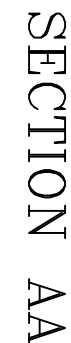


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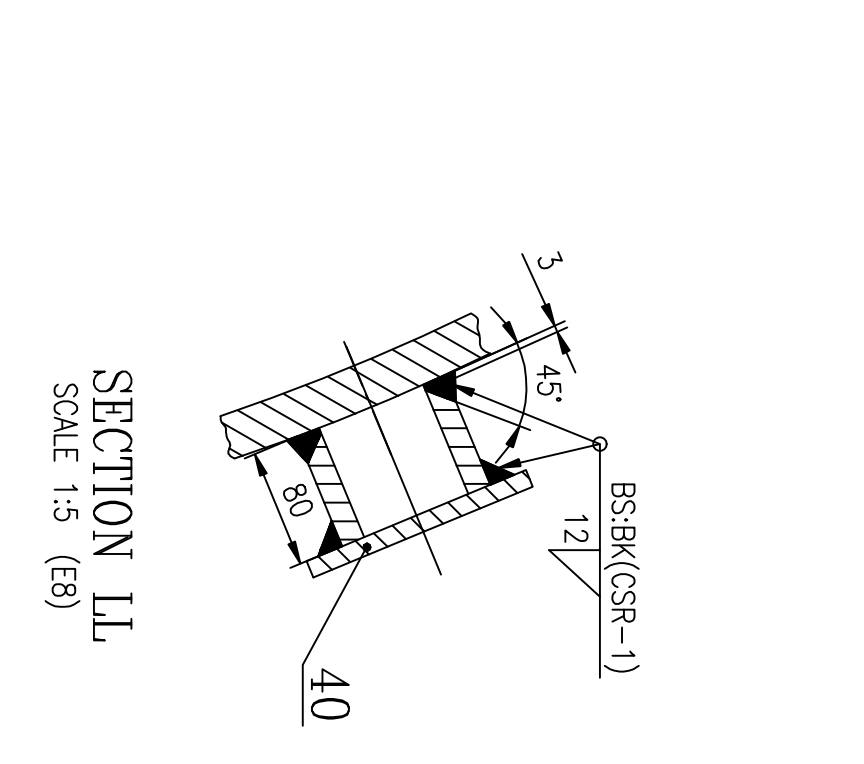
