355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT TEMP. in °C	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.					TIME in mins		SPEC. NO	ACC NORM REF.		
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0								
1	0-00-027-35556	F-01 (FURN LOWER FRONT INLET HDR) + F-16 (FURN LOWER SIDE INLET HDRS)	SA106GRC + SA234WPC	406.4	70	GTAW + SMAW	61.25 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							2	253	59	96	673			175					
2	0-00-027-35556	F-07 (FURN LOWER REAR INLET HDR) + F-16 (FURN LOWER SIDE INLET HDRS)	SA106GRC + SA234WPC	406.4	70	GTAW + SMAW	61.25 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							2	253	59	96	673			175					
3	0-00-027-35556	F-01 (FURN LOWER FRONT INLET HDR) + F-02TI (FURN LOWER FRONT SPIRAL INLET TERMINAL TUBE)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							271	1969	2341	-	-								
4	0-00-027-35556	F-07 (FURN LOWER REAR INLET HDR) + F-08TI (FURN REAR SPIRAL INLET TERM TUBE)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							271	1969	2341	-	-								
5	0-00-027-35556 0-00-027-35591	F-02TI (FURN LOWER FRONT SPIRAL INLET TERMINAL TUBE) + F-02L (FURN LOWER FRONT SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							258	2021	2863	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	1/18

CAUTION : THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.

* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX).
FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
6	0-00-027-35556 0-00-027-35591	F-08TI (FURN REAR SPIRAL INLET TERM TUBES) + F-08L (FURN LOWER REAR SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							258	2021	2863	-	-								
7	0-00-027-35556 0-00-027-35591	F-02TI (FURN LOWER FRONT SPIRAL INLET TERM TUBES) + F-08L (FURN LOWER REAR SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							3	24	34	-	-								
8	0-00-027-35556 0-00-027-35591	F-08TI (FURN REAR SPIRAL INLET TERM TUBES) + F-02L (FURN LOWER FRONT SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							3	24	34	-	-								
9	0-00-027-35556 0-00-027-35599 0-00-027-35600	F-02TI (FURN LOWER FRONT SPIRAL INLET TERM TUBES) + F-17L (L&R) (FURN LOWER SIDE SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							10	79	111	-	-								
10	0-00-027-35556 0-00-027-35599 0-00-027-35600	F-08TI (FURN LOWER REAR SPIRAL INLET TERM TUBES) + F-17L (L&R) (FURN LOWER SIDE SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							10	79	111	-	-								

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SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	2/18

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355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
11	0-00-027-35591	F-02L (FURN LOWER FRONT SPIRAL WALL PANEL) + F-02L (FURN LOWER FRONT SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							319	2498	3540	-	-								
12	0-00-027-35591	F-08L (FURN LOWER REAR SPIRAL WALL PANEL) + F-08L (FURN LOWER REAR SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							319	2498	3540	-	-								
13	0-00-027-35591	F-02L (FURN LOWER FRONT SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	38.1	8	GTAW + SMAW	8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							128	860	1374	-	-								
14	0-00-027-35591	F-02L (FURN LOWER FRONT SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							258	2021	2863	-	-								
15	0-00-027-35591	F-08L (FURN LOWER REAR SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	38.1	8	GTAW + SMAW	8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							128	860	1374	-	-								

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355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
16	0-00-027-35591	F-08L (FURN LOWER REAR SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							258	2021	2863	-	-								
17	0-00-027-35587	F-02U (FURN UPPER FRONT SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							133	1042	1476	-	-								
18	0-00-027-35588	F-08U (FURN UPPER REAR SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							133	1042	1476	-	-								
19	0-00-027-35599 0-00-027-35600	F-17L (L&R) (FURN LOWER SIDE SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	38.1	8	GTAW + SMAW	8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							516	3464	5536	-	-								
20	0-00-027-35599 0-00-027-35600	F-17L (L&R) (FURN LOWER SIDE SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							256	2005	2841	-	-								

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SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	4/18

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355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
21	0-00-027-35589 0-00-027-35590	F-17U (L&R) (FURN UPPER SIDE SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							286	2240	3174	-	-								
22	0-00-027-35578	F-02X (FURN FRONT SPIRAL WALL TO VERT TRANSITION PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							68	533	755	-	-								
23	0-00-027-35578	F-02X (FURN FRONT SPIRAL WALL TO VERT TRANSITION PANEL) + CORNER TUBES	SA213T12 + SA182F12CL2	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							2	16	23	-	-								
24	0-00-027-35578	F-08X (FURN REAR SPIRAL WALL TO VERT TRANSITION PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							68	533	755	-	-								
25	0-00-027-35578	F-08X (FURN REAR SPIRAL WALL TO VERT TRANSITION PANEL) + CORNER TUBES	SA213T12 + SA182F12CL2	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							2	16	23	-	-								

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SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	5/18

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355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

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PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
26	0-00-027-35577	F-17X (L&R) (FURN SIDE SPIRAL WALL TO VERT TRANSITION PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							120	940	1332	-	-								
27	0-00-027-35577	F-17X (L&R) (FURN SIDE SPIRAL WALL TO VERT TRANSITION PANEL) + CORNER TUBES	SA213T12 + SA182F12CL2	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							4	32	45	-	-								
28	0-00-027-35591 0-00-027-35581 0-00-027-35584	F-02L (FURN LOWER FRONT SPIRAL WALL PANEL) + F-WB (FURN BURNER PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							135	1058	1499	-	-								
29	0-00-027-35591 0-00-027-35581 0-00-027-35584	F-08L (FURN LOWER REAR SPIRAL WALL PANEL) + F-WB (FURN BURNER PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							135	1058	1499	-	-								
30	0-00-027-35589 0-00-027-35581 0-00-027-35584	F-17U (L&R) (FURN LOWER SIDE SPIRAL WALL PANEL) + F-WB (FURN BURNER PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							1216	9522	13494	-	-								

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SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	6/18

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355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

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PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
31	0-00-027-35587 0-00-027-35581 0-00-027-35584	F-02U (FURN UPPER FRONT SPIRAL WALL PANEL) + F-WB (FURN BURNER PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							598	4683	6636	-	-								
32	0-00-027-35588 0-00-027-35581 0-00-027-35584	F-08U (FURN UPPER REAR SPIRAL WALL PANEL) + F-WB (FURN BURNER PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							598	4683	6636	-	-								
33	0-00-027-35599 0-00-027-35581 0-00-027-35584	F-17L (L&R) (FURN LOWER SIDE SPIRAL WALL PANEL) + F-WB (FURN BURNER PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							250	1958	2775	-	-								
34	0-00-027-35578	F-02U (FURN UPPER FRONT SPIRAL WALL PANEL) + F-02X (FURN FRONT SPIRAL WALL TO VERT TRANSITION PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							124	971	1376	-	-								
35	0-00-027-35578	F-08U (FURN UPPER REAR SPIRAL WALL PANEL) + F-08X (FURN REAR SPIRAL TO VERT TRANSITION PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							124	971	1376	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	7/18

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* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX).
FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
36	0-00-027-35577	F-17U (L&R) (FURN UPPER SIDE SPIRAL WALL PANEL) + F-17X (L&R) (FURN SIDE SPIRAL TO VERT TRANSITION PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							218	1708	2420	-	-								
37	0-00-027-35587	F-02U (FURN UPPER FRONT SPIRAL WALL PANEL) + F-OFA (FURN SOFA PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							485	3798	5382	-	-								
38	0-00-027-35588	F-08U (FURN UPPER REAR SPIRAL WALL PANEL) + F-OFA (FURN SOFA PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							485	3798	5382	-	-								
39	0-00-027-35577	F-17U (L&R) (FURN UPPER SIDE SPIRAL WALL PANEL) + F-OFA (FURN SOFA PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							932	7299	10343	-	-								
40	0-00-027-35577	F-17X (L&R) (FURN SIDE SPIRAL TO VERT TRANSITION PANEL) + F-17TO (L&R) (FURN SIDE SPIRAL OUTLET TERM TUBES)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							262	1904	2264	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	8/18

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
41	0-00-027-35578	F-02X (FURN FRONT SPIRAL TO VERT TRANSITION PANEL) + F-02TO (FURN FRONT SPIRAL OUTLET TERM TUBES)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							140	1018	1210	-	-								
42	0-00-027-35578	F-08X (FURN REAR SPIRAL TO VERT TRANSITION PANEL) + F-08TO (FURN REAR SPIRAL OUTLET TERM TUBES)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							140	1018	1210	-	-								
43	0-00-027-35577	F-17TO (L&R) (FURN SIDE SPIRAL OUTLET TERM TUBES) + F-18 (L&R) (FURN INTERM SIDE HDRS)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							262	1904	2264	-	-								
44	0-00-027-35578	F-02TO (FURN FRONT SPIRAL OUTLET TERM TUBES) + F-03 (FURN INTERM FRONT HDR)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							140	1018	1210	-	-								
45	0-00-027-35578	F-08TO (FURN REAR SPIRAL OUTLET TERM TUBES) + F-09 (FURN INTERM REAR HDR)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							140	1018	1210	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	9/18

