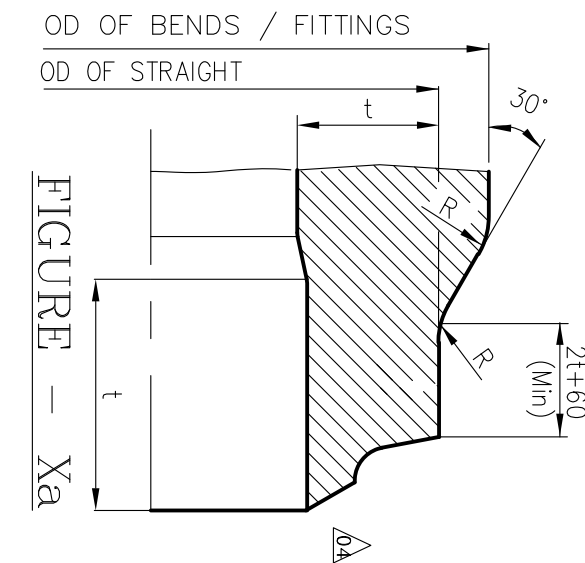
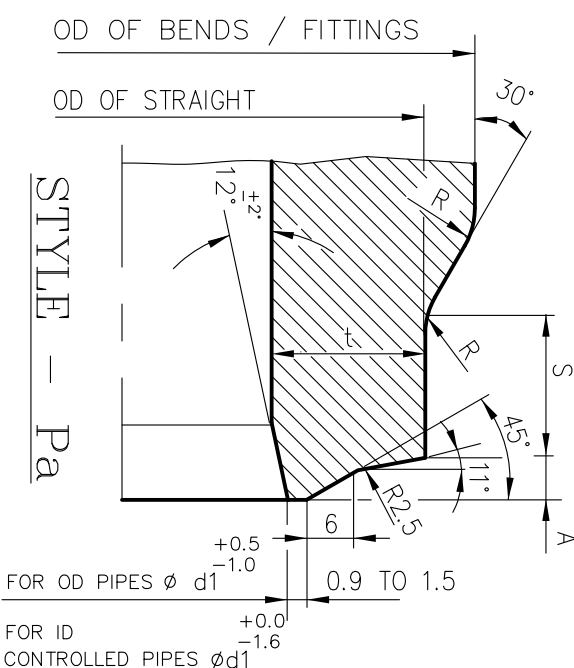


FIGURE – Xa

MATCHING EDGE PREPARATION
FOR MISMATCH OD APPLICABLE FOR BENDS/FITTINGS OF P91/P92 MATERIALS
NOTES:—
01. OD OF STRAIGHT TO BE PHYSICALLY MEASURED/VERIFIED.
02. t = THK OF CONNECTING PIPE (STRAIGHT)

MATCHING EDGE PREPARATION FOR MISMATCH OD DIAMETRICALLY GREATER THAN 8 mm (ie OD1 – OD2 > 8mm) APPLICABLE FOR BENDS/FITTINGS OTHER THAN P91/P92 MATERIALS
NOTES:—
01. OD OF STRAIGHT TO BE PHYSICALLY MEASURED/VERIFIED.
02. WHEN t<65, S+A = 65 Min. & t>65,S=65 Min. WHERE t=THK OF CONN.PIPE(STRAIGHT).



STYLE – Pa

MATCHING EDGE PREPARATION FOR MISMATCH OD DIAMETRICALLY GREATER THAN 8 mm (ie OD1 – OD2 > 8mm) APPLICABLE FOR ELBOWS OTHER THAN P91/P92 MATERIALS
NOTES:—
01. OD = OUTSIDE DIA OF CONN. PIPE (STRAIGHT) TO BE PHYSICALLY MEASURED/VERIFIED.
02. t = THK OF CONN.PIPE (STRAIGHT)
03. t = THK OF CONN.PIPE (STRAIGHT)