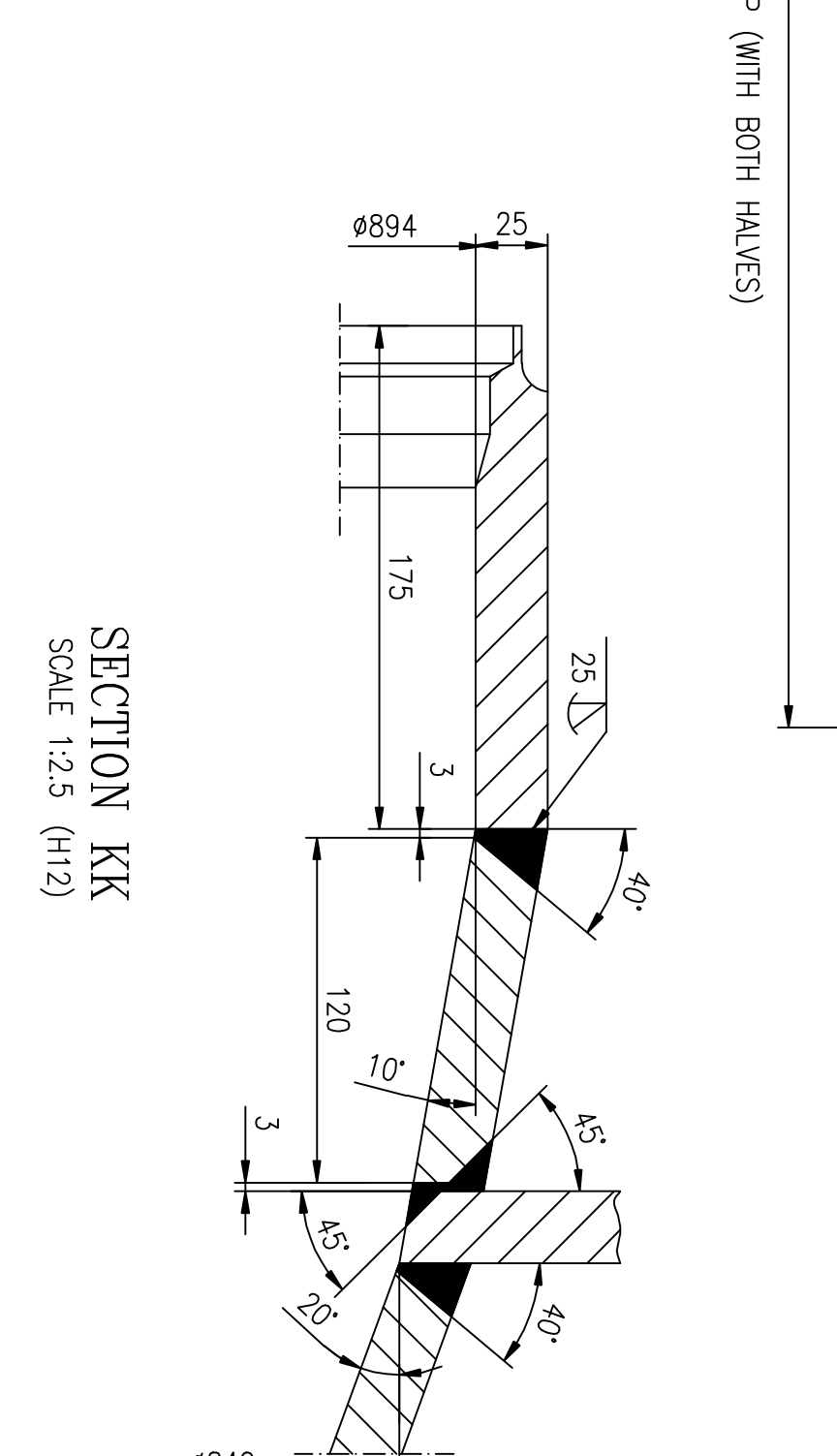
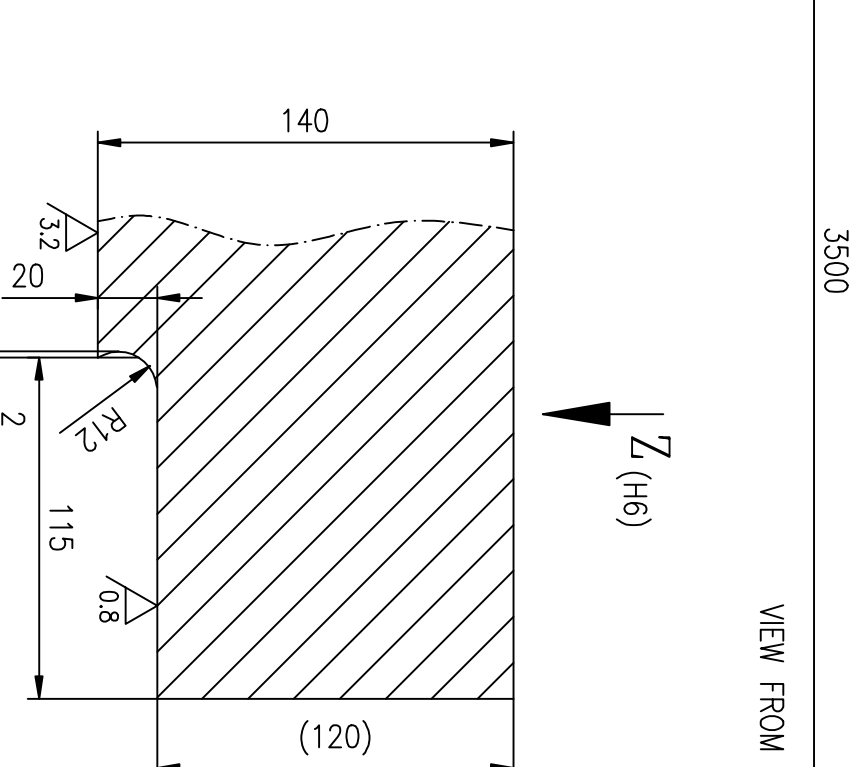
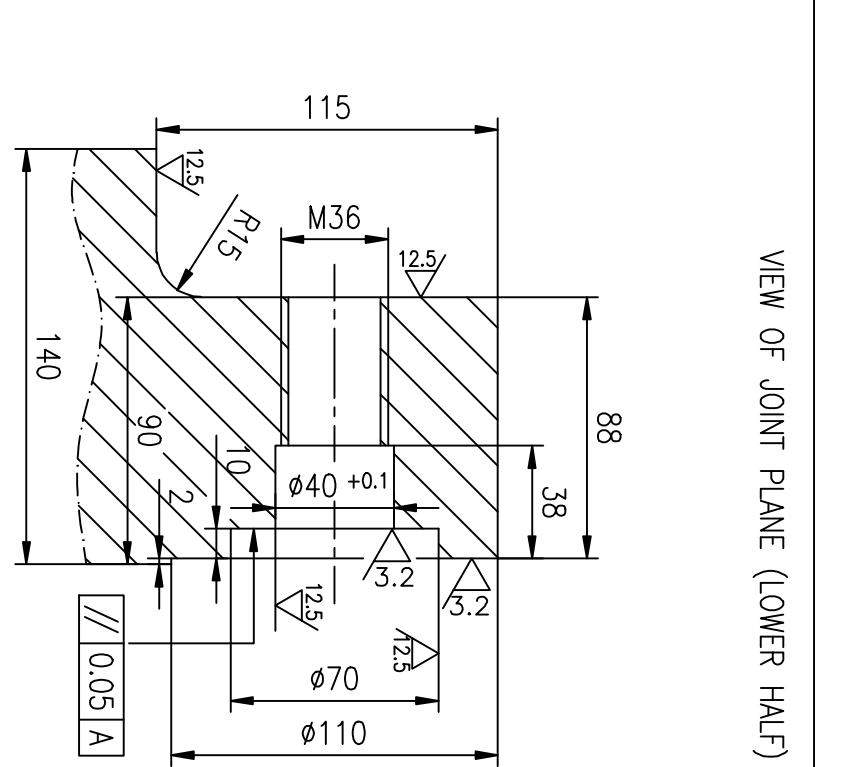
