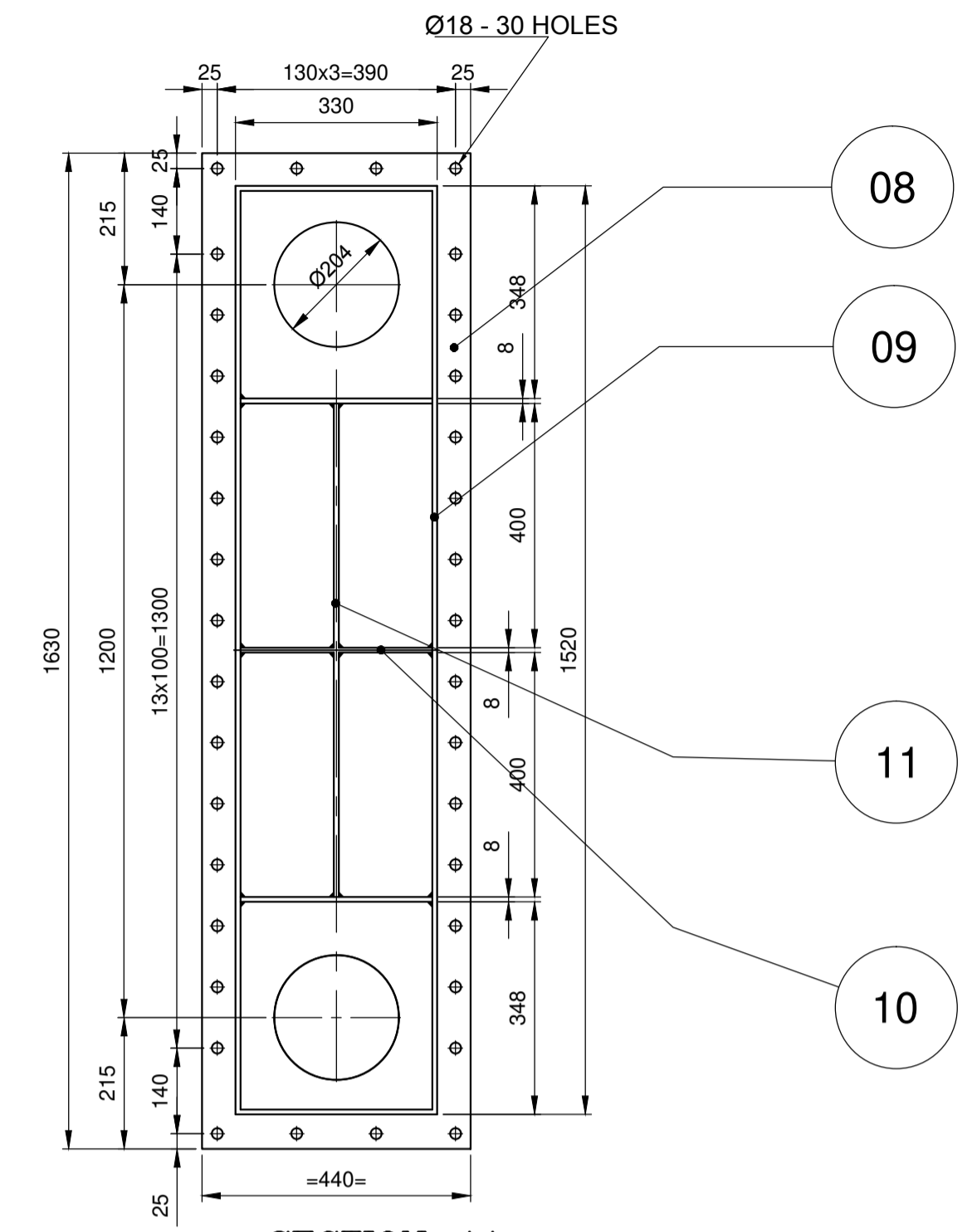
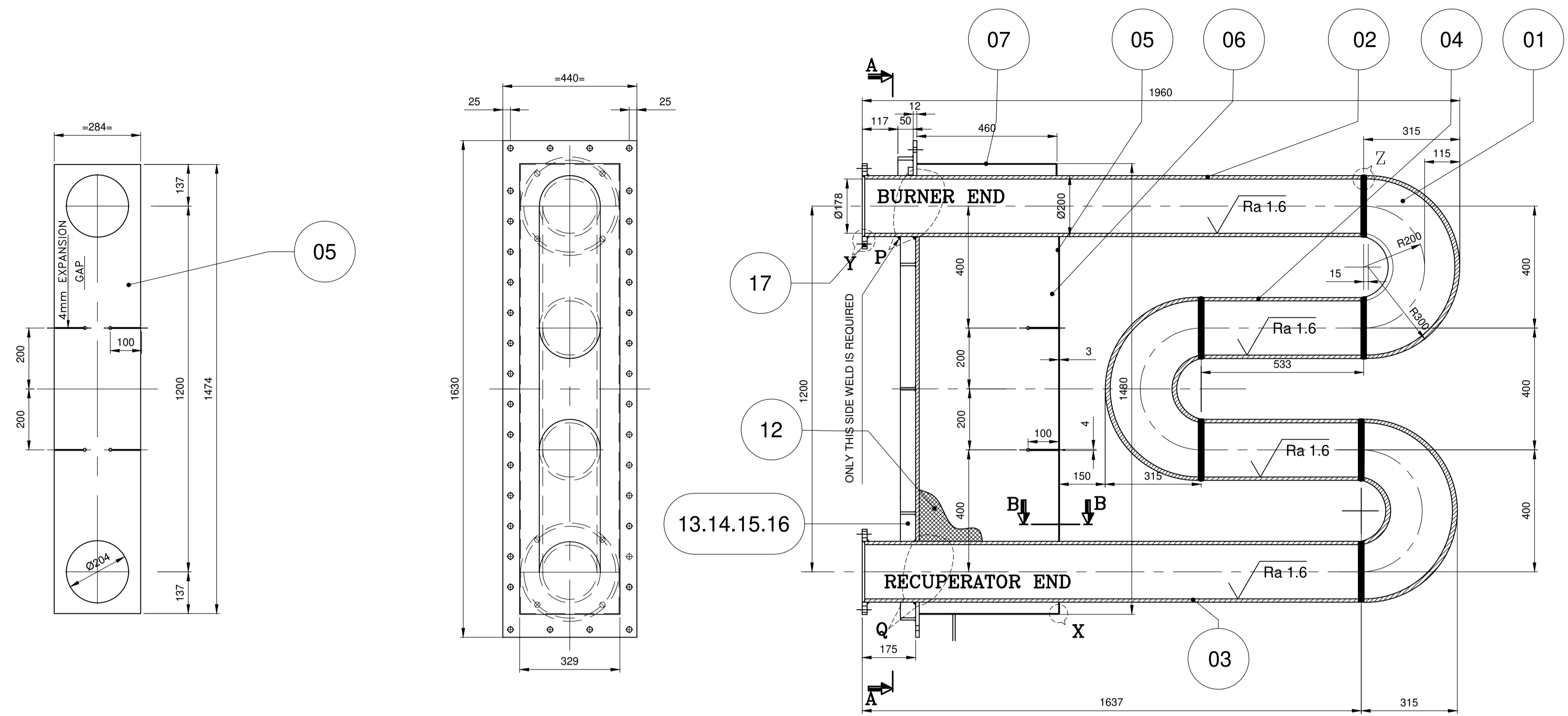


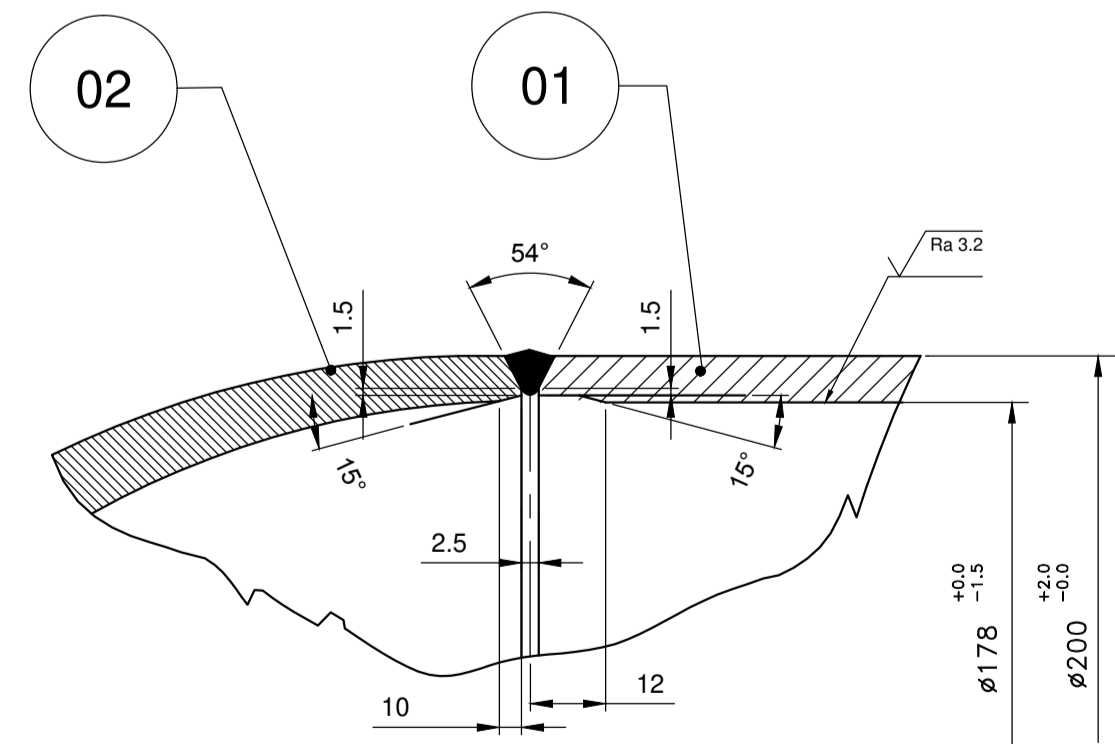