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
46	0-00-027-35577	F-18 (L&R) (FURN INTERM SIDE HDRS) + F-19TI (L&R) (FURN SIDE VERT INLET TERM TUBES)	SA213T12 + SA213T12	33.4	5.59	GTAW + SMAW	5.59 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							786	5305	3873	-	-								
47	0-00-027-35578	F-03 (FURN INTERM FRONT HDR) + F-04TI (FURN FRONT VERTICAL INLET TERM TUBES)	SA213T12 + SA213T12	33.4	5.59	GTAW + SMAW	5.59 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							420	2835	2070	-	-								
48	0-00-027-35578	F-09 (FURN INTERM REAR HDR) + F-10TI (FURN REAR VERT INET TERM TUBES)	SA213T12 + SA213T12	33.4	5.59	GTAW + SMAW	5.59 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							420	2835	2070	-	-								
49	0-00-027-35578	F-03 (FURN FRONT INTERM HDR INSPECTION NOZZLE) + FLAT END COVER	SA182F12CL2 + SA182F12CL2	168.3	39.7	GTAW + SMAW	34.74 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							2	91	25	40	92			100				NDT after SR	01
50	0-00-027-35578	F-09 (FURN REAR INTERM HDR INSPECTION NOZZLE) + FLAT END COVER	SA182F12CL2 + SA182F12CL2	168.3	39.7	GTAW + SMAW	34.74 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							2	91	25	40	92			100				NDT after SR	01

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	10/18

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
51	0-00-027-35577	F-18 (FURN INTERM HDR INSPECTION NOZZLE) + FLAT END COVER	SA182F12CL2 + SA182F12CL2	168.3	39.7	GTAW + SMAW	34.74 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							4	182	49	80	184			100					
52	0-00-027-35577	F-19TI (L&R) (FURN SIDE VERT INLET TERM TUBES) + F-17X (L&R) (FURN SIDE SPIRAL TO VERT TRANSITION PANEL)	SA213T12 + SA213T12	33.4	5.59	GTAW + SMAW	5.59 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							786	5305	3873	-	-								
53	0-00-027-35578	F-04TI (FURN FRONT VERTICAL INLET TERM TUBES) + F-02X (FURN FRONT SPIRAL TO VERT TRANSITION PANEL)	SA213T12 + SA213T12	33.4	5.59	GTAW + SMAW	5.59 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							420	2835	2070	-	-								
54	0-00-027-35578	F-10TI (FURN REAR VERT INET TERM TUBES) + F-08X (FURN REAR SPIRAL TO VERT TRANSITION PANEL)	SA213T12 + SA213T12	33.4	5.59	GTAW + SMAW	5.59 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							420	2835	2070	-	-								
55	0-00-027-35586	F-02X (FURN FRONT SPIRAL TO VERT TRANSITION PANEL) + F-04L (FURN LOWER FRONT VERT WALL PANEL)	SA213T12 + SA213T12	38.1	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							420	2786	4642	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	11/18

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
56	0-00-027-35586	F-04L (FURN INTER FRONT VERT WALL PANEL) + F-04U (FURN UPPER FRONT VERT WALL PANEL)	SA213T12 + SA213T12	38.1	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							420	2786	4642	-	-								
57	0-00-027-35586	F-04U (FURN UPPER FRONT VERT WALL PANEL) + F-05 (FURN UPPER FRONT OUTLET HDR)	SA213T23 + SA213T22	38.1	8.13	GTAW + SMAW	8.13 ▽	ER90S-B3	E9018-B3			1053/04	200	745 ± 15	20% RT + 80% PAUT			100% HC, 260HV (MAX)	
							420	5250	4642	-	-			60					
58	0-00-027-35586	F-08X (FURN REAR SPIRAL TO VERT TRANSITION PANEL) + F-11 (FURN REAR ARCH PANEL)	SA213T12 + SA213T12	38.1	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							420	2786	4642	-	-								
59	0-00-027-35586 0-00-027-35551	F-11 (FURN REAR ARCH PANEL) + F-12 (FURN SCREEN TUBES)	SA213T12 + SA213T12	38.1	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							280	1857	3095	-	-								
60	0-00-027-35586 0-00-027-35551	F-11 (FURN REAR ARCH PANEL) + F-13 (FURN HANGER TUBES)	SA213T12 + SA213T12	38.1	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							140	929	1548	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	12/18

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
61	0-00-027-35586 0-00-027-35551	F-12 (FURN SCREEN TUBES) + F-14 (FURN UPPER REAR OUTLET HDR)	SA213T12 + SA213T12	38.1	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							280	1857	3095	-	-								
62	0-00-027-35586 0-00-027-35551	F-13 (FURN HANGER TUBES) + F-14 (FURN UPPER REAR OUTLET HDR)	SA213T22 + SA213T22	63.5	12.7	GTAW + SMAW	12.7 ▽	ER90S-B3	E9018-B3			1084/01	200	740 ± 10	20% RT + 80% PAUT			100% HC, 260HV (MAX)	
							140	1636	1308	1152	-			60					
63	0-00-027-35586	F-17X (L&R) (FURN SIDE SPIRAL TO VERT TRANSITION PANEL) + F-19L (L&R) (FURN LOWER SIDE VERT WALL PANEL)	SA213T12 + SA213T12	38.1	9.1	GTAW + SMAW	9.1 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							786	4739	10720	-	-								
64	0-00-027-35586	F-19L (L&R) (FURN LOWER SIDE VERT WALL PANEL) + F-19U (L&R) (FURN UPPER SIDE VERT WALL PANEL)	SA213T12 + SA213T12	38.1	9.1	GTAW + SMAW	9.1 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							786	4739	10720	-	-								
65	0-00-027-35586	F-19U (L&R) (FURN UPPER SIDE VERT WALL PANEL) + F-19U LT (LOOSE TUBES)	SA213T12 + SA213T12	38.1	9.1	GTAW + SMAW	9.1 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							10	61	137	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	13/18

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
				SIZE	THICK		Qty in Nos.	Qty in gms	Qty in Nos. Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
66	0-00-027-35586	F-19U (L&R) (FURN UPPER SIDE VERT WALL PANEL) + F-20 (L&R) (FURN UPPER SIDE OUTLET HDRS)	SA213T12 + SA213T12	38.1	9.1	GTAW + SMAW	9.1 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							786	4739	10720	-	-								
67	1-07-318-01322 1-07-318-01323 0-00-027-35570	F-05 (FURN UPPER FRONT OUTLET HDR) + F-06 (FRONT RISER PIPES)	SA182F12CL2 + SA335P12	219.1	40	GTAW + SMAW	35.00 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							4	270	63	103	261			100				NDT after SR	01
68	1-07-318-01322 1-07-318-01323 0-00-027-35568	F-06 (FRONT RISER PIPES) + F-06 (FRONT RISER PIPES)	SA335P12 + SA335P12	219.1	40	GTAW + SMAW	35.00 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							16	1077	252	412	1042			100				NDT after SR	01
69	1-07-318-01322 1-07-318-01323 0-00-027-35568	F-06 (FRONT RISER PIPES) + F-31 (SEPARATOR)	SA335P12 + SA182F22CL3	219.1	40	GTAW + SMAW	35.00 ▽▽	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI				
							4	270	63	103	261			100				NDT after SR	01
70	0-07-316-02253 0-07-316-02254 0-00-027-35568	F-14 (FURN UPPER REAR OUTLET HDR) + F-15 (REAR RISER PIPES)	SA182F12CL2 + SA335P12	219.1	40	GTAW + SMAW	35.00 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							4	270	63	103	261			100				NDT after SR	01

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	14/18

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* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX).
FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0			in mins		SPEC. NO	ACC NORM		
71	0-07-316-02253 0-07-316-02254 0-00-027-35568	F-15 (REAR RISER PIPES) + F-15 (REAR RISER PIPES)	SA335P12 + SA335P12	219.1	40	GTAW + SMAW	35.00 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							20	1346	315	515	1302			100				NDT after SR	01
72	0-07-316-02253 0-07-316-02254 0-00-027-35568	F-15 (REAR RISER PIPES) + F-31 (SEPARATOR)	SA335P12 + SA182F22CL3	219.1	40	GTAW + SMAW	35.00 ▽▽	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI				
							4	270	63	103	261			100				NDT after SR	01
73	1-07-315-01314 TO 1-07-315-01321 0-00-027-35568	F-20 (FURN UPPER SIDE OUTLET HDRS) + F-21 (SIDE RISER PIPES)	SA182F12CL2 + SA335P12	219.1	40	GTAW + SMAW	35.00 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							8	539	126	206	521			100				NDT after SR	01
74	1-07-315-01314 TO 1-07-315-01321 0-00-027-35568	F-21 (SIDE RISER PIPES) + F-21 (SIDE RISER PIPES)	SA335P12 + SA335P12	219.1	40	GTAW + SMAW	35.00 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							36	2422	566	927	2343			100				NDT after SR	01
75	1-07-315-01314 TO 1-07-315-01321 0-00-027-35568	F-21 (SIDE RISER PIPES) + F-31 (SEPARATOR)	SA335P12 + SA182F22CL3	219.1	40	GTAW + SMAW	35.00 ▽▽	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI				
							8	539	126	206	521			100				NDT after SR	01