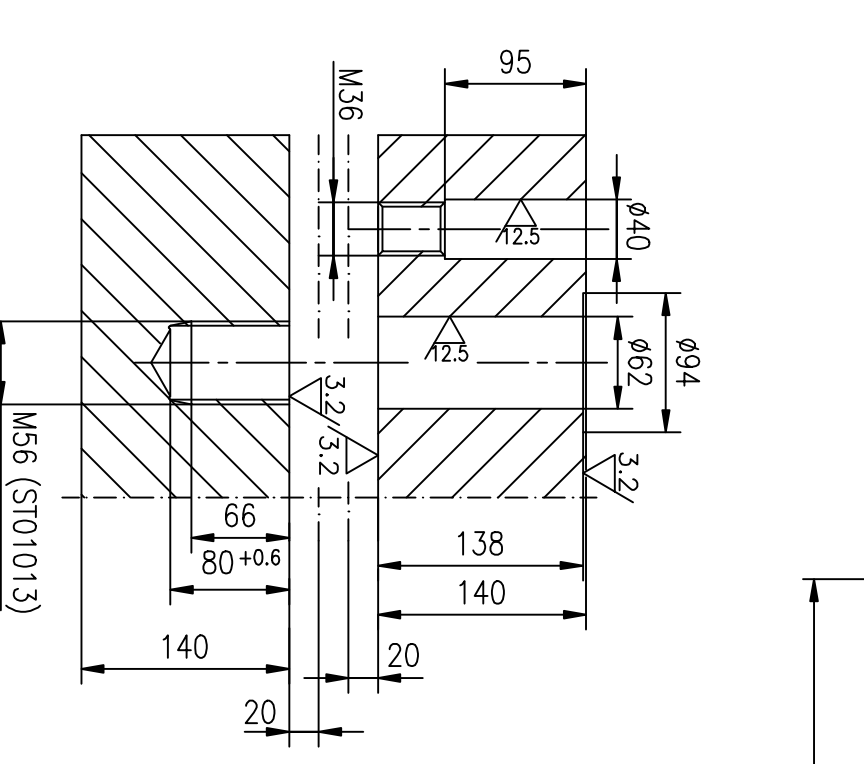
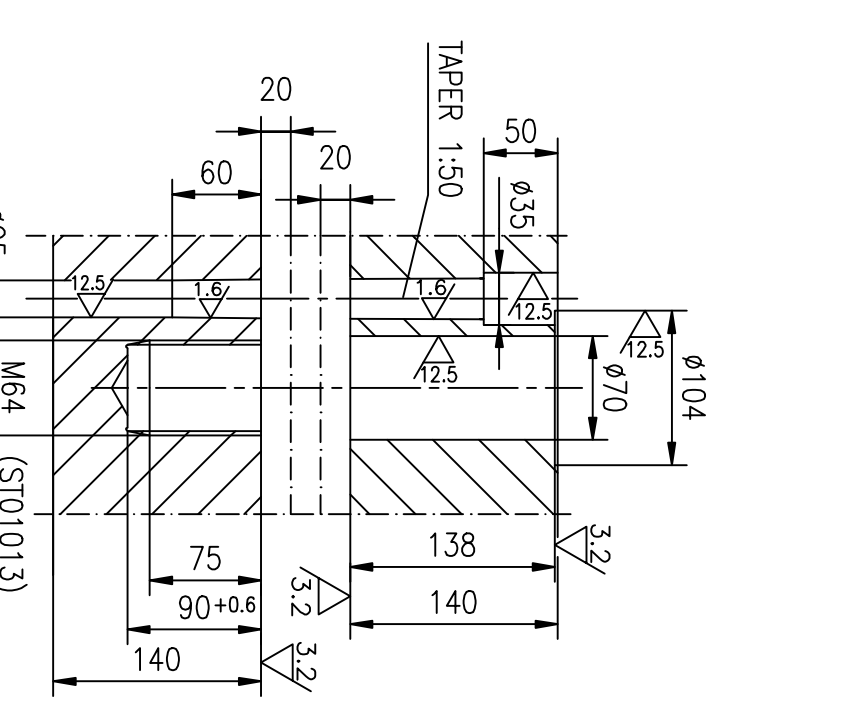
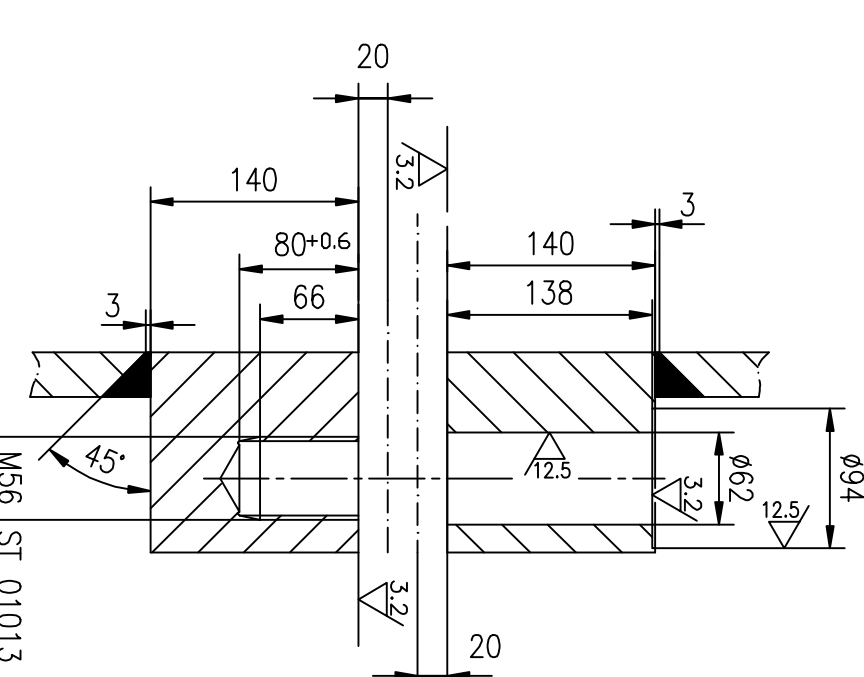
