



**BHARAT HEAVY ELECTRICALS LIMITED,
TIRUCHIRAPPALLI 620 014
OUTSOURCING DEPARTMENT**

NIT: 2025OSB058; NIT DTD: 25.11.2025

NIT DESCRIPTION: CRITICAL PIPING ITEMS WITH BHEL MATERIAL

Annexure I: Corrigendum

- **Following drawing has been added in RS01 & RS04.**
 - **Drawing No: 3-80-300-19825 Rev 04 [Description: Edge Preparation Details]**

All other Terms and Conditions of NIT remains unchanged.

Participation in **NIT** by Vendor shall be construed as acceptance to all T&Cs including above corrigendum.

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3-80-300-19825
DRAWING No.

- NOTES: -
- 01. APPLICABLE FOR P91/P92
 - 02. FOR OD MISMATCH, REFER FIGURE-Xa
 - 03. REFER STYLE-D FOR THICKNESS <14.2mm (FOR ALL OD/ID)
 - 04. REFER STYLE-PL
 - 05. $\alpha = 6^\circ$ FOR WALL THICKNESS ≥ 20 mm AND ≤ 30 mm
 - 06. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm

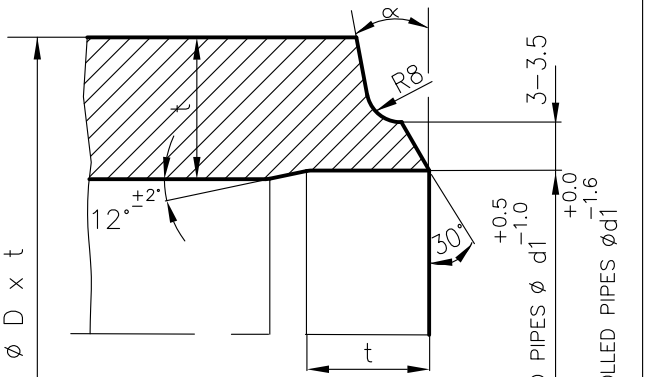


FIGURE - X

- 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)

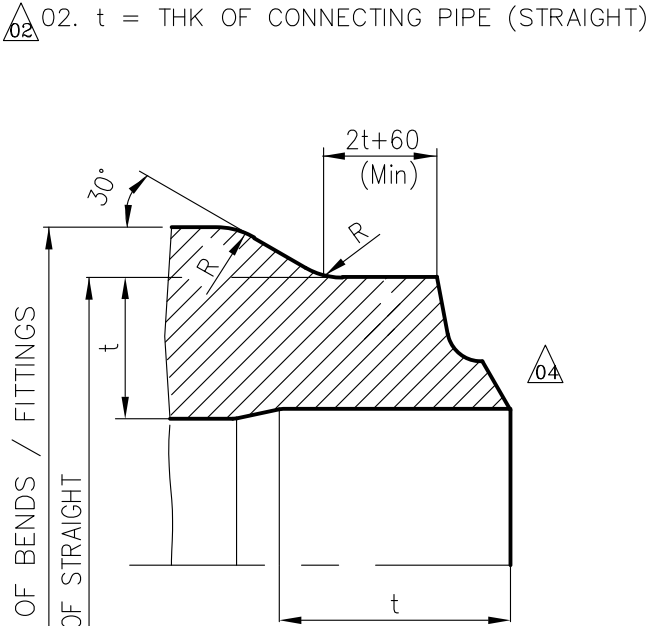
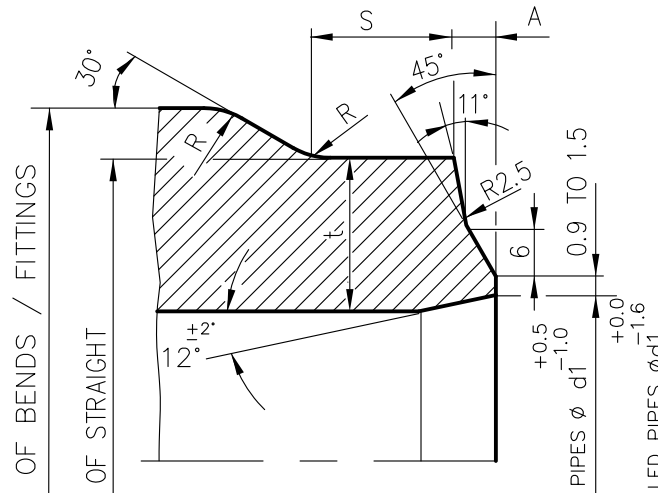


FIGURE - Xa

- 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.PE(STRAIGHT).