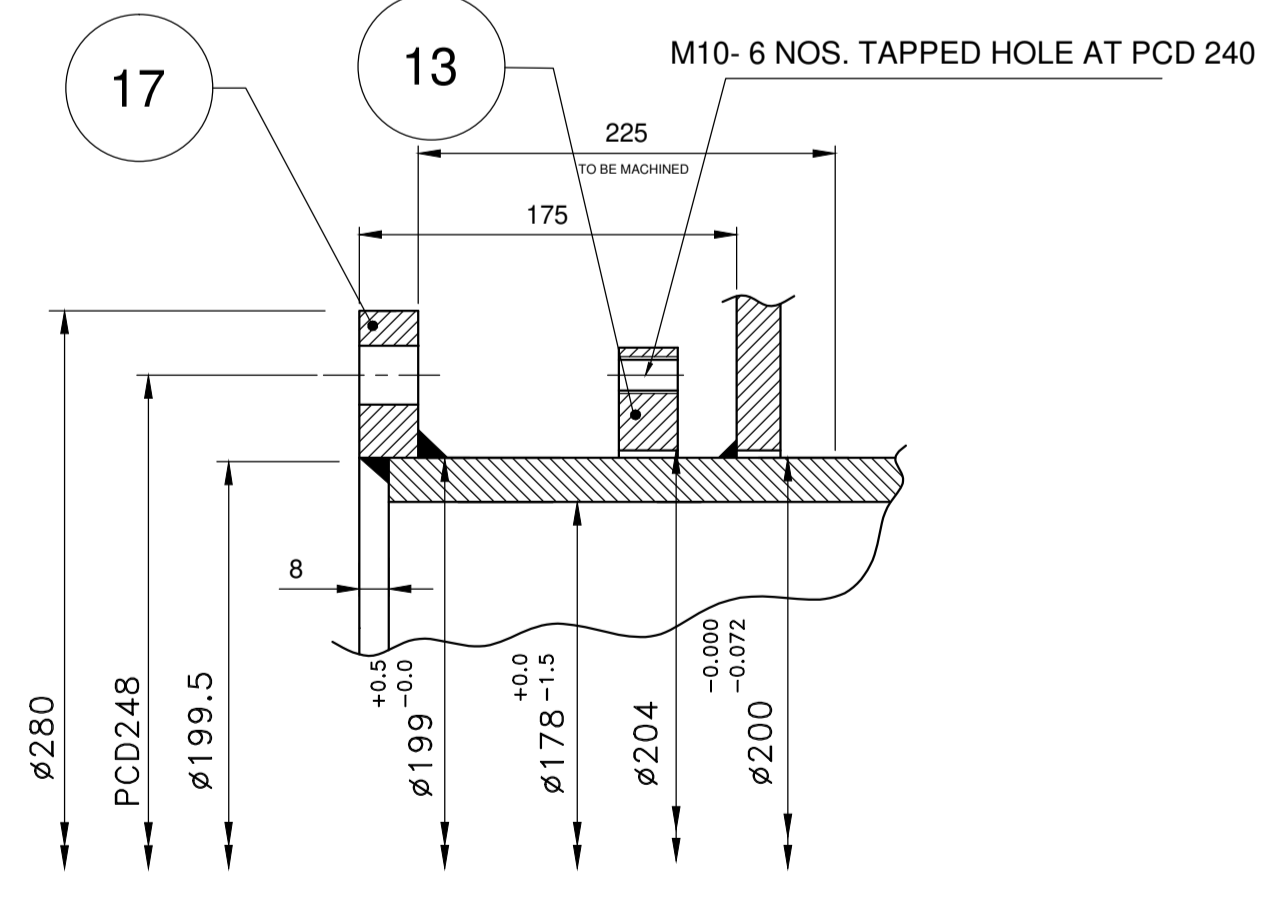
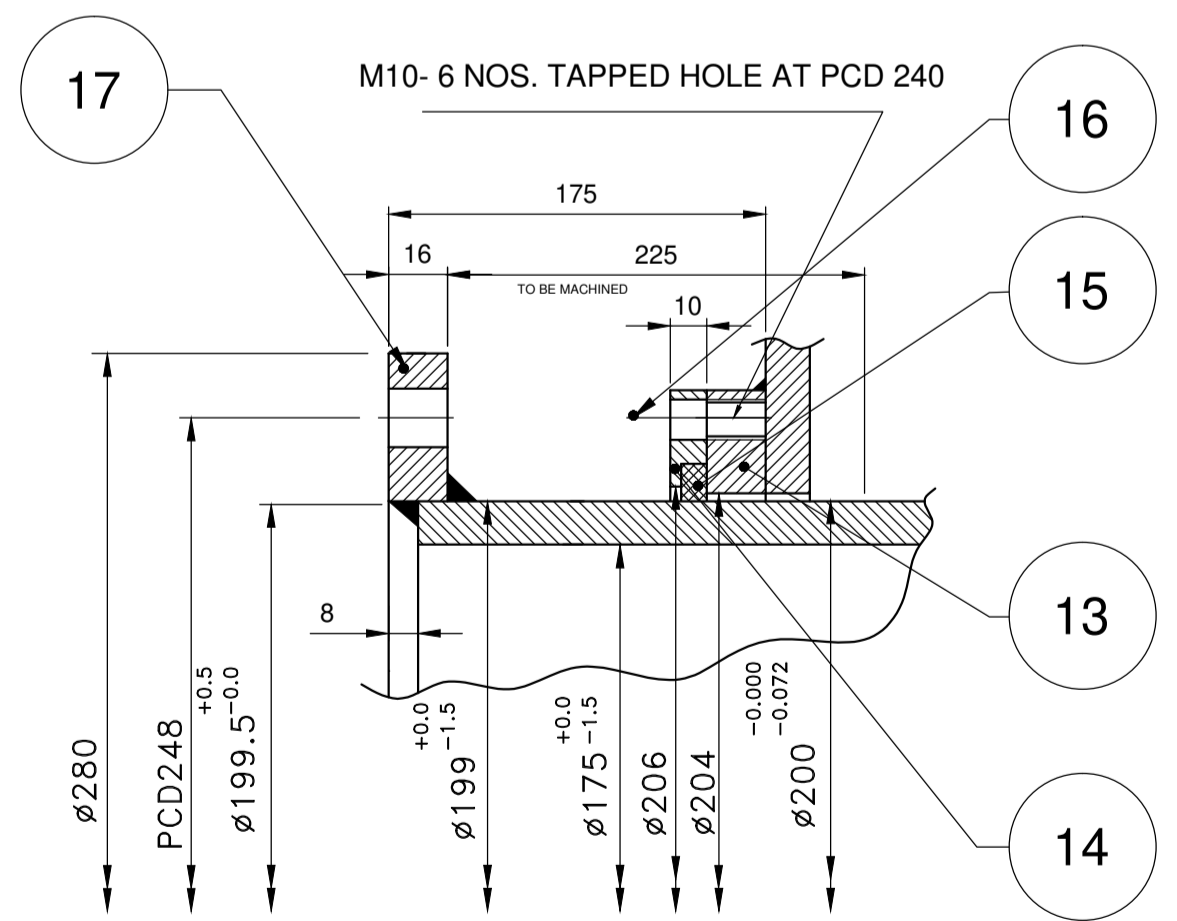
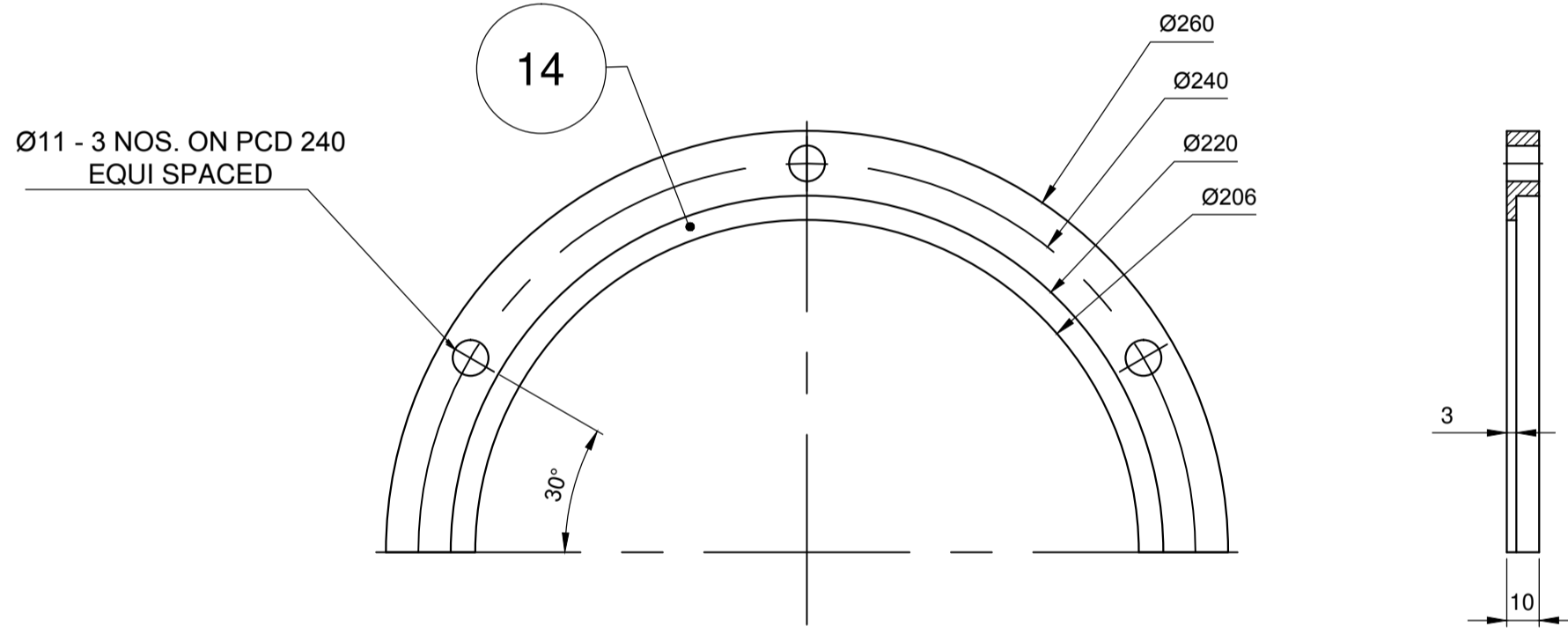