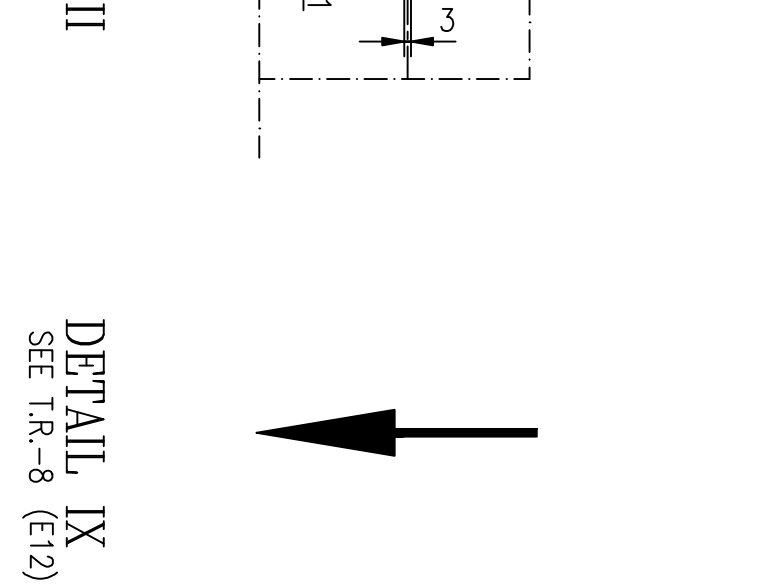
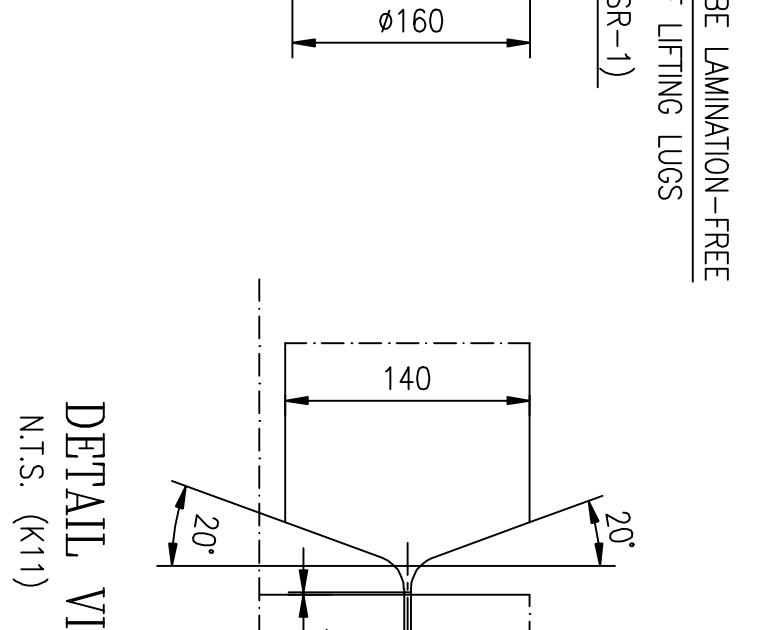
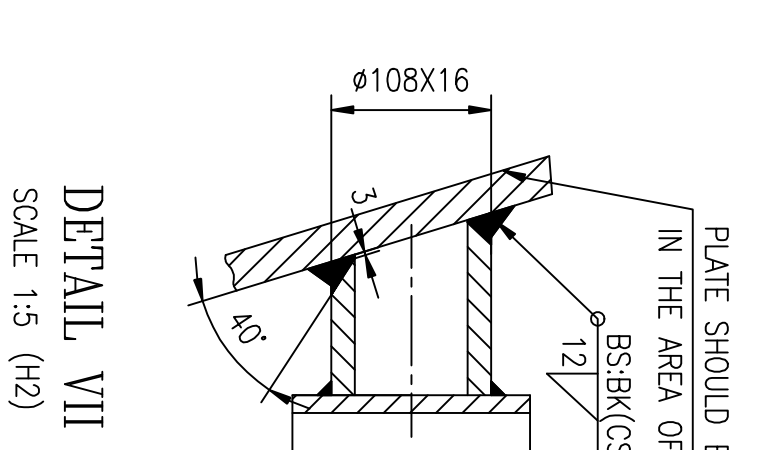
