

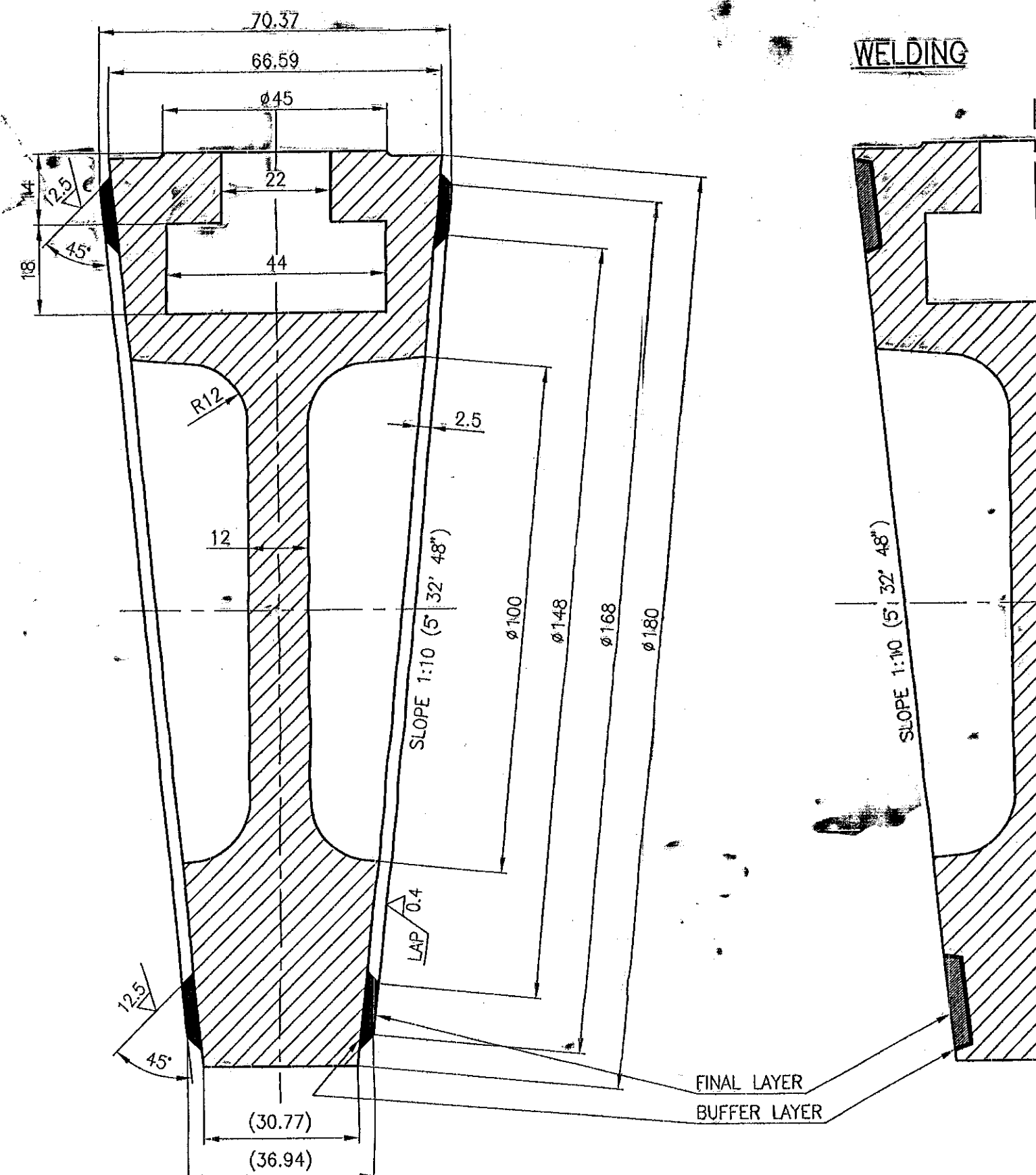
