

DRAWING No. 3-80-300-19825

NOTES: — 01. APPLICABLE FOR P91/P92
i) STRAIGHT WITH STRAIGHT/FITTING
ii) 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
i) WHEN THICKNESS IS ≥ 14.2 mm & <20mm (FOR ALL OD/ID)
ii) WHEN THICKNESS ≥ 20 mm & OD <219.1mm.
05. $\alpha = 6^\circ$ FOR WALL THICKNESS ≥ 20 mm AND ≤ 30 mm
06. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm

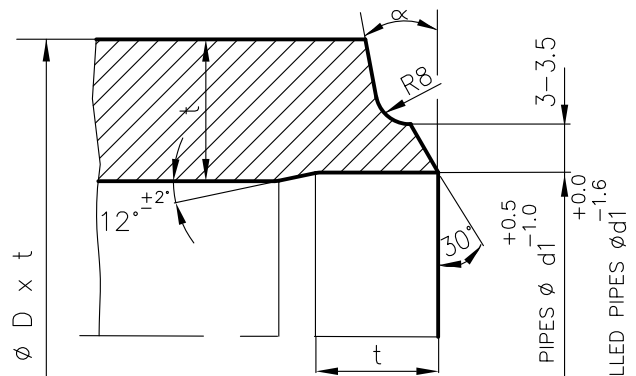


FIGURE - X

- 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)

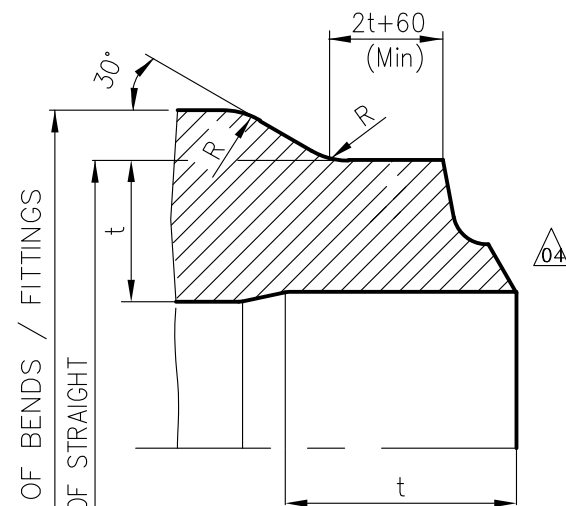


FIGURE - Xa

- 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.PIPES (STRAIGHT).

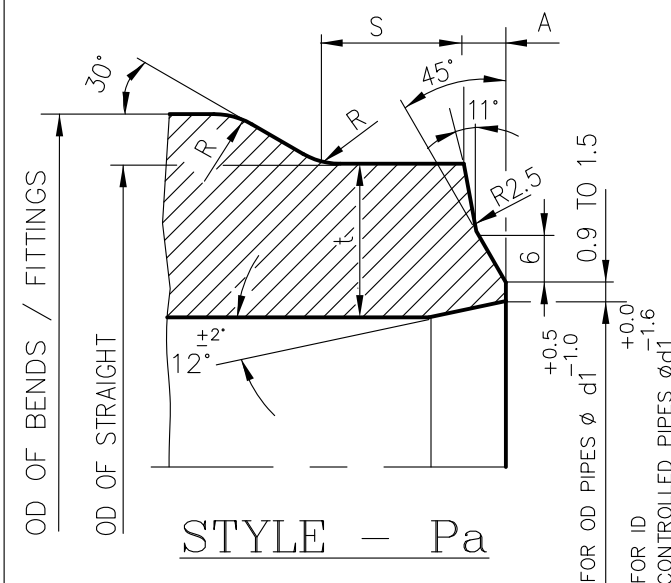


FIGURE - Pa

- 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.PIPES (STRAIGHT)
03. t = THK OF CONN.PIPES (STRAIGHT)