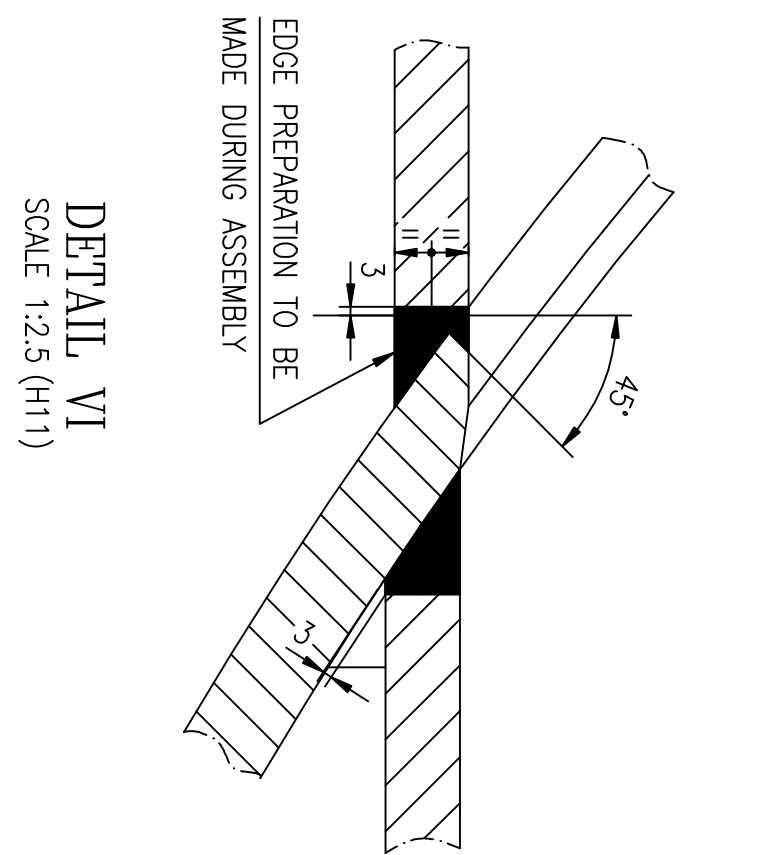
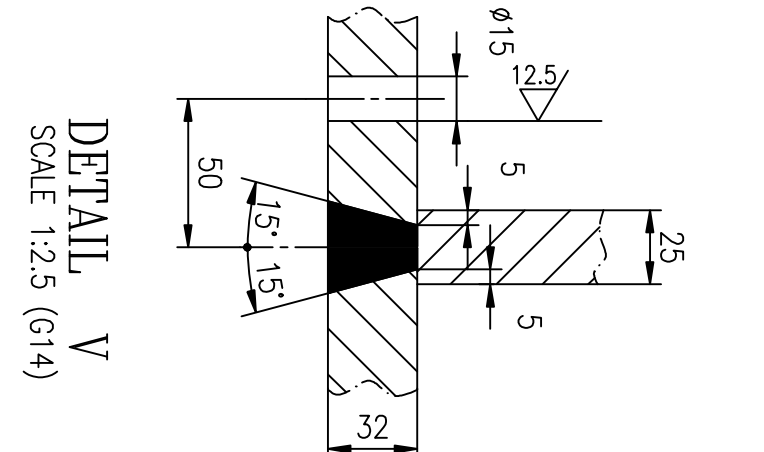
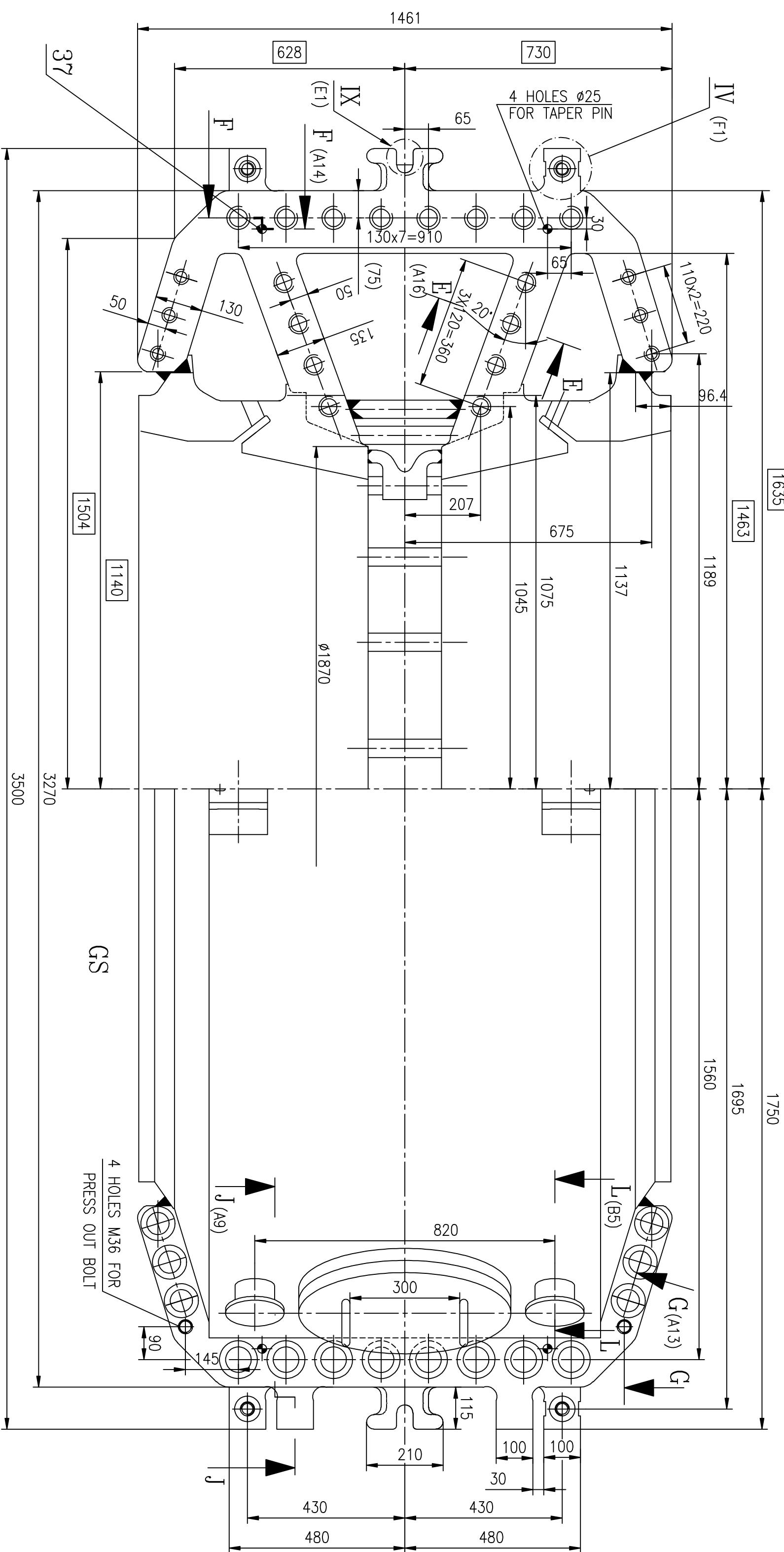