STYLE - 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.PE(STRAIGHT)
 - 03. t = THK OF CONN.PE(STRAIGHT)

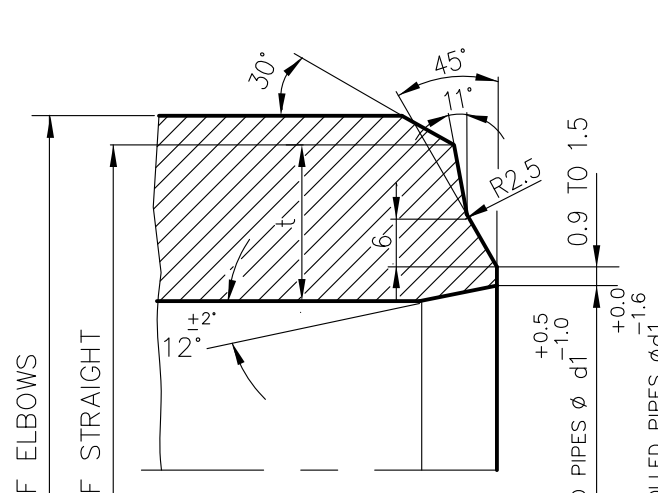


FIGURE - Z

- 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-D FOR THICKNESS <14.2mm (FOR ALL OD/ID)
 - 04. REFER STYLE-PL
 - 05. $\alpha = 6^\circ$ FOR WALL THICKNESS ≥ 20 mm AND ≤ 30 mm
 - 06. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm

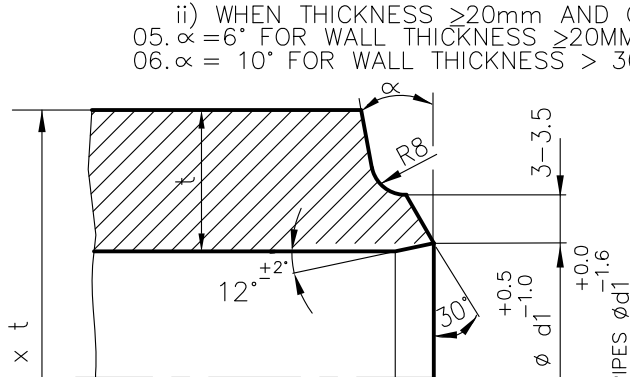


FIGURE - Xb

(BEND END)

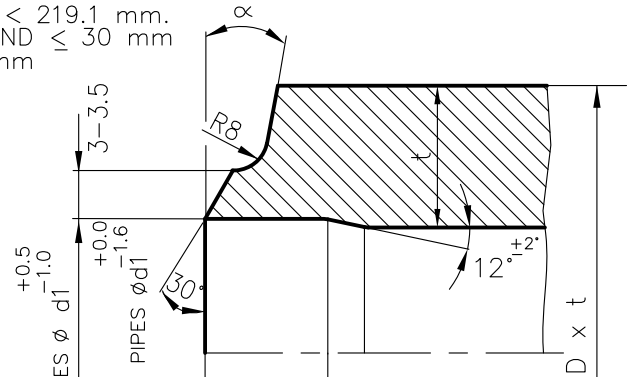
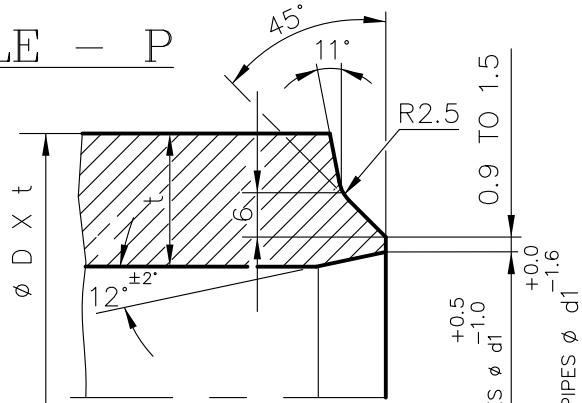


FIGURE - Xc

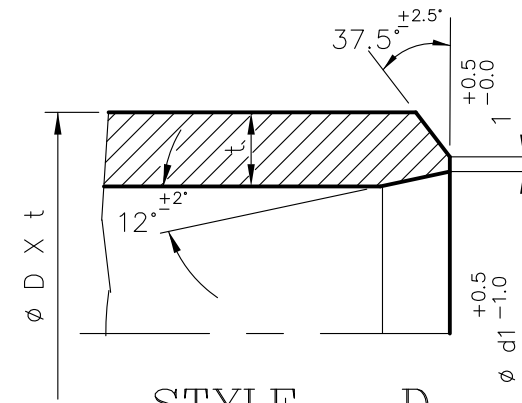
(STRAIGHT END)

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.



STYLE - 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

WEIGHT (Kg).

NAME OF ORIGINAL ORGANISATION

CARD CODE

U 01

DRAWING No.

3-80-300-19825
SHEET 1 OF 2

ITEM No.