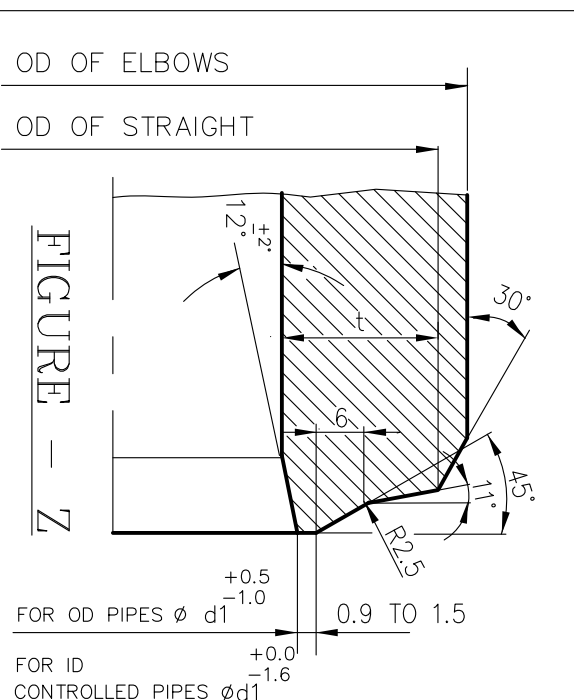


FIGURE – Z

NOTES:— 01. **APPLICABLE FOR P91/P92 ZERO ARM PIPEBEND WELDED WITH P91/P92 STRAIGHT PIPE**

02. FOR OD MISMATCH, REFER FIGURE-Xa

03. REFER STYLE-DL FOR THICKNESS <14.2mm (FOR ALL OD/ID)

04. REFER STYLE-PL

i) WHEN THICKNESS IS ≥ 14.2 mm AND < 20 mm FOR ALL OD/ID.

ii) WHEN THICKNESS ≥20mm AND OD < 219.1 mm, 05. α =6° FOR WALL THICKNESS ≥20MM AND ≤ 30 mm

06. α = 10° FOR WALL THICKNESS > 30 mm

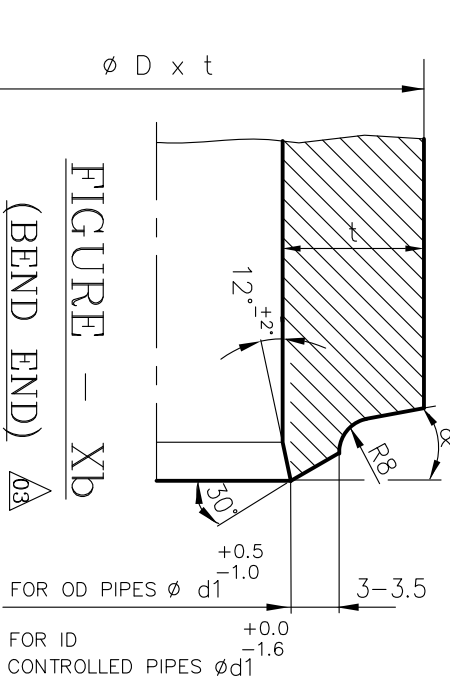


FIGURE – Xb

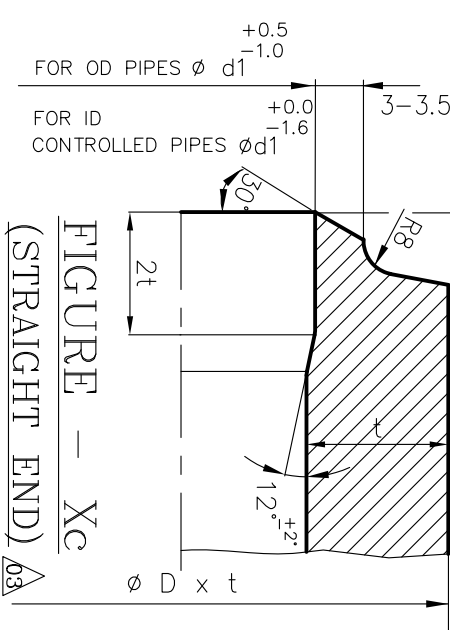
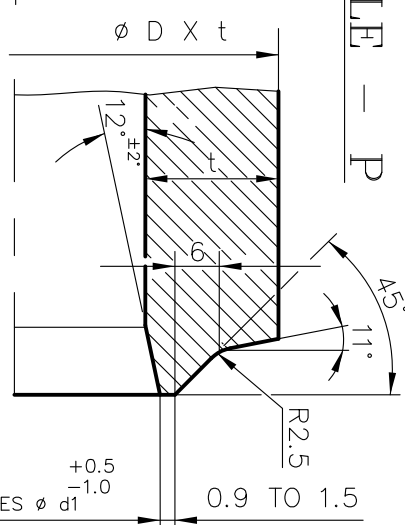