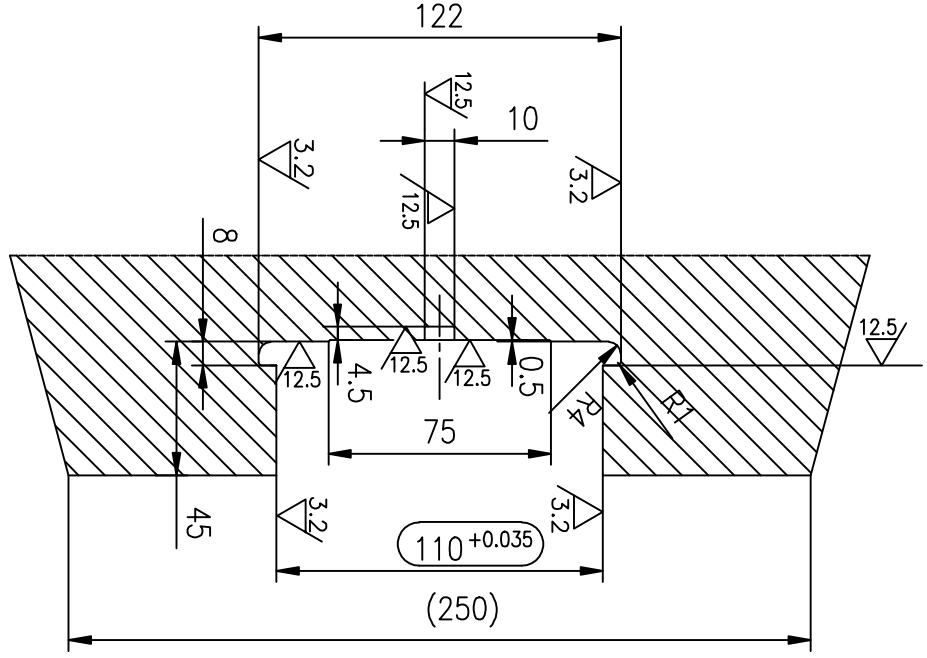
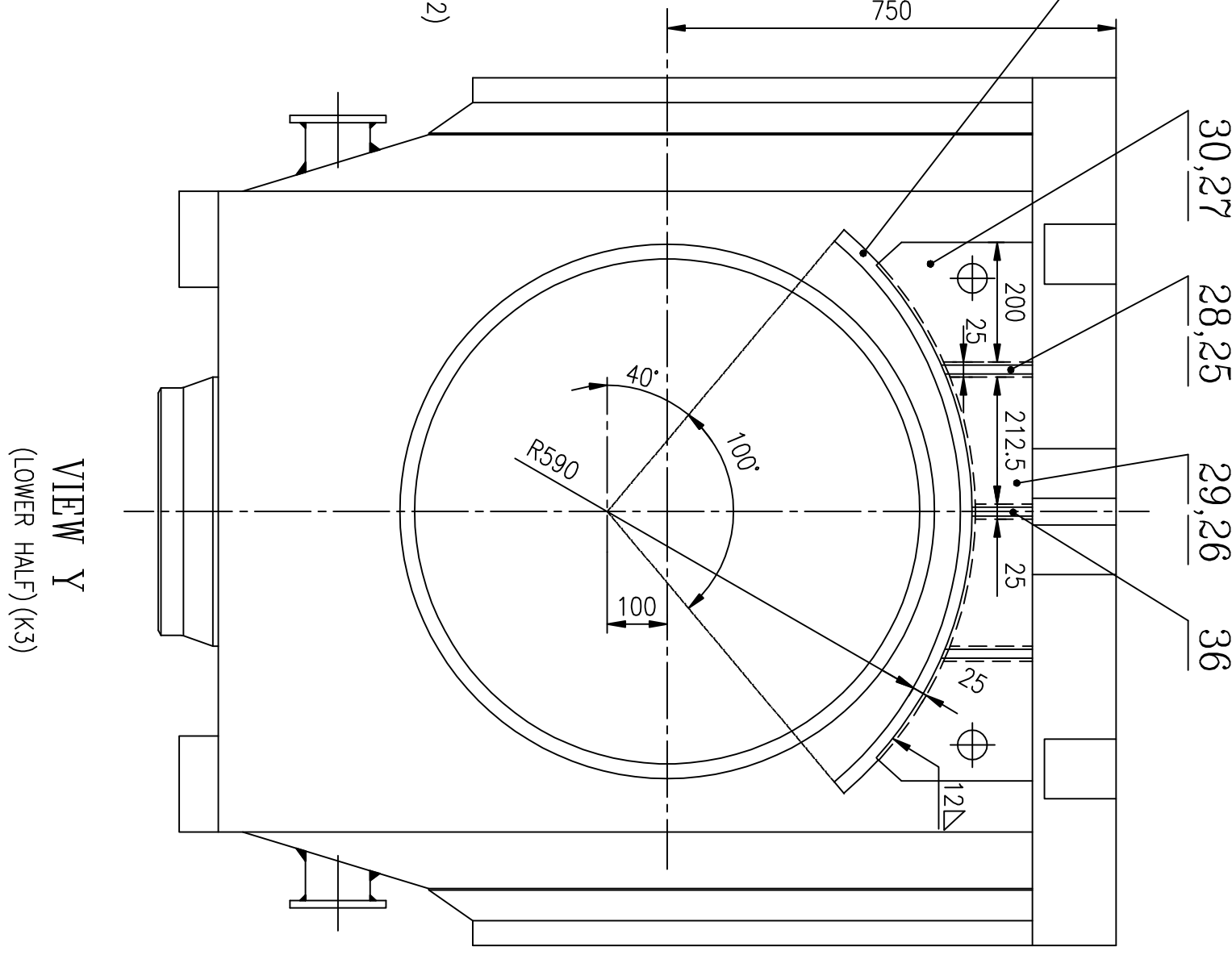
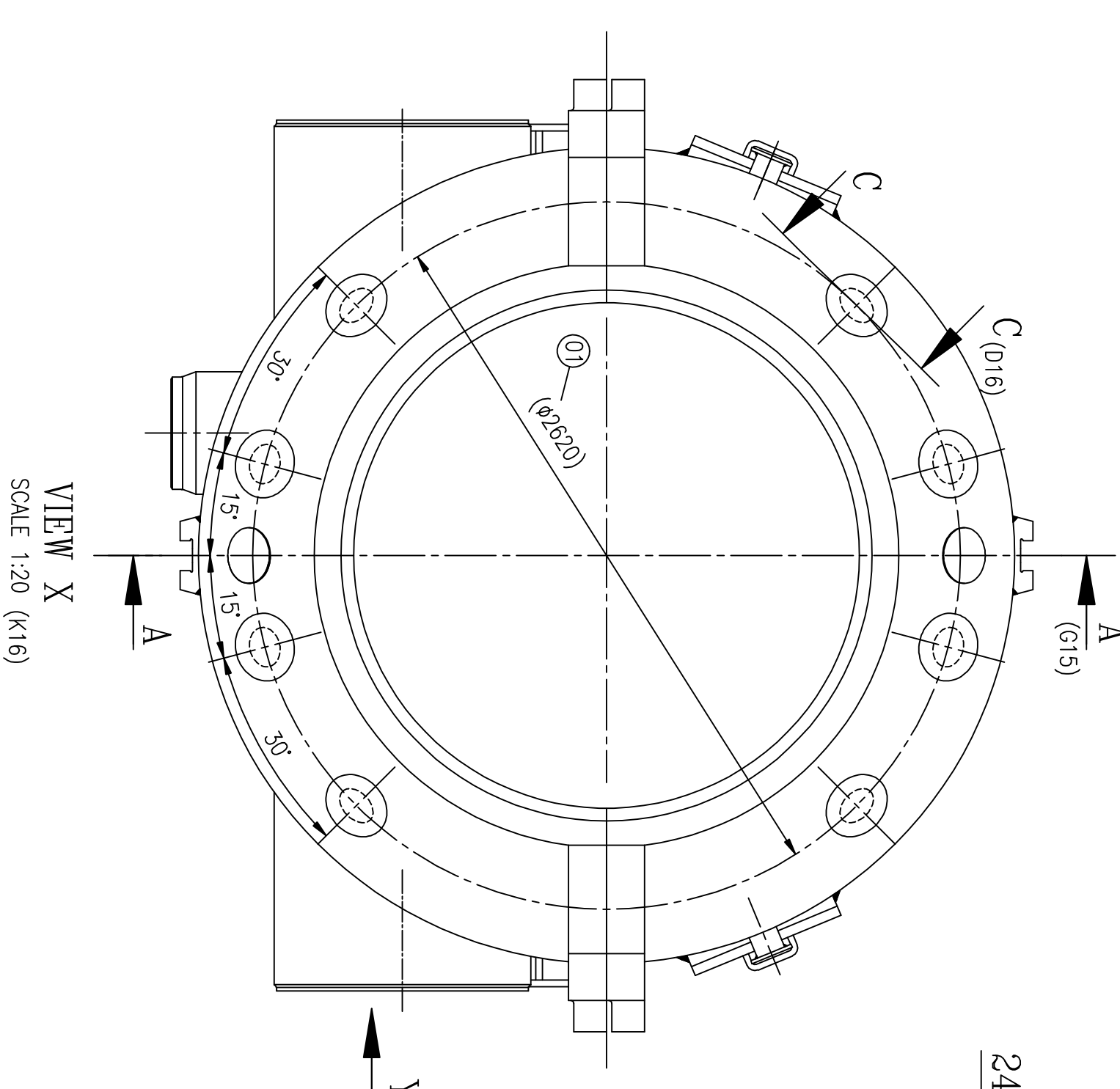
