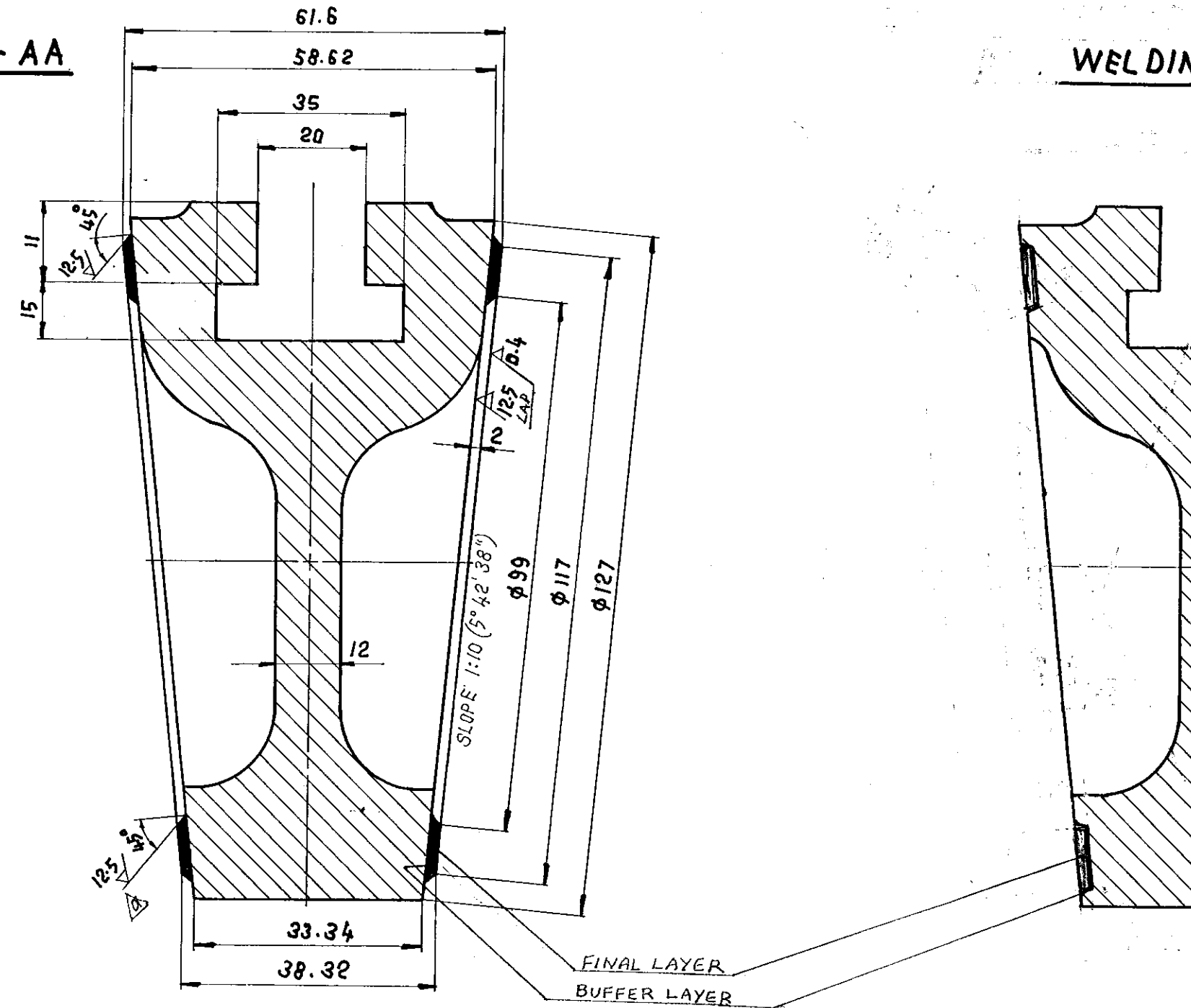




WELDING




02

SL. NO.	WEDGE						SEATING		TOTAL Wt (kg)
	DRG. NO.	CASTING DRG. NO.	MATL. SPECN	SCRAP SDRT	GROSS Wt (kg)	NET Wt (kg)	BUFFER LAYER	NET Wt (kg)	
	COMP. CODE	MATL. CODE.					FINAL LAYER		
01	2-V-N033-03379/03	2-V-N033-03379R	A 216 WCB (NR)	10	5.3	4.43	E 430	0.1	4.53
	93 102 630 0000	92 034 285					E 410		
02	2-V-N296-03379	2-V-N296-03379R	A 216 WCB NT CERTIFY	20	5.3	4.43	E 308	0.1	4.53
	931067920000	92 200 679					E CoCrA		

			
<h1 style="margin: 0;">BHARAT HEAVY ELECTRICALS LTD.,</h1> <h2 style="margin: 0;">BOILER PLANT UNIT, TIRUCHIRAPALLI-14</h2>			

FIRST ANGLE 	SCALE N T S	DRAWN <i>L. Jeyasamy</i>	TOTAL NET WT. (KG) —
		CHECKED <i>J. N. Srinivasan</i>	TYPE .
		APPROVED <i>S. Kumar</i>	
ALL DIMENSIONS IN MILLIMETRES	DATE 22-6-89	NEW / OLD DRG. NO.	

 <p>33-114</p>	<p>CAUTION</p> <p>THE INFORMATION CONTAINED IN THIS DRAWING IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LTD., BOILER PLANT UNIT, TIRUCHY-14 AND SHALL NOT BE USED WITHOUT THEIR EXPRESS WRITTEN PERMISSION IN ANY FORM OR PART THEREOF FOR ANY OTHER PURPOSE THAN FOR WHICH IT IS SENT</p>	<p>TITLE</p> <p>WEDGE ASSY</p> <p>4" 150C</p>
	<p>DRAWING NO.</p> <p>2-V-0000-03379</p>	<p>REVISION</p> <p>04</p>

REV. 04	DATE 11-8-96	ALTD: T.C. C. (S)	CHD & APPD: [Signature]	REV 03	DATE 17-1-96	ALTD: S. S. S. (S)	CHD & APPD: [Signature]	02	DATE 18-7-94	ALTD: [Signature] (LRS)	CHD: [Signature]	01	DATE 27-1-94	ALTERED: [Signature]	CHECKED: [Signature]
SL. NO. 02 INCLUDED				1. DETAIL FOR GROOVE PREPARATION FOR WELDING ELIMINATED.				01) HARDNESS 250 TO 300 BHN WAS 350 TO 400 BHN				ZONE			
				2) REF DCN NO. CS. 0545				02) DCN NO. CS. 0852				1) HARDNESS OF HARD FACING CHANGED.			
												2) DCN. NO. CS: 0257			