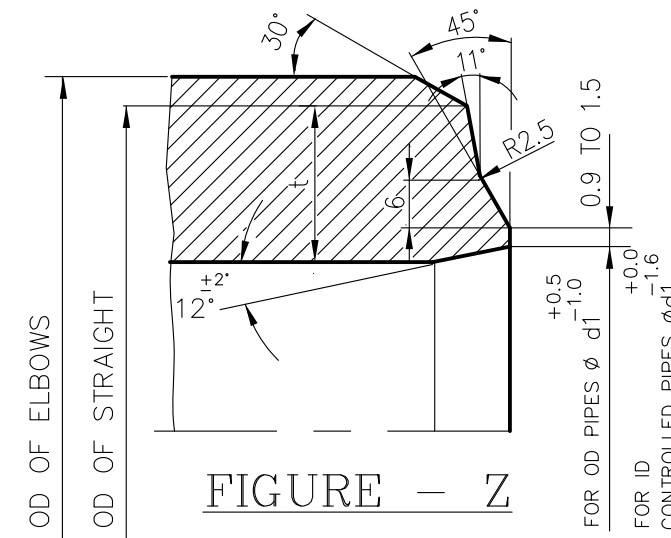


FIGURE - Z

- 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 ≥ 20 mm AND OD < 219.1 mm.
05. $\alpha = 6^\circ$ FOR WALL THICKNESS ≥ 20 mm AND ≤ 30 mm
06. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm

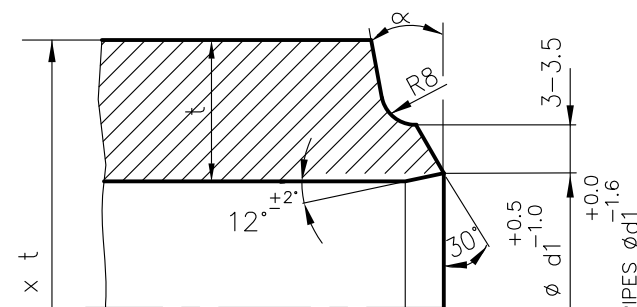


FIGURE - Xb

(BEND END)

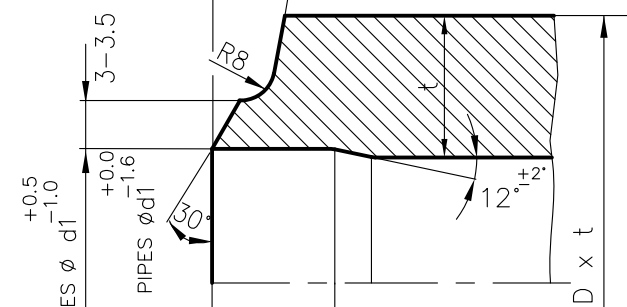
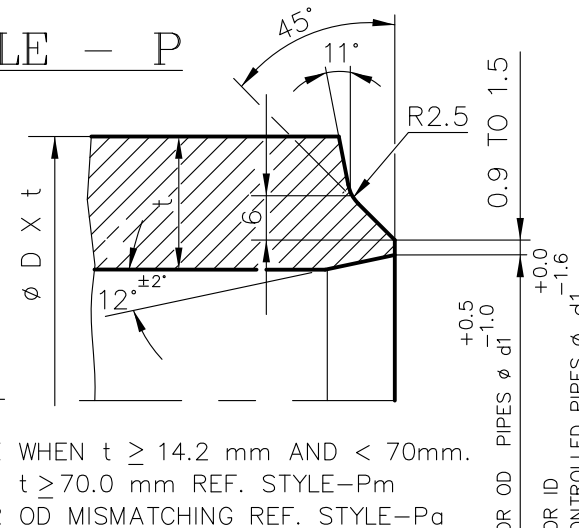


FIGURE - Xc

(STRAIGHT END)

STYLE - P



NOTES: —

01. USE WHEN $t \geq 14.2$ mm AND < 70mm.
02. FOR $t \geq 70.0$ mm REF. STYLE-Pm
03. FOR OD MISMATCHING REF. STYLE-Pa

- NOTES: — 01. USE WHEN $t < 14.2$ mm.