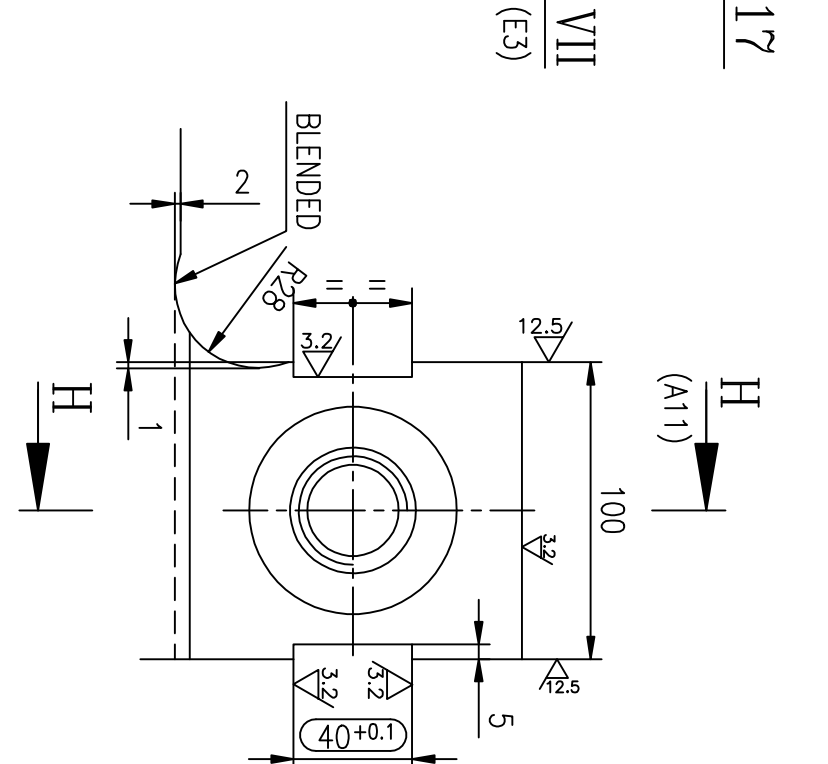
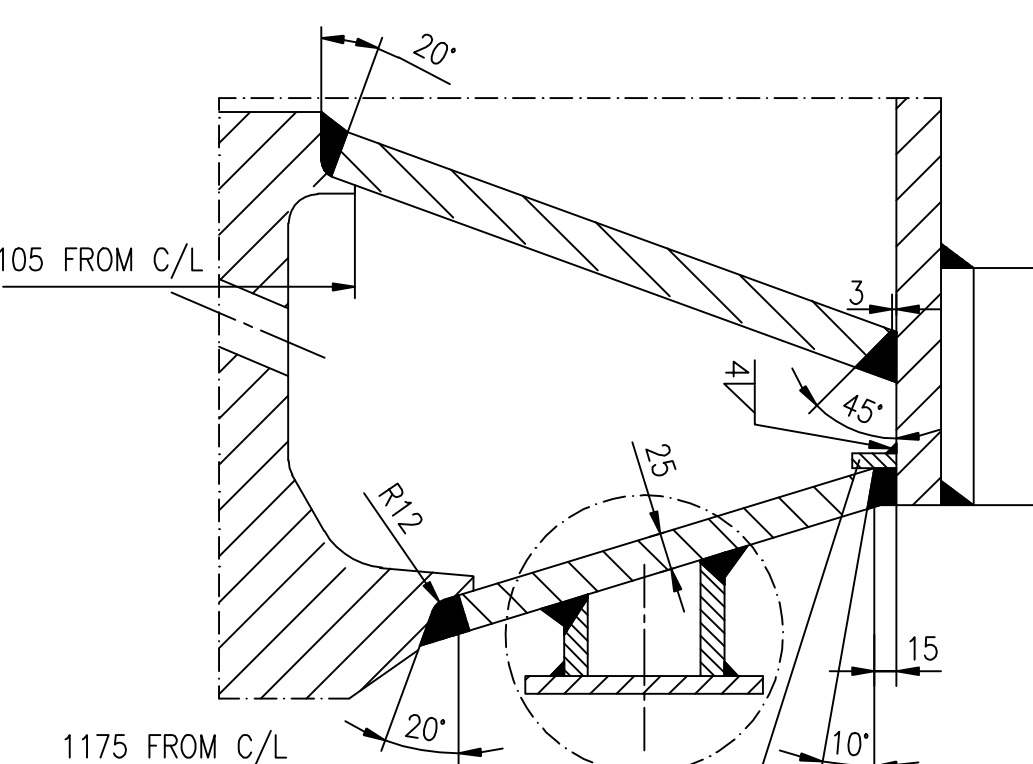
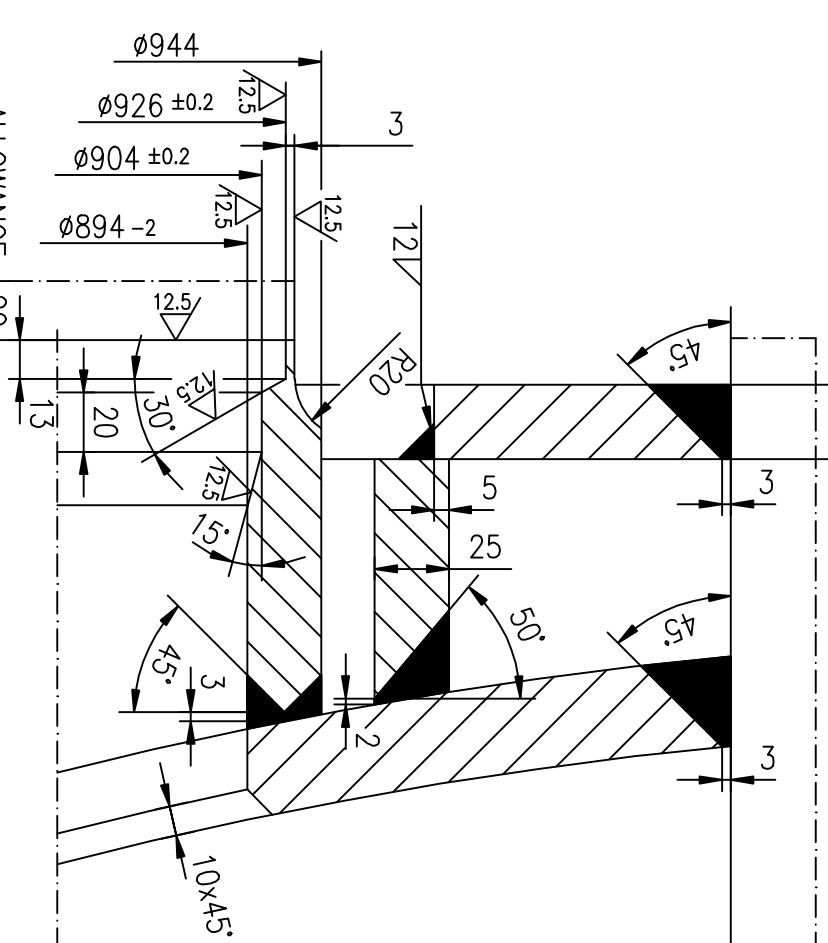