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	15/18

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
76	0-07-102-02217 0-00-027-35568	F-31 (SEPARATOR) + F-32 (LINK TO SEPARATOR STORAGE TANK)	SA182F22CL3 + SA335P12	355.6	65	GTAW + SMAW	56.88 ▽▽	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI				
							4	432	102	168	1030			165				NDT after SR	01
77	0-07-102-02217 0-00-027-35568	F-32 (LINK TO SEPARATOR STORAGE TANK) + F-32 (LINK TO SEPARATOR STORAGE TANK)	SA335P12 + SA335P12	355.6	65	GTAW + SMAW	56.88 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							8	863	204	335	2059			165				NDT after SR	01
78	0-07-102-02217 0-00-027-35568	F-32 (LINK TO SEPARATOR STORAGE TANK) + F-33 (STORAGE TANK)	SA335P12 + SA182F22CL3	355.6	65	GTAW + SMAW	56.88 ▽▽	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI				
							4	432	102	168	1030			165				NDT after SR	01
79	0-07-110-02218 0-00-027-35568	F-33 (STORAGE TANK) + F-49 (FURN DOWNCOMER TO CONNECTING SPHERE)	SA182F22CL3 + SA335P12	406.4	65	GTAW + SMAW	56.88 ▽▽	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI				
							2	260	59	96	603			165				NDT after SR	01
80	0-07-110-02218 0-00-027-35568	F-49 (FURN DOWNCOMER TO CONNECTING SPHERE) + F-50 (FURN CONNECTING SPHERE)	SA335P12 + SA182F12CL2	406.4	65	GTAW + SMAW	56.88 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							2	260	59	96	603			165				NDT after SR	01

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	16/18

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
81	1-07-217-01324 0-00-027-35568	F-33 (STORAGE TANK) + F-34 (SEPARATOR STORAGE TANK VENT LINK)	SA182F22CL3 + SA335P12	88.9	16	GTAW + SMAW	14.00 ▽▽	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI			NDT after SR	01
							2	58	13	21	4			60					
82	1-07-217-01324 0-00-027-35568	F-34 (SEPARATOR STORAGE TANK VENT LINK) + F-34 (SEPARATOR STORAGE TANK VENT LINK)	SA335P12 + SA234WP22CL1	88.9	16	GTAW + SMAW	14.00 ▽▽	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI			NDT after SR	01
							2	58	13	21	4			60					
83	1-07-217-01324 0-00-027-35568	F-34 (SEPARATOR STORAGE TANK VENT LINK) + S-01 (SH CONNECTING PIPE)	SA335P12 + SA182F12CL2	88.9	16	GTAW + SMAW	14.00 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							2	58	13	21	4			60					
84		GAMMA PLUG IN F-01 AND F-07	SA106GRC + SA105			SMAW	7 ◺	-	E7018			1101/01	100	Nil	100% LPI or MPI				
							4	-	2	-	-							FOR T- (25-75) MM	
85		GAMMA PLUG IN RISER LINKS	SA335P12 + SA182F22CL3			SMAW	7 ◺	-	E8018-B2			1102/01	200	Nil	100% LPI or MPI				
							102	-	26	-	-							FOR T- (25-75) MM	

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	17/18

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* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX).
FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 07

CUST No : 1834,1835

PG NAME : Circulation System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Circulation System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
86		GAMMA PLUG IN F-49 LINKS	SA335P12 + SA182F22CL3			SMAW	7 ◺	-	E8018-B2			1102/01	200	Nil	100% LPI or MPI			FOR T- (25-75) MM	
							16	-	5	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
SAJI P J	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-07-CIR-EWS	1	18/18

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* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX).
FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 19

CUST No : 1834,1835

PG NAME : Economiser System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Economiser System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT TEMP. in °C	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0			TIME in mins		SPEC. NO	ACC NORM REF.		
1	0-19-850-02662 0-00-027-35571	ECO I/L LINK + ECO I/L LINK (E-04 + E-04/VALVE)	SA106GRC + SA106GRC	610	82	GTAW + SMAW	71.75 ▽▽	ER70S-A1	E7018-1			1004/04	150	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							22	4528	962	1577	14974			205					
2	0-19-850-02662 0-00-027-35571	ECO I/L LINK +ECO I/L LINK(E-04A + E-04A)	SA106GRC + SA106GRC	457	60	GTAW + SMAW	52.50 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% RT 100% MPI/LPI				
							7	1091	230	376	2139			150					
3	0-19-850-02662 0-00-027-35571	ECO I/L LINK+ECO I/L HDR (E-04A + E-05)	SA106GRC + SA106GRC	457	60	GTAW + SMAW	52.50 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% RT 100% MPI/LPI				
							2	312	66	108	611			150					
4	2-19-850-05101 0-00-027-35571	ECO I/L LINK+WATER COOLED HGR I/L HDR LINK (E-04 NOZZLE + E.04.01)	SA105 + SA106GRC	219.1	36	GTAW + SMAW	31.50 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% RT 100% MPI/LPI				
							1	71	16	26	55			90					
5	2-19-850-05101 0-00-027-35571	WATER COOLED HGR I/L HDR LINK + WATER COOLED HGR I/L HDR LINK (E-04.01 + E.04.01)	SA106GRC + SA106GRC	219.1	36	GTAW + SMAW	31.50 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% RT 100% MPI/LPI				
							2	141	32	52	110			90					

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	NIRMAL RAJ N	09-02-2026	1834-19-ECO-EWS	0	1/8

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* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX).
FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 19

CUST No : 1834,1835

PG NAME : Economiser System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Economiser System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0			in mins		SPEC. NO	ACC NORM		
6	2-19-850-05101 0-00-027-35571	WATER COOLED HGR I/L HDR LINK + WATER COOLED HGR I/L HDR (E-04.01 + E.05A)	SA106GRC + SA106GRC	219.1	36	GTAW + SMAW	31.50 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% RT 100% MPI/LPI				
							1	71	16	26	55			90					
7	0-00-027-35546	ECO I/L HDR NIPP+ECO I/L TERM TUBE (E-05 NIPPLE + E-06TI)	SA210GRC + SA210GRC	44.45	7.1	GTAW + SMAW	7.1 ▽	ER70S-A1	E7018-1			1003/04	20	Nil	20%RT + 80% PAUT				
							940	8690	9449	-	-								
8	0-00-027-35546	ECO I/L TERM TUBE +ECO COIL LWR ASSY (E-06TI + E-06L)	SA210GRC + SA210GRC	44.45	7.1	GTAW + SMAW	7.1 ▽	ER70S-A1	E7018-1			1003/04	20	Nil	20%RT + 80% PAUT				
							940	8690	9449	-	-								
9	0-00-027-35546	ECO COIL LWR ASSY +ECO COIL INTER ASSY (E-06L + E-06I)	SA210GRC + SA210GRC	44.45	7.1	GTAW + SMAW	7.1 ▽	ER70S-A1	E7018-1			1003/04	20	Nil	20%RT + 80% PAUT				
							940	8690	9449	-	-								
10	0-00-027-35546	ECO COIL INTER ASSY +ECO COIL UPPER ASSY (E-06I + E-6U)	SA210GRC + SA210GRC	44.45	7.1	GTAW + SMAW	7.1 ▽	ER70S-A1	E7018-1			1003/04	20	Nil	20%RT + 80% PAUT				
							940	8690	9449	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	NIRMAL RAJ N	09-02-2026	1834-19-ECO-EWS	0	2/8

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* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX).
FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 19

CUST No : 1834,1835

PG NAME : Economiser System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Economiser System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
11	0-00-027-35546 0-00-027-35606	ECO COIL UPPER ASSY +ECO O/L TERM TUBES (E-06U + E-06TO)	SA210GRC + SA210GRC	44.45	7.1	GTAW + SMAW	7.1 ▽	ER70S-A1	E7018-1			1003/04	20	Nil	20%RT + 80% PAUT				
							940	8690	9449	-	-								
12	0-00-027-35546 0-00-027-35606	ECO O/L TERM TUBES +ECO JN. HDR NIPPLE (E-06TO + E-07 NIPPLE)	SA210GRC + SA210GRC	44.45	7.1	GTAW + SMAW	7.1 ▽	ER70S-A1	E7018-1			1003/04	20	Nil	20%RT + 80% PAUT				
							940	8690	9449	-	-								
13	0-00-027-35546 0-00-027-35606	WATER COOLED HGR I/L HDR NIPPLE + WATER COOLED HGR I/L TERM TUBES (E-05A NIPPLE + E-06ATI)	SA210GRC + SA210GRC	44.45	13.49	GTAW + SMAW	13.49 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							472	2489	2414	3277	-			35					
14	0-00-027-35546 0-00-027-35606	WATER COOLED HGR I/L TERM TUBES + WATER COOLED HGR TUBES (E-06ATI + E-06A)	SA210GRC + SA210GRC	44.45	13.49	GTAW + SMAW	13.49 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							472	2489	2414	3277	-			35					
15	0-00-027-35546 0-00-027-35605	WATER COOLED HGR TUBES + ECO COIL LWR ASSY HGR TUBES (E-06A + E-06L HGR)	SA210GRC + SA210GRC	44.45	13.49	GTAW + SMAW	13.49 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							472	2489	2414	3277	-			35					

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	NIRMAL RAJ N	09-02-2026	1834-19-ECO-EWS	0	3/8

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* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX).
FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 19

CUST No : 1834,1835

PG NAME : Economiser System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Economiser System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
16	0-00-027-35546	ECO COIL LWR ASSY HGR TUBES + ECO COIL INTER ASSY HGR TUBES (E-06L HGR + E-06I-HGR)	SA210GRC + SA210GRC	44.45	13.49	GTAW + SMAW	13.49 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							472	2489	2414	3277	-			35					
17	0-00-027-35546	ECO COIL INTER ASSY HGR TUBES + ECO COIL UPR ASSY HGR TUBES (E-06I HGR + E-06U-HGR)	SA210GRC + SA210GRC	44.45	13.49	GTAW + SMAW	13.49 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							472	2489	2414	3277	-			35					
18	0-00-027-35546	ECO COIL UPR ASSY HGR TUBES + WATER COOLED HGR O/L TERM TUBES (E-06U HGR + E-06ATO)	SA210GRC + SA210GRC	44.45	13.49	GTAW + SMAW	13.49 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							472	2489	2414	3277	-			35					
19	0-00-027-35546	WATER COOLED HGR O/L TERM TUBES + ECO JN. HDR NIPPLES (E-06ATO + E-07 NIPPLE)	SA210GRC + SA210GRC	44.45	13.49	GTAW + SMAW	13.49 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							472	2489	2414	3277	-			35					
20	0-00-027-35544 0-00-027-35606	ECO JN. HDR NIPPLE +ECO LWR HGR TUBE (E-07 NIPPLE + E-08L)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							476	6087	4792	5498	-			40					