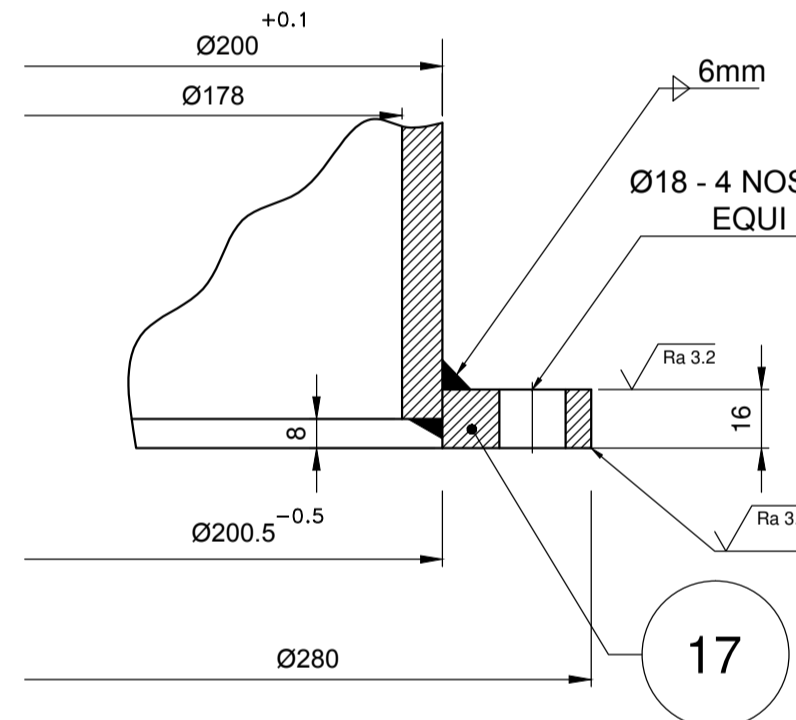
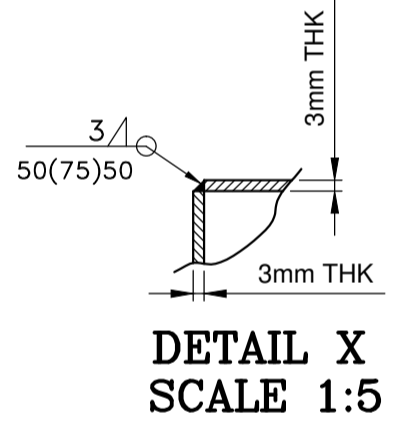
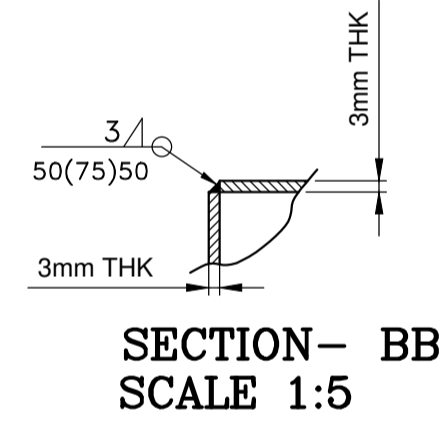
~ (Ra 1.6) ~ (Ra 3.2)



- NOTES:
1. ALL WELDS TO BE OF GAS TIGHT CONSTRUCTION.
 2. FLANGES OF BOTH THE TUBES TO BE IN THE SAME PLANE MAX. DEVIATION 0.5mm.
 3. ALL WELDS TO BE IN DESCALED CONDITION.
 4. CENTRIFUGALLY CAST PIPE (IT-1) & STATICALLY CAST BEND (IT-2) TO BE FREE FROM SURFACE DEFECTS SUCH AS BLOW HOLES, & SAND INTRUSIONS, ID OF PIPE TO BE M/C.
