


VAR.NO	L	N	NO. OF RINGS	WEIGHT (Kg)
01	1590	5	1	469.03
02	2850	10	2	938.06

- NOTES: -**
1. ALL LONGITUDINAL AND CIRCUMFERENTIAL WELDS ARE TO BACK GOUNDED TO SOUND METAL
 2. ALL BUTT WELD JOINTS TO BE 100 % RADIOGRAPHED.
 3. FOR WELD DETAILS & WPS. NOS. REFER DRG. NO. 2-163-10-00014
 4. POS. NOS. 1/4, 2/3, 3/3, 4/3, 5/4 ARE REQUIRED TO PREVENT DISTORTION OF SHELL SEGMENTS DURING TRANSPORTATION.
 5. DURING THE FIT UP OF DISHED END TO SHELL A REFERENCE LINE SHALL BE MARKED ON THE SHELL AT A DISTANCE OF 100MM FROM THE END OF THE SHELL , WHICH SHALL BE TRANSFERRED BACK AFTER WELDING, TO IDENTIFY WELD LINE.

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PREFIX 1/, 2/, 3/, 4/, 5/ FOR POS. NOS. FOR REF. SEC-I, II, III, IV, V RESPECTIVELY, EXCEPT POS. NO. 141.

[illegible]

TYPE OF PRODUCT OR		OF CUSTOMER/PROJECT		DRN.		NAME A.L. RAJAM	DATE 18.10.10	NO. OF VAR.
BHARAT HEAVY ELECTRICALS LTD. HYDERABAD				CHD.	UMESH MENON	18.10.10	N.A.	
				APPD.	R. SRINIVAS	18.10.10		
DEPT. HEE	GRADE OF TOL. DIM. C/M/F		SCALE NTS	WEIGHT (KG) NA	REF. TO ASSY DRG. NA		ITEM NO. N.A.	NO. OF ITEMS N.A.
CODE 405					DRAWING NO. 1-163-11-11373		REV. 02	
TITLE SHELL ASSLY (FOR STORAGE TANK SHELL)				CARD CODE	SHEET No. 1		NO OF SHEETS 1	