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	NIRMAL RAJ N	09-02-2026	1834-19-ECO-EWS	0	4/8

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* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX).
FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 19

CUST No : 1834,1835

PG NAME : Economiser System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Economiser System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
21	0-00-027-35544	ECO LWR HGR TUBE +ECO HGR TUBE (LTRH LWR ASSY) (E-08L + R-04L HANGER)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							476	6087	4792	5498	-			40					
22	0-00-027-35544	ECO HGR TUBE (LTRH LWR ASSY)+ECO HGR TUBE (LTRH LWR INTER ASSY) (R-04L HGR + R-04LI HGR)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							476	6087	4792	5498	-			40					
23	0-00-027-35544	ECO HGR TUBE (LTRH LWR INTER ASSY)+ECO HGR TUBE (LTRH INTER ASSY) (R-04LI HGR + R-04I HGR)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							476	6087	4792	5498	-			40					
24	0-00-027-35544	ECO HGR TUBE (LTRH INTER ASSY)+ECO HGR TUBE (LTRH UPR INTER ASSY) (R-04I HANGER + R-04UI HANGER)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							476	6087	4792	5498	-			40					
25	0-00-027-35544	ECO HGR TUBE (LTRH UPR INTER ASSY)+ECO HGR TUBE (LTRH UPR ASSY) (R-04UI HANGER + R-04U HANGER)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							476	6087	4792	5498	-			40					

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	NIRMAL RAJ N	09-02-2026	1834-19-ECO-EWS	0	5/8

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 19

CUST No : 1834,1835

PG NAME : Economiser System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Economiser System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
26	0-00-027-35544	ECO HGR TUBE (LTRH UPR ASSY)+ECO UPR HGR TUBE (R-04U HGR + E-08U)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							476	6087	4792	5498	-			40					
27	0-00-027-35544 0-00-027-35574	ECO UPR HGR TUBE +ECO HGR O/L TERM TUBE (E-08U + E-08TO)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							476	6087	4792	5498	-			40					
28	0-00-027-35544 0-00-027-35574	ECO HGR O/L TERM TUBE +ECO O/L HDR NIPPLE (E-08TO + E-09 NIPP)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							476	6087	4792	5498	-			40					
29	0-00-027-35580	ECO JN. HDR NIPPLE + ECO HGR TUBE (LTRH HDR SUPPT) (E-07 NIPP + E-08X)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							40	512	403	462	-			40					
30	0-00-027-35580	ECO HGR TUBE (LTRH HDR SUPPT)+ECO HGR TUBE (LTRH HDR SUPPT) (E-08X + E-08X)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							160	2046	1611	1848	-			40					

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	NIRMAL RAJ N	09-02-2026	1834-19-ECO-EWS	0	6/8

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 19

CUST No : 1834,1835

PG NAME : Economiser System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Economiser System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
31	0-00-027-35580	ECO HGR TUBE(LTRH HDR SUPPT)+ECO O/L HDR NIPPLE (E-08X + E-09 NIPPLE)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
							40	512	403	462	-			40					
32	0-19-851-02645 0-00-027-35571	ECO O/L HDR+ECO O/L LINK (E-09 + EF-01)	SA106GRC + SA106GRC	508	70	GTAW + SMAW	61.25 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							2	341	73	120	871			175					
33	0-19-851-02645 0-00-027-35571	ECO O/L LINK+ECO O/L LINK (EF-01 + EF-01)	SA106GRC + SA106GRC	508	70	GTAW + SMAW	61.25 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							18	3069	656	1075	7832			175					
34	0-19-851-02645 0-19-852-02665 0-00-027-35571	ECO O/L LINK+ECO MIXING LINE (EF-01 + EF-02)	SA106GRC + SA234WPC	508	70	GTAW + SMAW	61.25 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							2	341	73	120	871			175					
35	0-19-852-02665 0-19-853-02646 0-00-027-35571	ECO MIXING LINE+ECO WW I/L LINK (EF-02 + EF-03)	SA234WPC + SA106GRC	508	70	GTAW + SMAW	61.25 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							2	341	73	120	871			175					

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	NIRMAL RAJ N	09-02-2026	1834-19-ECO-EWS	0	7/8

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 19

CUST No : 1834,1835

PG NAME : Economiser System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Economiser System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
36	0-19-853-02646 0-00-027-35571	ECO WW I/L LINK+ECO WW I/L LINK (EF-03 + EF-03)	SA106GRC + SA106GRC	508	70	GTAW + SMAW	61.25 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							4	682	146	239	1741			175					
37	0-19-853-02646 0-00-027-35571	ECO WW I/L LINK+FURN SIDE I/L HDRS (EF-03 + F-16 L&R)	SA106GRC + SA234WPC	508	70	GTAW + SMAW	61.25 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							2	341	73	120	871			175					
38	0-19-753-02639 0-19-763-02643 0-19-783-02666 0-19-793-02668	ECO INTER HDRS:INSP. NOZZLE + FLAT END COVER	SA105 + SA105	168.3	45.4	GTAW + SMAW	39.72 ▽▽	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% RT 100% MPI/LPI				
							8	328	97	159	451			115					
39		GAMMA PLUG	SA105 + SA106GRC			SMAW	7 ◺	-	E7018			1101/01	150	Nil	100% LPI or MPI				
							23	-	6	-	-							FOR T >75 MM	
40		GAMMA PLUG	SA105 + SA106GRC			SMAW	7 ◺	-	E7018			1101/01	100	Nil	100% LPI or MPI				
							43	-	11	-	-							FOR T- (25-75) MM	

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	NIRMAL RAJ N	09-02-2026	1834-19-ECO-EWS	0	8/8

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 17

CUST No : 1834,1835

PG NAME : Reheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Reheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT TEMP. in °C	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0			TIME in mins		SPEC. NO	ACC NORM REF.		
1	0-00-027-35822	LTRH I/L HDR + SPOOL PIPE (R-03 HDR + R-03 SPOOL)	SA335P12 + SA335P12	558.8	35	GTAW + SMAW	30.62 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							2	439	81	132	300			90				NDT after SR	01
2	0-00-027-35822 0-00-027-35557	LTRH I/L HDR NIPPLE + LTRH I/L TERM TUBE (R-03 NIPPLE + R-04TI)	SA213T11 + SA213T11	69.85	5.08	GTAW + SMAW	5.08 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							952	17510	8317	-	-								
3	0-00-027-35557 0-00-027-35544	LTRH I/L TERM TUBE +LTRH LWR ASSY (R-04TI + R-04L)	SA213T11 + SA213T11	69.85	5.08	GTAW + SMAW	5.08 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							952	17510	8317	-	-								
4	0-00-027-35557 0-00-027-35544	LTRH LWR ASSY +LTRH LWR INTER ASSY (R-04L + R-04LI)	SA213T11 + SA213T11	69.85	5.08	GTAW + SMAW	5.08 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							952	17510	8317	-	-								
5	0-00-027-35557 0-00-027-35544	LTRH LWR INTER ASSY+LTRH INTER ASSY (R-04LI + R-04I)	SA213T11 + SA213T22	69.85	5.08	GTAW + SMAW	5.08 ▽	ER80S-B2	E8018-B2			1011/01	150	Nil	100% RT				
							952	17510	8317	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-17-RH-EWS	1	1/6

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* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX).
FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 17

CUST No : 1834,1835

PG NAME : Reheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Reheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
6	0-00-027-35557 0-00-027-35544	LTRH INTER ASSY +LTRH UPR INTER ASSY (R-04I + R-04UI)	SA213T22 + SA213T22	69.85	5.08	GTAW + SMAW	5.08 ▽	ER90S-B3	E9018-B3			1013/02	150	Nil	100% RT				
							952	17510	8317	-	-								
7	0-00-027-35557 0-00-027-35544	LTRH UPR INTER ASSY+LTRH UPR ASSY (R-04UI + R-04U)	SA213T22 + SA213T22	69.85	5.08	GTAW + SMAW	5.08 ▽	ER90S-B3	E9018-B3			1013/02	150	Nil	100% RT				
							952	17510	8317	-	-								
8	0-00-027-35573 0-00-027-35544	LTRH UPR ASSY + LTRH PENDANT LOOSE TUBE (R-04U + R-07B-LT)	SA213 UNS S30432 + SA213 UNS S30432	63.5	4	GTAW	4 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							952	71350	-	-	-								
9	0-00-027-35573 0-00-027-35544	LTRH PENDANT LOOSE TUBE+ LTRH PENDANT ASSY (R-07B-LT + R-07)	SA213 UNS S30432 + SA213 UNS S30432	63.5	4	GTAW	4 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							952	71350	-	-	-								
10	0-00-027-35573 0-00-027-35544	LTRH PENDANT ASSY +LTRH O/L TERM TUBE (R-07 + R-07TO)	SA213 UNS S30432 + SA213 UNS S30432	63.5	4	GTAW	4 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							952	71350	-	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-17-RH-EWS	1	2/6