FIGURE – Xc

STYLE – P



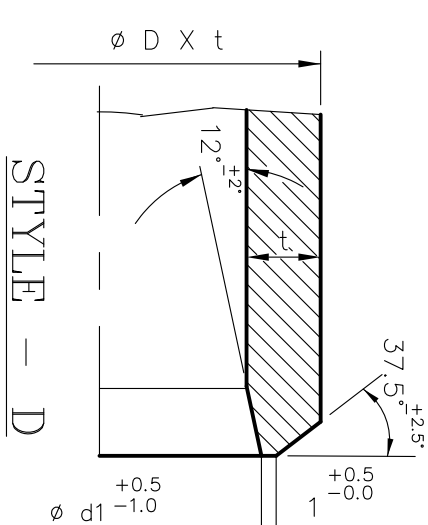
NOTES:—

01. USE WHEN t ≥ 14.2 mm AND < 70mm.

02. FOR t ≥ 70.0 mm REF. STYLE-Pm

03. FOR OD MISMATCHING REF. STYLE-Pa

NOTES:—
01. USE WHEN t < 14.2 mm.



STYLE – D

01

STANDARD

REV		DATE	ALTERED	P SURESH
04		07.12.16	APPROVED	R SESHAGIRI
SHEET 2 OF 2 IS ADDED.				
NOTES ADDED, MODIFIED AND DELETED IN FIGURE-X, Xa, Xb, Xc AND STYLE-P				
REV		DATE	ALTERED	M.R.K
03		10.04.13	APPROVED	C.K.N
FIG.Xb AND FIG.Xc ADDED IN FIG.X, NOTE 01 MODIFIED. IN FIG.Xa,ST-Pa,FIG.Z, F92 MATERIAL ADDED				
REV		DATE	ALTERED	M.R.K
02		10.01.13	APPROVED	C.K.N
IN FIG.Xa, NOTE 04 ADDED GENERAL NOTES 03 ADDED. IN FIG.Xa, BMM OD MISMATCH IS REMOVED				
REV		DATE	ALTERED	R.SENDHIL
01		11.05.04	APPROVED	A.VELAYUTHAM
PROJECT NAME REMOVED AND STANDARD INCORPORATED IN TITLE BLOCK				
REV		DATE	ALTERED	P SURESH
04		07.12.16	APPROVED	R SESHAGIRI
SHEET 2 OF 2 IS ADDED.				
NOTES ADDED, MODIFIED AND DELETED IN FIGURE-X, Xa, Xb, Xc AND STYLE-P				
REV		DATE	ALTERED	M.R.K
03		10.04.13	APPROVED	C.K.N
FIG.Xb AND FIG.Xc ADDED IN FIG.X, NOTE 01 MODIFIED. IN FIG.Xa,ST-Pa,FIG.Z, F92 MATERIAL ADDED				
REV		DATE	ALTERED	M.R.K
02		10.01.13	APPROVED	C.K.N
IN FIG.Xa, NOTE 04 ADDED GENERAL NOTES 03 ADDED. IN FIG.Xa, BMM OD MISMATCH IS REMOVED				
REV		DATE	ALTERED	R.SENDHIL
01		11.05.04	APPROVED	A.VELAYUTHAM
PROJECT NAME REMOVED AND STANDARD INCORPORATED IN TITLE BLOCK				