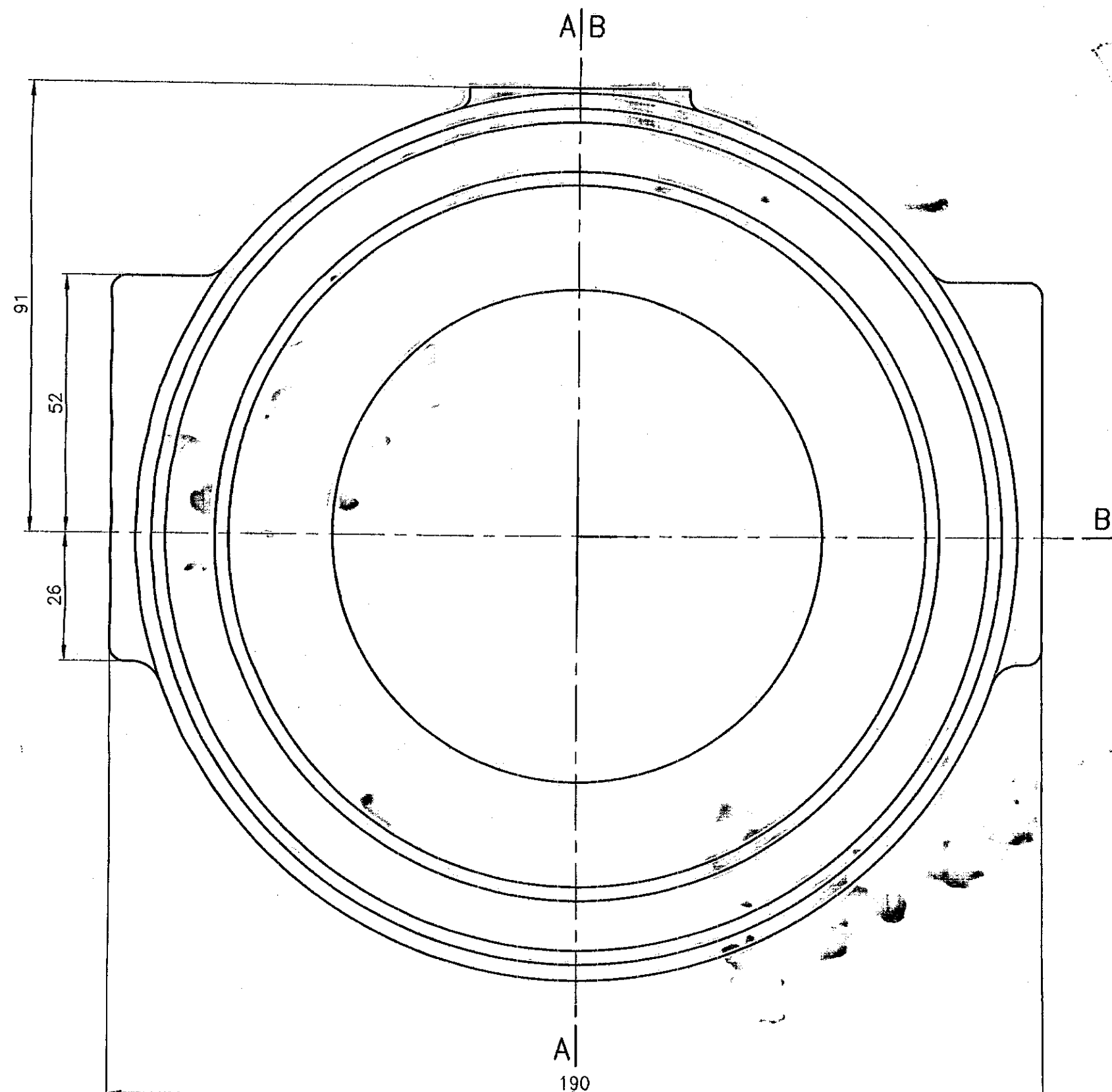
2-V-0000-03309/04
DRAWING NO.

ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

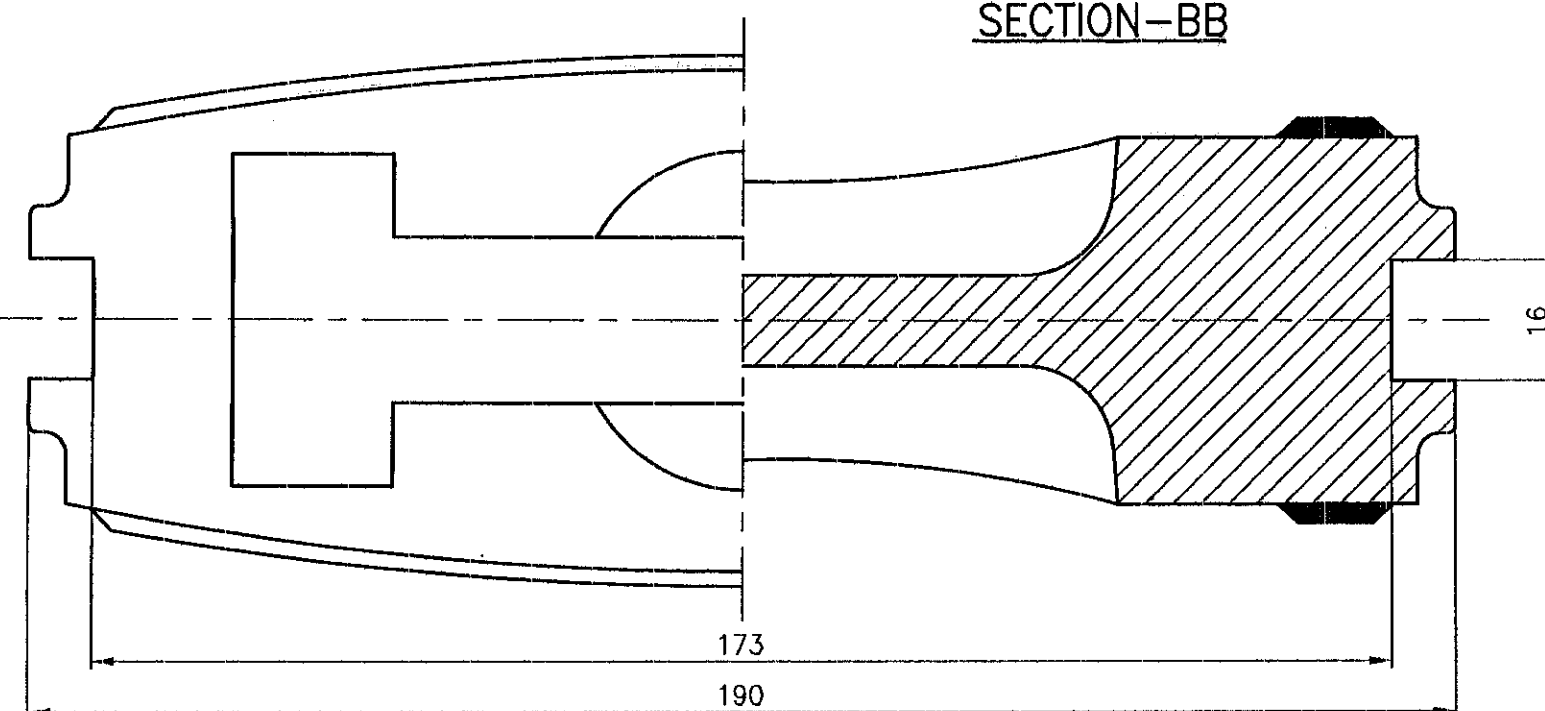
SECTION-AA

WELDING

12.5 0.4



SECTION-BB



NOTES:

- HARDNESS OF HARD FACING 250 TO 300 BHN. DIFFERENCE OF SEAT HARDNESS BETWEEN WEDGE AND SEATING SHOULD BE 50 BHN.
- FOR SL. No. 02 ELECTRODE E308L DIRECTLY DEPOSITED. NO BUFFER LAYER.

03	CASTING DRG. 2.V.N801.03304R	92 201 049	A216 WCC CERTIFY	NORMALISED	10	8.0	8.6	E430	E410	0.2	2.V.N801.03309
02	CASTING DRG. 2.V.N001.03304R	92 034 280	A216 WCB CERTIFY	NORMALISED	10	8.0	8.6	---	E308L	0.2	931093060000
01	CASTING DRG. 2.V.N001.03304R	92 034 280	A216 WCB CERTIFY	NORMALISED	10	8.0	8.6	E430	E410	0.2	2.V.N001.03309/03
SL No.	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	BUFFER LAYER HARD	FINAL FACING SEAT	WT (%)	DRAWING No
											COMP. CODE

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		CS		DRAWING RETRACED WITH REV.04 ON 27.03.99 (REFER DCN:CS:0257,0352,0545)							
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.		BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT, TIRUCHIRAPALLI - 620014.		DRN K.P.LEON CHD T.R.R.MURTHY APPD R.VASANTH		SIGN DATE 27.03.99 27.03.99 27.03.99		NO. OF VAR. -			
REV 04 DATE 27.03.99 ALtered K.P.LEON CHD & APPD		DEPT VL CODE 320		SCALE 1 : 1		WEIGHT (KG) 8.2		REFERENCE INFORMATION CAD:C203309		NO. OF ITEMS -	
SL. NUMBER 03 INCLUDED.		TITLE WEDGE		CARD CODE U 01		DRAWING NO. 2-V-0000-03309		REV 04		Size A2	