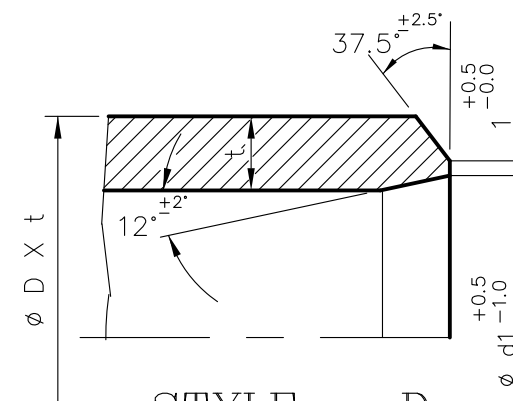


FIGURE - D

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

STANDARD

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 WHEREEVER 'R' IS INDICATED.

NOTES FOR WELDING:

01. WELD REINFORCEMENT TO BE FLUSH GROUND AND MERGED WITH PARENT METAL WITHOUT ANY UNEVENNESS.

REV 04	DATE 07.12.16	ALTERED: P SURESH APPROVED: R SESHAGIRI
ZONE	SHEET 2 OF 2 IS ADDED. NOTES ADDED, MODIFIED AND DELETED IN FIGURE-X, Xa, Xb, Xc AND STYLE-P	
REV 03	DATE 10.04.13	ALTERED: M.R.K APPROVED: C.K.N
ZONE	FIG Xb AND FIG Xc ADDED. IN FIG.X, NOTE 01 MODIFIED. IN FIG.Xa, STY-Pa, FIG.Z, P92 MATERIAL ADDED	
REV 02	DATE 10.01.13	ALTERED: M.R.K APPROVED: C.K.N
ZONE	IN FIG.Xa, NOTE 04 ADDED. GENERAL NOTES 03 ADDED. IN FIG.Xa, 8MM OD MISMATCH IS REMOVED	
REV 01	DATE 11.05.04	ALTERED: R.SENDHIL APPROVED: A.VELAYUTHAM
ZONE	PROJECT NAME REMOVED AND STANDARD INCORPORATED IN TITLE BLOCK	

BHARAT HEAVY ELECTRICALS LTD.,
PIPING CENTRE, MADRAS

DEPT.

GRADE OF UN TOL. DIM

CODE

C/M/F

TITLE

EDGE PREPARATION
DETAILS

DRN	NAME K.B.RAGUNATH	SIGN	DATE 11.10.01	NO OF ITEMS
CHD	M.C.SEKARAN		11.10.01	
APPD	A.VELAYUTHAM		11.10.01	

WEIGHT (Kg).

NAME OF ORIGINAL ORGANISATION

ITEM No.

DRAWING No.

3-80-300-19825

REV

04

SHEET 1 OF 2

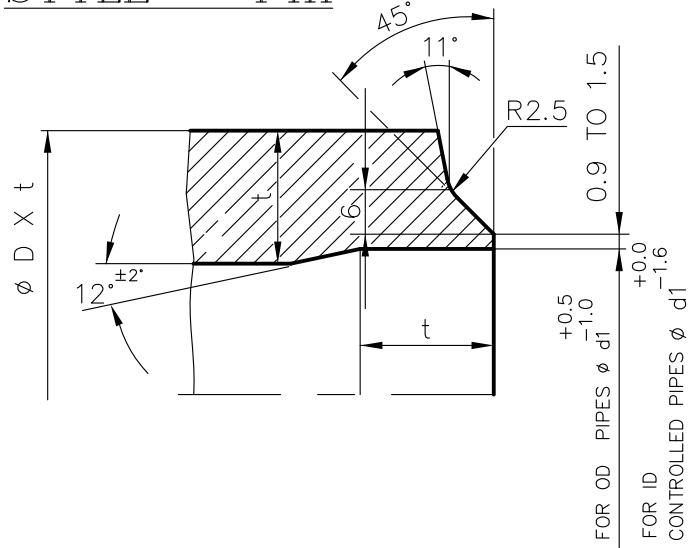
SIZE A3

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3-80-300-19825

DRAWING No.

