

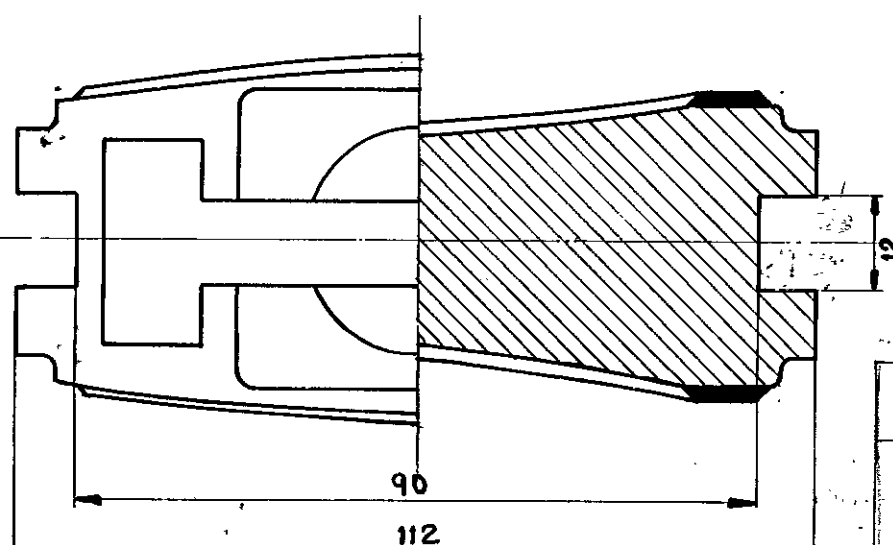
NOTE:-

2) HARDNESS OF HARDFACING
250 TO 300 BHN. FOR E410 AND
350 BHN (MIN) FOR ECO CRA.
DIFFERENCE OF SEAT
HARDNESS BETWEEN WEDGE
AND SEATING SHOULD BE
50 BHN.

FINAL LAYER

\\ BUFFER LAYER

SECTION. BB

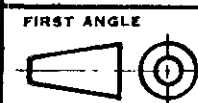


WEDGE							SEATING WELD		TOTAL WT (KGS)
SL.NO	PRODN. DRG. NO	CASTING DRG. NO	MATL. SPECN	SCRAP SORT	GROSS WT (KGS)	NET WT (KGS)	BUFFER LAYER	NET WT (KGS)	
	COMP CODE	MATL. CODE					FINAL LAYER		
01.	3-V-N025-06598/04	3-V-N025-06598R	A 216 WCB (NR)	10	2.75	1.95	E430	0.06	2.07
	93 102 628 0000	92 034 283 0000					-E410		
02.	3-V-N 291 065 98/01	3-V-N 291-06598 R	A 217 WCB NT CR	20	2.75	1.95	—	0.06	2.07
	93 10703 50000	92200 678					ECOCRA		
03.	3-V-N 292 065 98/01	3-V-N 292-06598 R	A 217 WCB NT CR	20	2.75	1.95	—	0.06	2.07
	93 107 036 0000	92200 700					ECOCRA		

BHARAT HEAVY ELECTRICALS LTD.,
BOILER PLANT UNIT, TIRUCHIRAPALLI-14

REV 04	DATE 05.08.96	ALTD: <i>NO PAGE</i> END: <i>HAPPD</i>
-----------	------------------	-------------------------------------------

SL. NO 02 & 03
ARE INCLUDED.



ALL DIMENSIONS IN MILLIMETRES

DRAWN	J. PRABAKAR <i>JP</i>	TOTAL NET Wt. (kg)	
CHECKED	<i>ND.PC</i>	TYPE	
APPROVED	J.S. KUMAR <i>JS</i>		
DATE	17 06 89	NEW/OLD DRG. NO	


CAUTION

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 TO YOU.

REV	DATE	ALTD: R. Thiringer
005	9-12-94	CHKDBAPPD <i>and</i>

NOTES UPDATED

REFER DCN CS.0640

REV 03	DATE 17-1-96	ALTD: S. Soglikumar CHD & APPD: [Signature]	02	DATE 18/7/94	ALTD: [Signature] (CRS) CHD: [Signature]	REV. 01	DATE 27-1-94	ALTERED T.A. [Signature] CHECKED [Signature]
1) DETAIL FOR GROOVE PREPARATION FOR WELDING ELIMINATED. 2) REF DCN NO. CS: 545			01. HARDNESS 250 TO 300 BHN WAS 350 TO 400 BHN 02) DCN NO. CS: 0352			ZONE  HARDNESS OF HARDFACIM CHANGED. REFER DCN. CS: 0257		

TITLE	
WEDGE ASSY (3" - 150 CLASS)	
DRAWING NO	REVISION
3-V-00000-06598	05