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 17

CUST No : 1834,1835

PG NAME : Reheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Reheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
11	0-00-027-35573 0-00-027-35544	LTRH O/L TERM TUBE +LTRH O/L HDR NIPPLE (R-07TO (1, 8) + R-08 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	50.8	4	GTAW	4 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							238	14270	-	-	-								
12	0-00-027-35573 0-00-027-35544	LTRH O/L TERM TUBE +LTRH O/L HDR NIPPLE (R-07TO (2-7) + R-08 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	44.45	4.2	GTAW	4.2 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							714	40491	-	-	-								
13	0-00-027-35548 1-17-174-00671	LTRH O/L HDR+ LINK TO RH DESH (R-08 + R-09)	SA335P91 + SA234WP91	813	40	GTAW + SMAW	35.00 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	654	195	260	791			100					
14	0-00-027-35548 1-17-174-00671	LINK TO RH DESH+ LINK TO RH DESH (R-09 + R-09)	SA335P91 + SA234WP91	813	40	GTAW + SMAW	35.00 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	654	195	260	791			100					
15	0-00-027-35548 0-17-900-00729	LINK TO RH DESH+ RH DESH (R-09 + R-10)	SA335P91 + SA335P91	813	40	GTAW + SMAW	35.00 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	654	195	260	791			100					

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-17-RH-EWS	1	3/6

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 17

CUST No : 1834,1835

PG NAME : Reheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Reheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
16	0-00-027-35548 0-17-900-00729 0-17-174-00801	RH DESH+ LINK TO FINISH RH (R-10 + R-11)	SA335P91 + SA335P91	813	40	GTAW + SMAW	35.00 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	654	195	260	791			100					
17	0-00-027-35548 0-17-174-00801	LINK TO FINISH RH+ LINK TO FINISH RH (R-11 + R-11)	SA335P91 + SA234WP91	813	40	GTAW + SMAW	35.00 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							7	2286	680	908	2767			100					
18	0-00-027-35547 0-17-174-00801	LINK TO FINISH RH+ FINISH RH I/L HDR (R-11 + R-12)	SA234WP91 + SA335P91	609.6	40	GTAW + SMAW	35.00 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	476	146	195	583			100					
19	0-00-027-35559 0-00-027-35560	FINISH RH I/L HDR NIPP+ FINISH RH I/L TERM TUBES (R-12 NIPPLE + R-13TI (1))	SA213T22 + SA213T22	76.2	6.6	GTAW + SMAW	6.6 ▽	ER90S-B3	E9018-B3			1013/02	150	Nil	20%RT + 80% PAUT				
							51	991	770	-	-								
20	0-00-027-35559 0-00-027-35560	FINISH RH I/L HDR NIPP+ FINISH RH I/L TERM TUBES (R-12 NIPPLE + R-13TI (2-3))	SA213T22 + SA213T22	63.5	5.59	GTAW + SMAW	5.59 ▽	ER90S-B3	E9018-B3			1013/02	150	Nil	100% RT				
							102	1643	956	-	-								

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RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-17-RH-EWS	1	4/6

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 17

CUST No : 1834,1835

PG NAME : Reheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Reheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
21	0-00-027-35559 0-00-027-35560	FIN. RH I/L HDR NIPP+ FINISH RH I/L TERM TUBES (R-12 NIPPLE + R-13TI (4-5))	SA213T22 + SA213T22	50.8	4.5	GTAW + SMAW	4.5 ▽	ER90S-B3	E9018-B3			1013/02	150	Nil	100% RT				
							102	1310	529	-	-								
22	0-00-027-35559 0-00-027-35560	FIN RH I/L HDR NIPP+ FINISH RH I/L TERM TUBES (R-12 NIPPLE + R-13TI (6-14))	SA213T22 + SA213T22	44.5	4.5	GTAW + SMAW	4.5 ▽	ER90S-B3	E9018-B3			1013/02	150	Nil	100% RT				
							459	4992	2085	-	-								
23	0-00-027-35559 0-00-027-35560	FINISH RH I/L TERM TUBES + FINISH RH ASSY (R-13TI (1) + R-13(1))	SA213 UNS S30432 + SA213 UNS S30432	76.2	5.08	GTAW	5.08 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							51	6800	-	-	-								
24	0-00-027-35559 0-00-027-35560	FINISH RH I/L TERM TUBES + FINISH RH ASSY (R-13TI (2-14) + R-13(2-14))	SA213 UNS S30432 + SA213 UNS S30432	63.5	4	GTAW	4 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							663	49691	-	-	-								
25	0-00-027-35559 0-00-027-35560	FINISH RH ASSY+FIN. RH O/L TERM TUBES (R-13 (1) + R-13TO (1))	SA213 UNS S30432 + SA213 UNS S30432	76.2	5.08	GTAW	5.08 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							51	6800	-	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-17-RH-EWS	1	5/6

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 17

CUST No : 1834,1835

PG NAME : Reheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Reheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
26	0-00-027-35559 0-00-027-35560	FIN RH ASSY+FIN. RH O/L TERM TUBES (R-13 (2-14) + R-13TO (2-14))	SA213 UNS S30432 + SA213 UNS S30432	63.5	4	GTAW	4 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							663	49691	-	-	-								
27	0-00-027-35559 0-00-027-35560	FIN RH O/L TERM TUBE+FINISH RH O/L HDR NIPPLE (R-13TO (1-14) + R-14 NIP)	SA213 UNS S30432 + SA213 UNS S30432	57.15	4.2	GTAW	4.2 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							714	52060	-	-	-								
28		GAMMA PLUG	SA335P12 + SA182F22CL3			SMAW	7 ◺	-	E8018-B2			1102/01	200	Nil	100% LPI or MPI			FOR T- (25-75) MM	
							2	-	1	-	-								

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RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-17-RH-EWS	1	6/6

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT TEMP. in °C	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.					TIME in mins		SPEC. NO	ACC NORM REF.		
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0								
1	2-12-850-03559 TO 2-12-850-03566 0-00-027-35568	SEPARATOR+ SH CONNECTING PIPE (F-31 NOZZLE + S-01)	SA182F22CL3 + SA335P12	273	50	GTAW + SMAW	43.75 ▽▽	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI			NDT after SR	01
							8	666	157	257	1020			125					
2	2-12-850-03559 TO 2-12-850-03566	SH CONN. PIPE+ SH CONN. PIPE (S-01 + S-01)	SA335P12 + SA234WP12CL1	273	50	GTAW + SMAW	43.75 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							32	2661	627	1027	4079			125					
3	2-12-850-03559 TO 2-12-850-03566 0-00-027-35569	SH CONNECTING PIPE + SH FURNACE ROOF I/L HDR (S-01 + S-02 TEE)	SA335P12 + SA234WP12CL1	273	50	GTAW + SMAW	43.75 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							8	666	157	257	1020			125					
4	0-00-027-35549 0-00-027-35569	SH FURNACE ROOF I/L HEADER + SH FURN ROOF PANEL/LT (S-02 NIPPLE + S-03/S-03LT)	SA213T12 + SA213T12	54	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							208	2407	1928	300	-								
5	0-00-027-35549 0-00-027-35569	SH FURN ROOF I/L HDR /SH FURN ROOF PANEL + LOOSE TUBE (S-02 NIPP/S-03 + S-03LT)	SA213T12 + SA213T12	50.8	8.64	GTAW + SMAW	8.64 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							4	42	34	8	-								

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RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	1/20

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
6	0-00-027-35549 0-00-027-35569	SH FURN ROOF PNL LOOSE TUBE +SH FURN ROOF PANEL (S-03LT + S-03)	SA213T12 + SA213T12	54	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							32	371	297	47	-								
7	0-00-027-35549 0-00-027-35569	SH FURN ROOF PANEL +SH FURN ROOF TUBES (S-03 + S-04A)	SA213T12 + SA213T12	60.3	10.16	GTAW + SMAW	10.16 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							210	2577	2043	796	-								
8	0-00-027-35549 0-00-027-35569	SH FURN ROOF TUBE +SH FURN ROOF TUBES (S-04A + S-04B)	SA213T12 + SA213T12	60.3	10.16	GTAW + SMAW	10.16 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							210	2577	2043	796	-								
9	0-00-027-35549 0-00-027-35569	SH FURN ROOF TUBES+SH FURN ROOF O/L HDR (S-04B + S-05 NIPPLE)	SA213T12 + SA213T22	60.3	10.16	GTAW + SMAW	10.16 ▽	ER80S-B2	E8018-B2			1012/04	150	680-720	20%RT + 80% PAUT				
							210	2577	2043	796	-			30					
10	0-00-027-35569 0-00-027-35579	SH FURN ROOF O/L HDR ELBOW+BP EXT SIDE I/L HDR (S-05 ELBOW + S-06 TEE)	SA234WP22CL1 + SA234WP12CL1	406.4	80	GTAW + SMAW	70.00 ▽▽	ER80S-B2	E8018-B2			1012/04	150	680-720	100% (ISRT+UT) 100% MPI/LPI				
							2	237	59	96	818			200				NDT after SR	01