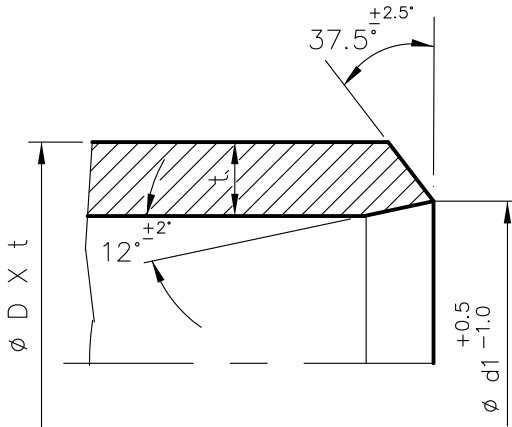
STYLE - P_m



NOTES: -

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

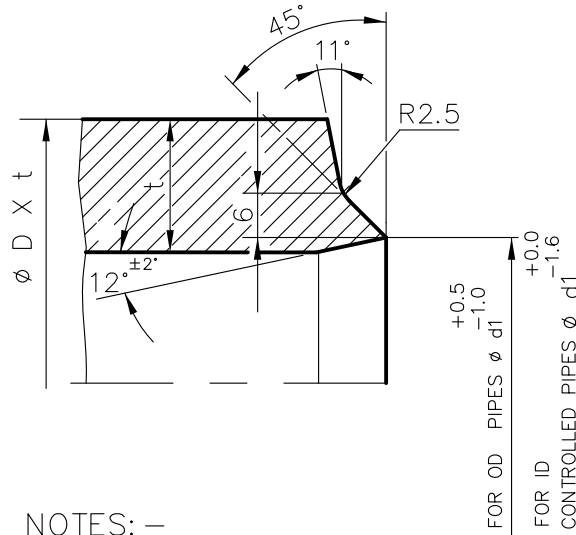
STYLE - D_L



NOTES: -

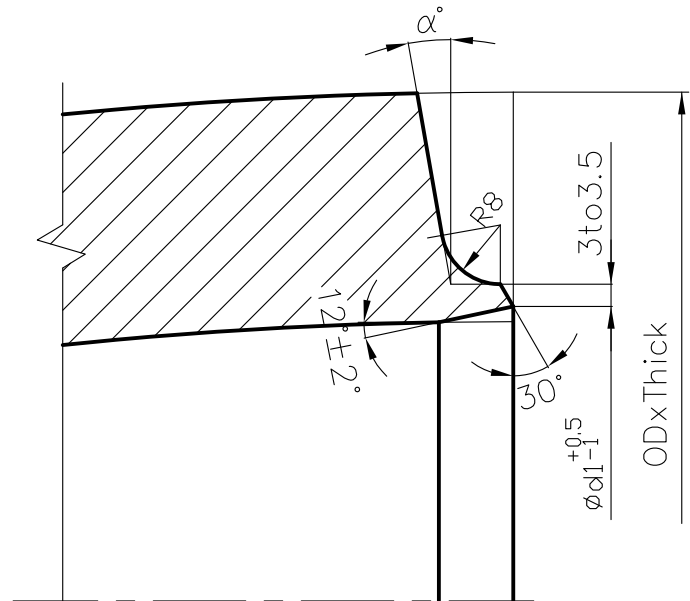
01. USE FOR P91 / P92 PIPES AND FITTINGS WHEN $t < 14.2$ mm (ALL OD/ID).

STYLE - P_L



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-P_a



01. USE FOR P91 / P92 FITTINGS
02. REFER STYLE-D_L FOR THICKNESS < 14.2 mm FOR ALL OD/ID.
03. REFER STYLE-P_L
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

NOTE :

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

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

STANDARD



BHARAT HEAVY ELECTRICALS LTD.,
PIPING CENTRE, MADRAS

DRN	NAME	SIGN	DATE	NO OF ITEMS
CHD	P SURESH		07.12.16	
APPD	R SESHAGIRI		07.12.16	
	C KARUNAKARAN		07.12.16	

DEPT.	GRADE OF UN TOL. DIM	SCALE	WEIGHT (Kg).	NAME OF ORIGINAL ORGANISATION	ITEM No.
CODE	C/M/F				

TITLE	CARD CODE	DRAWING No.	REV
EDGE PREPARATION DETAILS	U 01	3-80-300-19825 SHEET 2 OF 2	04