 5. ASSEMBLY SHALL BE PNEUMATICALLY TESTED AT 5 kg/cm² PRESSURE UNDER WATER.
 6. WELDING SHALL BE BY TIG WITH THERMITE 25/35 R
 7. WELDMENT SHALL BE TESTED WITH BOROSCOPIC EXAMINATION

CHEMICAL COMPOSITION OF MATERIAL: N28/48W DIN G NiCr28W
C 0.5 Si 1.5 Mn 1.3 Cr 28 Ni 48 W 5

ITEM NO	DESCRIPTION	DRAWING NO	MATL CODE	UNIT WT	QTY
17	PL.16 OD280 ID200.5		SS AISI310	2	3.8
16	HEX SCREW M10x20		P8.8 IS:1364	6	0.023
15	SEAL(BRAIDED) ID202xOD222X10SQ		ASBESTOS	1	
14	FLANGE OD260XID206x10MM THICK		SS AISI 304	2	1.39
13	PAD PLATE OD260xID204x16MM THICK		SS AISI 304	2	4.46
12	CERAMIC FIBRE1480x290x25MM THK TEMP 1260°C		DENSITY128 kg/m ³		
11	FLAT 50x8THKx400 LONG IS:1730		E250A IS:2062	2	1.13
10	FLAT 50x8THKx314 LONG IS:1730		E250A IS:2062	5	0.9
09	FLAT 50x8THKx1520 LONG IS:1730		E250A IS:2062	2	4.54
08	PL1630x440x12 THK IS:1730		E250A IS:2062	1	67.6
07	PL 457x284x3 THK IS:1730		SS AISI304	2	15.0
06	PL 1474x457x3 THK IS:1730		SS AISI304	2	9.4
05	PL 1474x284x3 THK IS:1730		SS AISI310	1	27.0
04	TUBE OD200 ID178x533LONG		DIN G NiCr28W N28/48W	2	84.0
03	RECUPERATOR END TUBE OD200 ID178x1637 LONG		DIN G NiCr28W N28/48W	1	84.0
02	BURNER END TUBE OD200 ID178x1637LONG		DIN G NiCr28W N28/48W	1	84.0
01	180° BEND OD200 ID178		DIN G NiCr28W N28/48W	3	45.0



REV	DATE	ALTERED	BY	DATE	ALTERED	BY
01	30.4.15	CHECKED	R.K. Singh	1-10-14	CHECKED	R.K. Singh
		APPROVED	S. Loganathan		APPROVED	S. Loganathan

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Bharat Heavy Electricals Ltd
SEAMLESS STEEL TUBE PLANT
TIRUCHIRAPALLI - 620014

DRN	S.S.N.KUMAR/ A.S	SIGNATURE	S.S.N.Kumar/ A.S	DATE	22.08.14
CHD	R.K.SINGH	SIGNATURE	R.K. Singh	DATE	22.08.14
APPD	G.LOGANATHAN	SIGNATURE	G. Loganathan	DATE	22.08.14

DEPT: SSTP GRADE OF UNTOL DIM SCALE WEIGHT (Kg) REF TO ASSY DWG NO -
456 C/M/F 1:10,1.5,1.4 467 REF TO OLD DWG NO -

TITLE: **TEM - RADIANT TUBE ASSY.** DRAWING NO: **1-7-0129-07-01753**

DESIGN-II SOAKING ZONE GAS/OIL FIRING-NORM CON

MISSING DIMENSIONS ADDED

NEW BORDER INSERTED