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, MADRAS	
DEPT.		GRADE OF UN TOL. DIM	SCALE
CODE		C/M/F	WEIGHT (Kg).
TITLE		EDGE PREPARATION DETAILS	CARD CODE
		U 01	DRAWING No. 3-80-300-19825
			SHEET 1 OF 2

GENERAL NOTES :

01. THE MINIMUM THICKNESS AT WELD END SHALL NOT BE LESS THAN

a) 0.875 TIMES t NOM. FOR OD PIPES.

b) t MIN. FOR ID CONTROLLED PIPES.

02. t NOM & t MIN SHALL BE AS PER SPECIFIED PIPE SIZE.

03. SHARP CORNERS SHALL BE ROUNDED OFF WHEREVER 'R' IS INDICATED.

NOTES FOR WELDING:

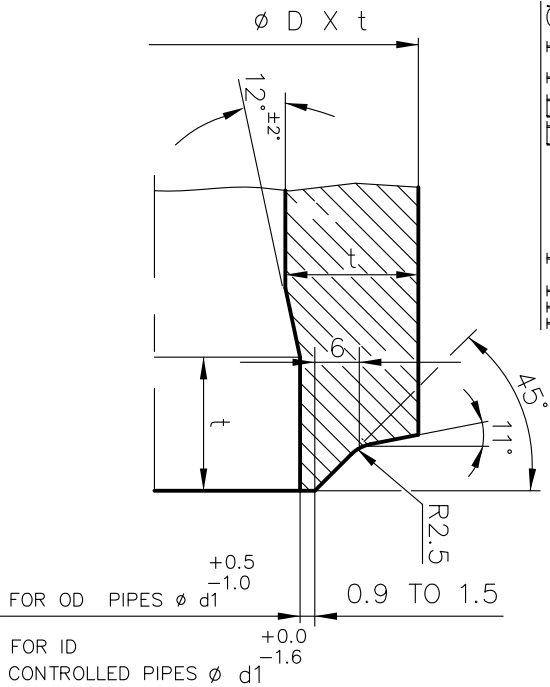
01. WELD REINFORCEMENT TO BE FLUSH GROUND AND MERGED WITH

PARENT METAL WITHOUT ANY UNEVENNESS.

52861-003-08-C

DRAWING No.

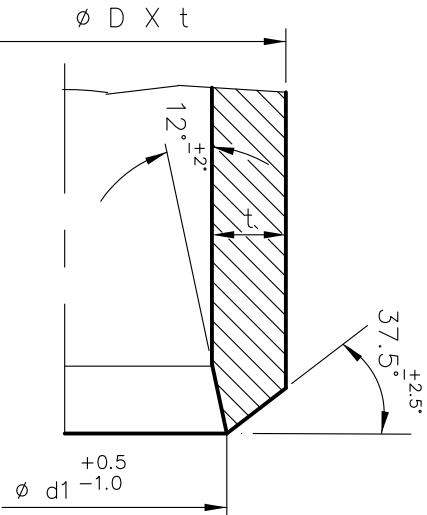
STYLE – Pm



NOTES: –

- 01. USE FOR SA106GRC PIPES WHEN $t \geq 70.0$ mm.
- 02. FOR OD MISMATCHING REF. FIGURE-Po
- 03. FOR FITTINGS USE STYLE-P.