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	2/20

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* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX).
FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
11	0-00-027-35579	BP EXT SIDE I/L HDR+BP EXT SIDE WALL PANEL (S-06 NIPPLE + S-07 L&R)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							172	1535	1968	-	-								
12	0-00-027-35579	BP EXT SIDE WALL PANEL LOOSE TUBES + BP EXT SIDE WALL PANEL (S-07 L&R LT+ S-07 L&R)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							26	232	298	-	-								
13	0-00-027-35579	BP EXT SIDE WALL PANEL+BP EXT SIDE FLOOR PANEL (S-07 L&R + S-08 L&R)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							172	1535	1968	-	-								
14	0-00-027-35579	BP EXT SIDE FLOOR PANEL + BP EXT SIDE FLOOR PANEL (S-08 L&R + S-08TOA/B)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							172	1535	1968	-	-								
15	0-00-027-35579 0-00-027-36584	BP EXT SIDE FLOOR PANEL + BP EXT SIDE FLOOR PANEL LOOSE TUBES (S-08TOA/B + S-08 LT)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							172	1535	1968	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	3/20

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
16	0-00-027-35579 0-00-027-36584	BP EXT SIDE FLOOR PANEL LOOSE TUBES + BP EXT SIDE FLOOR O/L HDR (S-08 LT + S-09 NIPP)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							172	1535	1968	-	-								
17	0-00-027-35575	BP EXT SIDE FLOOR O/L HDR+ SC FURN ARCH SUPPT I/L HDR (S-09 + S-09A TEE)	SA335P12 + SA234WP12CL1	406.4	85	GTAW + SMAW	74.38 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% (ISRT+UT) 100% MPI/LPI				
							1	115	30	48	447			215				NDT after SR	01
18	0-00-027-35575	SC FURN ARCH SUPPORT I/L HDR+SC FURN ARCH SUPPT LINK (S-09A NOZZLE + S-09B)	SA182F12CL2 + SA335P12	168.3	47.6	GTAW + SMAW	41.65 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							20	786	242	396	1205			120				NDT after SR	01
19	0-00-027-35575	SC FURN ARCH SUPT LINK+SC FURN ARCH SUPPT O/L HDR (S-09B + S-09C NOZZLE)	SA335P12 + SA182F12CL2	168.3	47.6	GTAW + SMAW	41.65 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							20	786	242	396	1205			120				NDT after SR	01
20	0-00-027-35575	SC FURN ARCH SUPT O/L HDR + BP EXT SIDE CONNECTING LINK (S-09C TEE + S-10)	SA234WP12CL1 + SA335P12	323.9	60	GTAW + SMAW	52.50 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							2	196	47	77	410			150				NDT after SR	01

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	4/20

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
21	0-12-184-03706 0-00-027-35571	BP EXT SIDE CONN. LINK+ BP EXT SIDE CONN. LINK (S-10 + S-10)	SA234WP12CL1 + SA335P12	323.9	60	GTAW + SMAW	52.50 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							12	1173	279	457	2457			150				NDT after SR	01
22	0-12-184-03706 0-00-027-35571	BP EXT SIDE CONN. LINK+ BP LWR FRONT HDR (S-10 + S-14)	SA335P12 + SA335P22	323.9	60	GTAW + SMAW	52.50 ▽▽	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI				
							2	196	47	77	410			150				NDT after SR	01
23	1-12-184-02197 0-00-027-35575	BP EQUALIZING LINE+BP EXT SIDE FLOOR O/L HDR/ EXT SIDE LINK (S-09D + S-09/S-10)	SA213T12 + SA213T12	38.1	6.6	GTAW + SMAW	6.6 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							2	16	16	-	-								
24	1-12-184-02197 0-00-027-35575	BP EQUALIZING LINE+BP EQUALIZING LINE (S-09D + S-09D)	SA213T12 + SA213T12	38.1	6.6	GTAW + SMAW	6.6 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							6	46	46	-	-								
25	0-00-027-35579	BP EXT SIDE I/L HDR +BP UPR SIDE I/L HDR (S-06 TEE + S-11 -L&R)	SA234WP12CL1 + SA335P12	406.4	85	GTAW + SMAW	74.38 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% (ISRT+UT) 100% MPI/LPI				
							2	230	59	96	893			215				NDT after SR	01

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	5/20

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
26	0-00-027-35601	BP UPR SIDE I/L HDR +BP UPR SIDE WALL PANEL (S-11 NIPPLE + S-12U L&R)	SA213T12 + SA213T12	50.8	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							278	2941	2394	384	-								
27	0-00-027-35601	BP UPR SIDE WALL PANEL+ BP INTER SIDE WALL PANEL (S-12U L&R + S-12I L&R)	SA213T12 + SA213T12	50.8	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							278	2941	2394	384	-								
28	0-00-027-35601	BP INTER SIDE WALL PANEL+ BP LWR SIDE WALL PANEL (S-12I L&R + S-12L L&R)	SA213T12 + SA213T12	50.8	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							278	2941	2394	384	-								
29	0-00-027-35601	LTRH OPENING LOOSE TUBES L&R	SA213T12 + SA213T12	50.8	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							40	424	345	56	-								
30	0-00-027-35601	BP LWR SIDE WALL PANEL + BP LWR SIDE WALL PANEL LOOSE TUBES (S-12L L&R + S-13 LT)	SA213T12 + SA213T22	50.8	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1012/04	150	680-720	20%RT + 80% PAUT				
							16	170	138	23	-			30					

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	6/20

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
31	0-00-027-35601	BP LWR SIDE WALL PANEL+ BP LOWER SIDE HDR NIPPLES (S-12L L&R + S-13 L&R NIPPLE)	SA213T12 + SA213T22	50.8	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1012/04	150	680-720	20%RT + 80% PAUT				
							262	2772	2256	362	-			30					
32	0-00-027-35601	BP LWR SIDE WALL PANEL LOOSE TUBES + BP LOWER SIDE HDR NIPPLES (S-13 LT + S-13 L&R NIPPLE)	SA213T22 + SA213T22	50.8	8.13	GTAW + SMAW	8.13 ▽	ER90S-B3	E9018-B3			1014/03	150	680-720	20%RT + 80% PAUT				
							16	170	138	23	-			30					
33	0-00-027-35601 0-00-027-35572	BP LWR FRONT WALL + BP LWR FRONT WALL PANEL LOOSE TUBES (S-15L + S-14LT/S-13 LT)	SA213T12 + SA213T22	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1011/01	150	Nil	20%RT + 80% PAUT				
							12	108	138	-	-								
34	0-00-027-35601	BP LWR FRONT HDR+ BP LOWER FRONT WALL PANEL (S-14 NIPPLE + S-15L)	SA213T22 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1011/01	150	Nil	20%RT + 80% PAUT				
							148	1321	1694	-	-								
35	0-00-027-35601 0-00-027-35572	BP LWR FRONT WALL PANEL LOOSE TUBES+ BP LWR FRONT/SIDE HDR(S-14LT/S-13LT + S-14/S-13)	SA213T22 + SA213T22	44.45	7.62	GTAW + SMAW	7.62 ▽	ER90S-B3	E9018-B3			1013/02	150	Nil	20%RT + 80% PAUT				
							12	108	138	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	7/20

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
36	0-00-027-35601	BP LWR FRONT WALL PANEL+ BP UPPER FRONT WALL PANEL (S-15L + S-15U)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							160	1428	1831	-	-								
37	0-00-027-35601	BP UPR FRONT WALL PANEL+BP UPR FRONT WALL PANEL (S-15U + S-16 PANEL)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							160	1428	1831	-	-								
38	0-00-027-35601	BP UPR FRONT WALL PANEL+BP FRONT SCREEN TUBES (S-16 PANEL + S-16)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							160	1428	1831	-	-								
39	0-00-027-35601 0-00-027-35569	BP FRONT SCREEN TUBES+ BP FRONT O/L HDR (S-16 + S-22 NIPPLE)	SA213T12 + SA213T22	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1011/01	150	Nil	20%RT + 80% PAUT				
							160	1428	1831	-	-								
40	0-00-027-35569 0-00-027-35558	BP FRONT O/L HDR+ BP ROOF PANEL (S-22 NIPPLE + S-21)	SA213T22 + SA213T12	48.3	9.2	GTAW + SMAW	9.2 ▽	ER80S-B2	E8018-B2			1012/04	150	680-720	20%RT + 80% PAUT				
							160	1462	1226	360	-			30					

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	8/20

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
41	0-00-027-35601	BP ROOF PANEL+ BP UPPER REAR WALL PANEL (S-21 + S-20U)	SA213T12 + SA213T12	48.3	9.2	GTAW + SMAW	9.2 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							160	1462	1226	360	-								
42	0-00-027-35601	BP UPR REAR WALL PANEL+ BP INTER REAR WALL PANEL (S-20U + S-20I)	SA213T12 + SA213T12	48.3	9.2	GTAW + SMAW	9.2 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							160	1462	1226	360	-								
43	0-00-027-35601	BP INTER REAR WALL PANEL+ BP LOWER REAR WALL PANEL (S-20I + S-20L)	SA213T12 + SA213T12	48.3	9.2	GTAW + SMAW	9.2 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							160	1462	1226	360	-								
44	0-00-027-35601 0-00-027-35572	BP LOWER REAR WALL PANEL + BP LOWER REAR WALL PANEL LOOSE TUBES (S-20L + S-13LT/S-17LT)	SA213T12 + SA213T22	48.3	9.2	GTAW + SMAW	9.2 ▽	ER80S-B2	E8018-B2			1012/04	150	680-720	20%RT + 80% PAUT				
							8	74	62	18	-			30					
45	0-00-027-35601 0-00-027-35572	BP LWR REAR WALL + BP LWR REAR HDR (S-20L+S-17 NIPP)	SA213T12 + SA213T22	48.3	9.2	GTAW + SMAW	9.2 ▽	ER80S-B2	E8018-B2			1012/04	150	680-720	20%RT + 80% PAUT				
							152	1389	1165	342	-			30					