REV

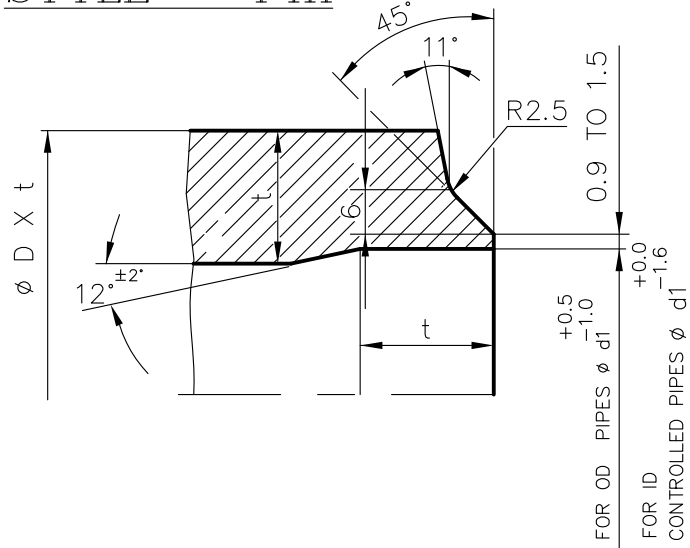
04

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DRAWING No.

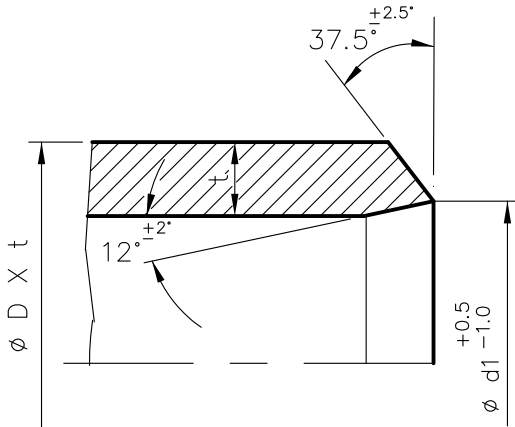
STYLE - P_m



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.

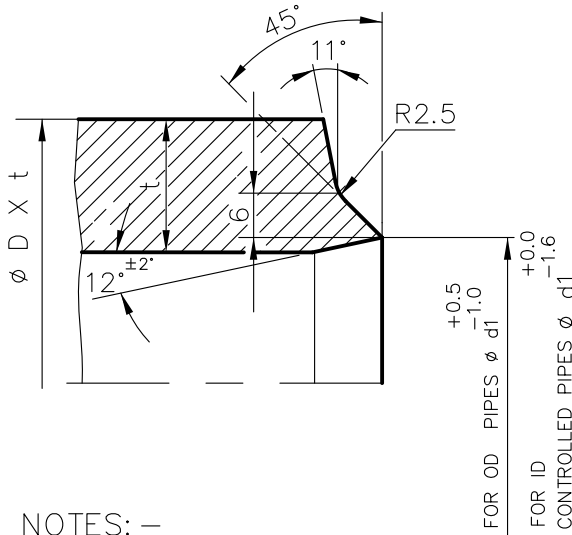
STYLE - D_L



NOTES: -

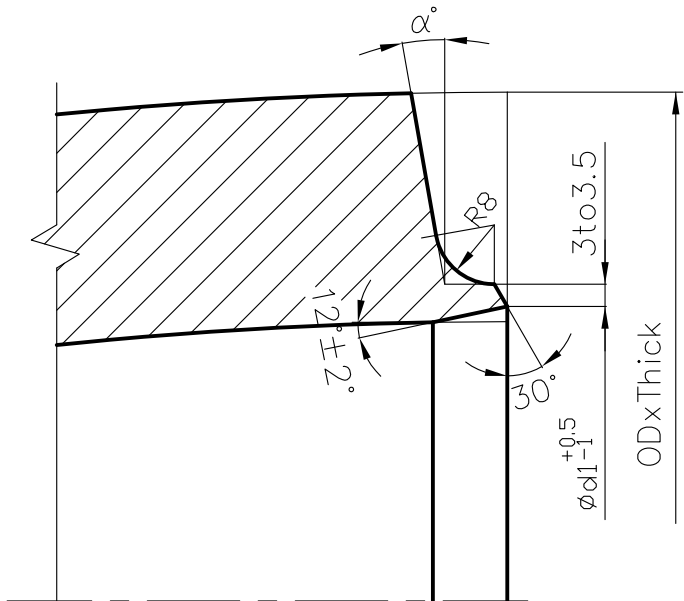
01. USE FOR P91 / P92 PIPES AND FITTINGS WHEN $t < 14.2$ mm (ALL OD/ID).

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-X_f IS APPLICABLE FOR ALL BUTT WELDED FITTINGS NOT COVERED IN NOTES 02 & 03

FIGURE-X_f

NOTE :

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

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

STANDARD

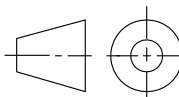


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PIPING CENTRE, MADRAS

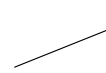
DRN	NAME	SIGN	DATE	NO OF ITEMS
CHD	P SURESH		07.12.16	
APPD	R SESHAGIRI		07.12.16	
	C KARUNAKARAN		07.12.16	

DEPT.

GRADE OF
UN TOL. DIM
C/M/F



SCALE



WEIGHT (Kg).



NAME OF ORIGINAL
ORGANISATION

ITEM
No.

TITLE

EDGE PREPARATION
DETAILS

CARD
CODE

U 01

DRAWING No.

3-80-300-19825

SHEET 2 OF 2

REV

04