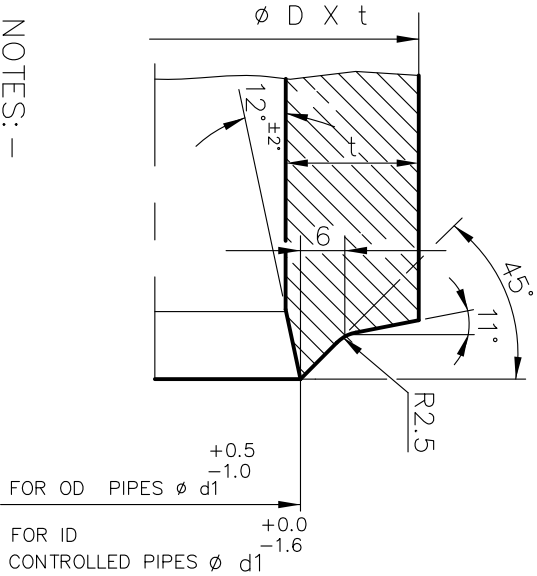
STYLE – DL



NOTES: –

- 01. USE FOR P91 / P92 PIPES AND FITTINGS WHEN $t < 14.2$ mm (ALL OD/ID).

STYLE – PL

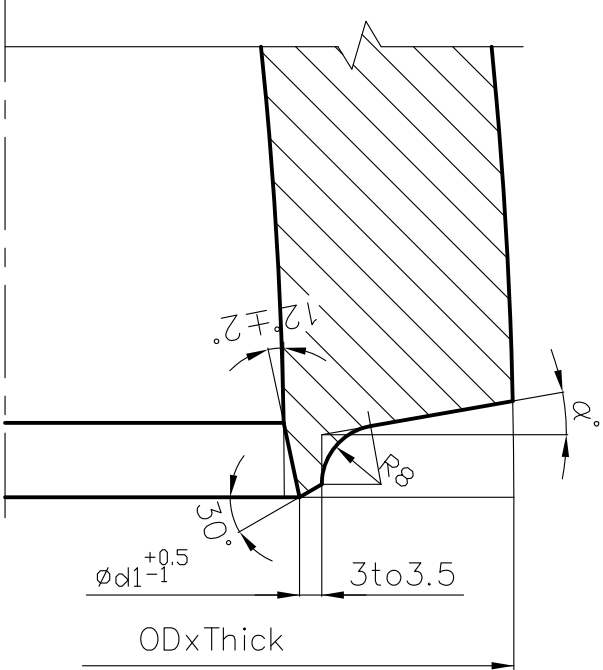


NOTES: –

- 01. USE FOR P91 / P92 PIPES AND FITTINGS
- i) WHEN THICKNESS IS ≥ 14.2 mm AND < 20 mm FOR ALL OD/ID.
- ii) WHEN THICKNESS ≥ 20 mm AND OD < 219.1 mm.
- 02. FOR OD MISMATCHING REF. FIGURE-Po

NOTE :

- 01. FOR GENERAL NOTES AND NOTES FOR WELDING REFER SHEET 1 OF 2.



- 01. USE FOR P91 / P92 FITTINGS
- 02. REFER STYLE-DL FOR THICKNESS < 14.2 mm FOR ALL OD/ID.
- 03. REFER STYLE-PL
- i) WHEN THICKNESS IS ≥ 14.2 mm AND < 20 mm FOR ALL OD/ID.
- ii) WHEN THICKNESS ≥ 20 mm AND OD < 219.1 mm.
- 04. $\alpha = 6^\circ$ FOR WALL THICKNESS ≥ 20 MM AND ≤ 30 mm
- 05. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm.
- 06. FIGURE-Xf IS APPLICABLE FOR ALL BUTT WELDED FITTINGS NOT COVERED IN NOTES 02 & 03

FIGURE – Xf

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT				STANDARD						
BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, MADRAS				NAME		SIGN		DATE		NO OF ITEMS
				DRN		P SURESH		07.12.16		
				CHD		R SESHAGIRI		07.12.16		
APPD		C KARUNAKARAN				07.12.16				
DEPT.	GRADE OF UN TOL. DIM		SCALE		WEIGHT (Kg).	NAME OF ORIGINAL ORGANISATION				
CODE	C/M/F									
TITLE				CARD CODE	DRAWING No.					REV
EDGE PREPARATION DETAILS				U 01	3-80-300-19825					04
					SHEET 2 OF 2					