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	9/20

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* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX).
FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
46	0-00-027-35601 0-00-027-35572	BP LOWER REAR WALL PANEL LOOSE TUBES + BP LWR REAR HDR (S-13LT/S-17LT + S-17NIPP)	SA213T22 + SA213T22	48.3	9.2	GTAW + SMAW	9.2 ▽	ER90S-B3	E9018-B3			1014/03	150	680-720	20%RT + 80% PAUT				
							8	74	62	18	-			30					
47	0-00-027-35572	BP LWR FRONT HDR+ BP LWR SIDE HDRS (S-14 + S-13 ELBOW L&R)	SA335P91 + SA234WP91	406.4	80	GTAW + SMAW	70.00 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	237	98	130	1145			200					
48	0-00-027-35572	BP LWR SIDE HDRS+ BP LWR REAR HDR (S-13 ELBOW L&R+ S-17)	SA234WP91 + SA335P91	406.4	80	GTAW + SMAW	70.00 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	237	98	130	1145			200					
49	0-00-027-35569	BP FRONT O/L HDR + SPOOL PIPE	SA234WP22CL1 + SA335P12	457	75	GTAW + SMAW	65.62 ▽▽	ER80S-B2	E8018-B2			1012/04	150	680-720	100% (ISRT+UT) 100% MPI/LPI				
							2	289	66	108	855			190				NDT after SR	01
50	0-00-027-35569	BP FRONT O/L HDR SPOOL PIPE + LINK FROM BP FRNT O/L HDR (S-22 SPOOL PIPE + S-25A)	SA335P12 + SA335P12	457	75	GTAW + SMAW	65.62 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% (ISRT+UT) 100% MPI/LPI				
							2	289	66	108	855			190				NDT after SR	01

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	10/20

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
51	1-12-852-02195 0-00-027-35548	LINK FROM BP FRNT O/L HDR+LINK FROM BP FRNT O/L HDR (S-25A + S-25A)	SA335P12 + SA234WP12CL1	457	75	GTAW + SMAW	65.62 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% (ISRT+UT) 100% MPI/LPI				
							4	578	132	215	1709			190				NDT after SR	01
52	1-12-852-02195 0-00-027-35548	LINK FROM BP FRNT O/L HDR+ LINK TO PLATEN SH (S-25A + S25B)	SA335P12 + SA335P12	457	75	GTAW + SMAW	65.62 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% (ISRT+UT) 100% MPI/LPI				
							2	289	66	108	855			190				NDT after SR	01
53	1-12-852-02196 0-00-027-35547	LINK TO PLATEN SH+ LINK TO PLATEN SH (S-25B + S-25B)	SA335P12 + SA234WP12CL1	457	75	GTAW + SMAW	65.62 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% (ISRT+UT) 100% MPI/LPI				
							4	578	132	215	1709			190				NDT after SR	01
54	1-12-852-02196 0-00-027-35547	LINK TO PLATEN SH+ SH PLATEN FRONT I/L HDR (S-25B + S-26 TEE)	SA335P12 + SA234WP12CL1	457	75	GTAW + SMAW	65.62 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% (ISRT+UT) 100% MPI/LPI				
							2	289	66	108	855			190				NDT after SR	01
55	0-12-187-03715 0-00-027-35547	BP BYPASS PIPE+ LINK TO SH PLATEN (S-24 + S-25B)	SA335P12 + SA182F12CL2	273	45	GTAW + SMAW	39.38 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI				
							2	174	40	65	206			115				NDT after SR	01

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	11/20

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
56	0-12-187-03715 0-00-027-35547	BP BYPASS PIPE + LINK FROM SH CONNECTING PIPE (S-24 + S-01 TEE)	SA335P12 + SA234WP12CL1	273	45	GTAW + SMAW	39.38 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							8	696	157	257	821			115					
57	0-12-187-03715 0-00-027-35547	BP BYPASS PIPE+ BP BYPASS PIPE (S-24 + S-24)	SA335P12 + SA335P12	273	45	GTAW + SMAW	39.38 ▽▽	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							20	1740	392	642	2051			115					
58	0-00-027-35561 0-00-027-35562	SH PLATEN FRONT I/L HDR+SH PLATEN FRONT I/L TERM TUBE (S-26 NIPPLE + S-27TI(1))	SA213T22 + SA213T22	50.8	8.64	GTAW + SMAW	8.64 ▽	ER90S-B3	E9018-B3			1014/03	150	680-720	20%RT + 80% PAUT				
							34	349	286	62	-			30					
59	0-00-027-35561 0-00-027-35562	SH PLATEN FRONT I/L HDR+SH PLATEN FRONT I/L TERM TUBE (S-26 NIPPLE + S-27TI (2-3))	SA213T22 + SA213T22	44.5	7.1	GTAW + SMAW	7.1 ▽	ER90S-B3	E9018-B3			1013/02	150	Nil	20%RT + 80% PAUT				
							68	630	685	-	-								
60	0-00-027-35561 0-00-027-35562	SH PLATEN FRONT I/L HDR+SH PLATEN FRONT I/L TERM TUBE (S-26 NIPPLE + S-27TI (4-18))	SA213T22 + SA213T22	33.4	6.6	GTAW + SMAW	6.6 ▽	ER90S-B3	E9018-B3			1013/02	150	Nil	20%RT + 80% PAUT				
							510	3122	3375	-	-								

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RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	12/20

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
61	0-00-027-35561 0-00-027-35562	SH PLATEN FRONT I/L TERM TUBE+SH PLATEN FRONT ASSY (S-27TI(1) + S-27(1))	SA213T22 + SA213T22	50.8	8.64	GTAW + SMAW	8.64 ▽	ER90S-B3	E9018-B3			1014/03	150	680-720	100% RT				
							34	349	286	62	-			30					
62	0-00-027-35561 0-00-027-35562	SH PLATEN FRONT I/L TERM TUBE+SH PLATEN FRONT ASSY (S-27TI(2-3) + S-27(2-3))	SA213T22 + SA213T22	44.5	7.1	GTAW + SMAW	7.1 ▽	ER90S-B3	E9018-B3			1013/02	150	Nil	100% RT				
							68	630	685	-	-								
63	0-00-027-35561 0-00-027-35562	SH PLATEN FRONT I/L TERM TUBE+SH PLATEN FRONT ASSY (S-27TI(4-18) + S-27(4-18))	SA213T22 + SA213T22	33.4	6.6	GTAW + SMAW	6.6 ▽	ER90S-B3	E9018-B3			1013/02	150	Nil	100% RT				
							510	3122	3375	-	-								
64	0-00-027-35561 0-00-027-35562	SH PLATEN FRONT ASSY+ SH PLATEN FRONT O/L TERM TUBE (S-27 (1) + S-27TO (1))	SA213 UNS S30432 + SA213 UNS S30432	50.8	8.64	GTAW	8.64 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							34	4683	-	-	-								
65	0-00-027-35561 0-00-027-35562	SH PLATEN FRONT ASSY+ SH PLATEN FRONT O/L TERM TUBE (S-27 (2-18) + S-27TO (2-18))	SA213 UNS S30432 + SA213 UNS S30432	44.45	7.11	GTAW	7.11 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							578	48606	-	-	-								

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	13/20

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
66	0-00-027-35561 0-00-027-35562	SH PLATEN FRONT O/L TERM TUBE+ SH PLATEN FRONT O/L HDR (S-27TO (1) + S-28 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	50.8	8.64	GTAW	8.64 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							34	4683	-	-	-								
67	0-00-027-35561 0-00-027-35562	SH PLATEN FRONT O/L TERM TUBE+ SH PLATEN FRONT O/L HDR (S-27TO (2-18) + S-28 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	44.45	7.11	GTAW	7.11 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							578	48606	-	-	-								
68	0-12-178-03679 0-00-027-35547	SH PLATEN FRONT O/L HDR+ LINK TO SH DESUPERHEATER-1 (S-28 TEE + S-29)	SA234WP91 + SA335P91	559	80	GTAW + SMAW	70.00 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	371	134	179	1663			200					
69	0-12-178-03679 0-00-027-35547	LINK TO SH DESH-1+ LINK TO SH DESH-1 (S-29 + S-29)	SA335P91 + SA234WP91	559	80	GTAW + SMAW	70.00 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							6	1111	401	535	4987			200					
70	0-12-178-03679 0-00-027-35547	LINK TO SH DESH-1+ SH DESH-1 (S-29 + S-30)	SA335P91 + SA335P91	559	80	GTAW + SMAW	70.00 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	371	134	179	1663			200					

PREPARED	CHECKED (W.T.C)	APPROVED	DATE	DOC NO.	REV NO :	PAGE NO.
RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	14/20

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
71	0-12-178-03680 0-00-027-35547	SH DESH-1+ LINK FROM SH DESH-1 (S-30 + S-31)	SA335P91 + SA335P91	558.8	76.2	GTAW + SMAW	66.68 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	376	134	179	1544			195					
72	0-12-178-03680 0-00-027-35547	LINK FROM SH DESH-1+ LINK FROM SH DESH-1 (S-30 + S-30)	SA335P91 + SA234WP91	558.8	76.2	GTAW + SMAW	66.68 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	376	134	179	1544			195					
73	0-12-178-03680 0-00-027-35547	LINK FROM SH DESH-1+ SH PLATEN REAR I/L HDR (S-31 + S-32 TEE)	SA335P91 + SA234WP91	558.8	75	GTAW + SMAW	65.62 ▽▽	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	378	134	179	1507			190					
74	0-00-027-35563 0-00-027-35564	SH PLATEN REAR I/L HDR+ SH PLATEN REAR I/L TERM TUBE (S-32 NIPPLE + S-33TI (1))	SA213 UNS S30432 + SA213 UNS S30432	50.8	8.64	GTAW	8.64 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							34	4683	-	-	-								
75	0-00-027-35563 0-00-027-35564	SH PLATEN REAR I/L HDR+ SH PLATEN REAR I/L TERM TUBE (S-32 NIPPLE + S-33TI (2-18))	SA213 UNS S30432 + SA213 UNS S30432	44.45	7.11	GTAW	7.11 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							578	48606	-	-	-								

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RUDRABHATLA SAIKUMAR	MANIKANDAN C	ANAND KUMAR S	06-05-2026	1834-12-SH-EWS	1	15/20

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* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX).
FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
76	0-00-027-35563 0-00-027-35564	SH PLATEN REAR I/L TERM TUBE+ SH PLATEN REAR ASSY (S-33TI (1) + S-33 (1))	SA213 UNS S30432 + SA213 UNS S30432	50.8	8.64	GTAW	8.64 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							34	4683	-	-	-								
77	0-00-027-35563 0-00-027-35564	SH PLATEN REAR I/L TERM TUBE+ SH PLATEN REAR ASSY (S-33TI (2-18) + S-33 (2-18))	SA213 UNS S30432 + SA213 UNS S30432	44.45	7.11	GTAW	7.11 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							578	48606	-	-	-								
78	0-00-027-35563 0-00-027-35564	SH PLATEN REAR ASSY+ SH PLATEN REAR O/L TERM TUBE (S-33(1)+S-33TO (1))	SA213 UNS S30432 + SA213 UNS S30432	50.8	8.64	GTAW	8.64 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							34	4683	-	-	-								
79	0-00-027-35563 0-00-027-35564	SH PLATEN REAR ASSY+ SH PLATEN REAR O/L TERM TUBE (S-33 (2-18) + S-33TO (2-18))	SA213 UNS S30432 + SA213 UNS S30432	44.45	7.11	GTAW	7.11 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							578	48606	-	-	-								
80	0-00-027-35563 0-00-027-35564	SH PLATEN REAR O/L TERM TUBE+ SH PLATEN REAR O/L HDR (S-33TO (1) + S-34 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	50.8	8.64	GTAW	8.64 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							34	4683	-	-	-								

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
81	0-00-027-35563 0-00-027-35564	SH PLATEN REAR O/L TERM TUBE+ SH PLATEN REAR O/L HDR (S-33TO(2-3) + S-34 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	44.45	7.6	GTAW	7.6 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							68	6461	-	-	-								
82	0-00-027-35563 0-00-027-35564	SH PLATEN REAR O/L TERM TUBE+ SH PLATEN REAR O/L HDR (S-33TO (4-18) + S-34 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	44.45	8.1	GTAW	8.1 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							510	54502	-	-	-								
83	0-12-179-03684	SH PLATEN REAR O/L HDR+ LINK FROM SH DESUPERHEATER-2 (S-34 TEE + S-35)	SA234WP92 + SA335P92	559	85	GTAW + SMAW	74.38 ▽▽	ER90S-B92	E9015-B92			1056/04	220	755 ± 15	100% UT 100% MPI			NDT after SR; 100% HC, 186 HB TO 300HB	
							2	363	134	179	1822			215					
84	0-12-179-03684	LINK FROM SH DESH-2 +LINK FROM SH DESH-2 (S-35 + S-35)	SA234WP92 + SA335P92	559	85	GTAW + SMAW	74.38 ▽▽	ER90S-B92	E9015-B92			1056/04	220	755 ± 15	100% UT 100% MPI			NDT after SR; 100% HC, 186 HB TO 300HB	
							4	726	268	357	3644			215					
85	0-12-179-03684	LINK FROM SH DESH-2+ SH DESUPERHEATER-2 (S-35 + S-36)	SA335P92 + SA335P92	559	85	GTAW + SMAW	74.38 ▽▽	ER90S-B92	E9015-B92			1056/04	220	755 ± 15	100% UT 100% MPI			NDT after SR; 100% HC, 186 HB TO 300HB	
							2	363	134	179	1822			215					

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
86	0-12-179-03685	SH DESH-2+ LINK TO FINISH SH (S-36 + S-37)	SA335P92 + SA335P92	559	85	GTAW + SMAW	74.38 ▽▽	ER90S-B92	E9015-B92			1056/04	220	755 ± 15	100% UT 100% MPI			NDT after SR; 100% HC, 186 HB TO 300HB	
							2	363	134	179	1822			215					
87	0-12-179-03685	LINK TO FINISH SH+ LINK TO FINISH SH (S-37 + S-37)	SA234WP92 + SA335P92	559	85	GTAW + SMAW	74.38 ▽▽	ER90S-B92	E9015-B92			1056/04	220	755 ± 15	100% UT 100% MPI			NDT after SR; 100% HC, 186 HB TO 300HB	
							3	544	201	268	2733			215					
88	0-12-179-03685	LINK TO FINISH SH+ FINISH SH I/L HDR (S-37 + S-38 TEE)	SA335P92 + SA234WP92	559	80	GTAW + SMAW	70.00 ▽▽	ER90S-B92	E9015-B92			1056/04	220	755 ± 15	100% UT 100% MPI			NDT after SR; 100% HC, 186 HB TO 300HB	
							2	371	134	179	1663			200					
89	0-00-027-35565 0-00-027-35566	FINISH SH I/L HDR+ FINISH SH I/L TERM TUBE (S-38 NIPPLE + S-39TI (1-11))	SA213 UNS S30432 + SA213 UNS S30432	44.45	7.11	GTAW	7.11 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							1144	96203	-	-	-								
90	0-00-027-35565 0-00-027-35566	FINISH SH I/L TERM TUBE+ FINISH SH FRONT ASSY (S-39TI (1) + S-39 (1-11))	SA213 UNS S30432 + SA213 UNS S30432	44.45	7.11	GTAW	7.11 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							1144	96203	-	-	-								

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
91	0-00-027-35565 0-00-027-35566	FINISH SH FRONT ASSY+ FINISH SH REAR ASSY (S-39 (1) + S-40 (1))	SA213 UNS S30432 + SA213 UNS S30432	44.45	8.1	GTAW	8.1 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							104	11115	-	-	-								
92	0-00-027-35565 0-00-027-35566	FINISH SH FRONT ASSY+ FINISH SH REAR ASSY (S-39 (2-11) + S-40 (2-11))	SA213 UNS S30432 + SA213 UNS S30432	44.45	7.6	GTAW	7.6 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							1040	98807	-	-	-								
93	0-00-027-35565 0-00-027-35566	FINISH SH REAR ASSY+ FINISH SH O/L TERM TUBE (S-40 (1-11) + S-40TI (1-11)	SA213 UNS S30432 + SA213 UNS S30432	38.1	9.14	GTAW	9.14 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							1144	131277	-	-	-								
94	0-00-027-35565 0-00-027-35566	FINISH SH REAR ASSY+ FINISH SH O/L HDR (S-40 (1-11) + S-41 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	38.1	9.14	GTAW	9.14 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							1144	131277	-	-	-								
95	0-00-027-35552 0-00-027-35553 0-00-027-35554	SC FURN ARCH SUPPT I/L HDR+ STEAM COOLED SPACER TUBE (S-09A + S-44), (S-44+S-44)	SA213T12 + SA213T12	50.8	9.14	GTAW + SMAW	9.14 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							6	60	50	14	-								

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FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.

355-005/A
(09-09-2016)

ERECTION WELDING SCHEDULE

PG NO : 12

CUST No : 1834,1835

PG NAME : Superheater System

PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)

SYSTEM DESCRIPTION : Superheater System

WELDING CODE : IBR / ASME

PRESSURE PARTS/~~NON PRESSURE PARTS~~

CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01

SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV
								GTAW	SMAW										
									Qty in Nos.										
				SIZE	THICK		Qty in Nos.	Qty in gms	Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM		
96	0-00-027-35552 0-00-027-35553 0-00-027-35554	SC SPACER TUBE + SC SPACER TUBE (S-44 + S-44)	SA213 UNS S30432 + SA213 UNS S30432	57.15	9.65	GTAW	9.65 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT				
							49	9342	-	-	-								
97	0-00-027-35552 0-00-027-35553 0-00-027-35554	SC SPACER TUBE+SH PLATEN REAR I/L HDR (S-44 + S-32), (S-44 + S-44)	SA213T91 + SA213T91	42.4	7.11	GTAW + SMAW	7.11 ▽	ER90S-B9	E9015-B91			1036/09	220	745 ± 15	20%RT + 80% PAUT			NDT after SR; 100% HC, 180 HB TO 300HB	
							6	94	97	-	-			30					
98		GAMMA PLUG	SA335P12 + SA182F22CL3			SMAW	7 ◺	-	E8018-B2			1102/01	200	Nil	100% LPI or MPI				
							157	-	40	-	-							FOR T- (25-75) MM	
99		GAMMA PLUG	SA234WP22CL1 + SA182F22CL3			SMAW	7 ◺	-	E9018-B3			1103/01	200	Nil	100% LPI or MPI				
							2	-	1	-	-							FOR T >75 MM	

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