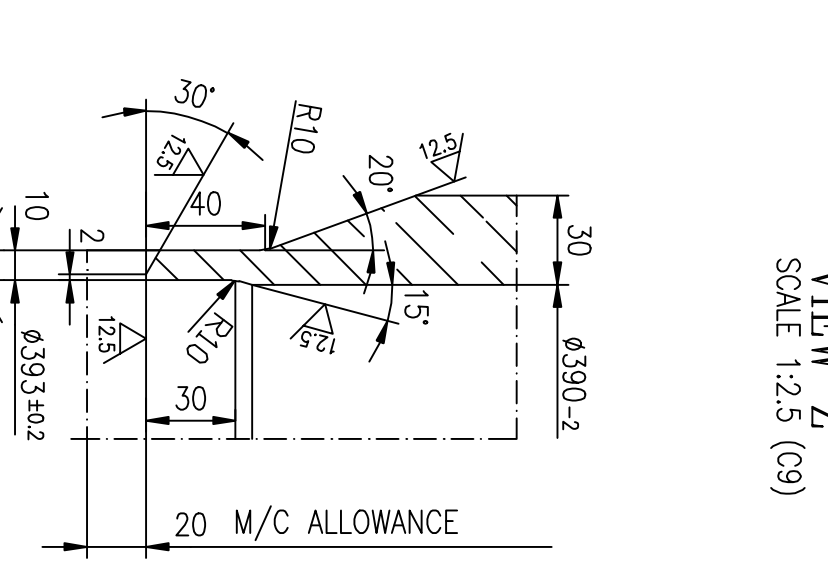
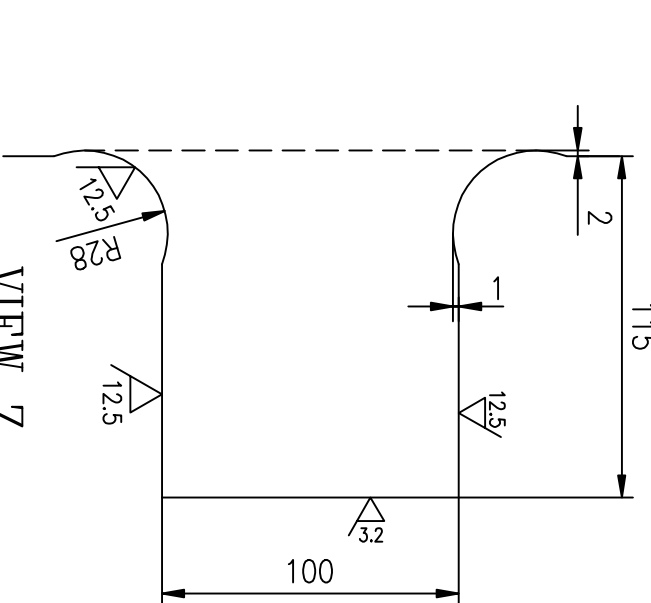
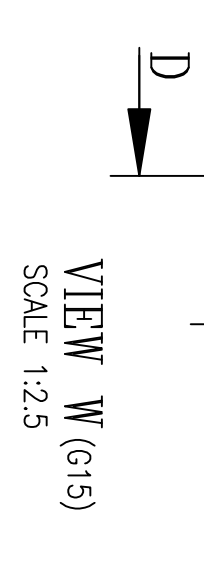
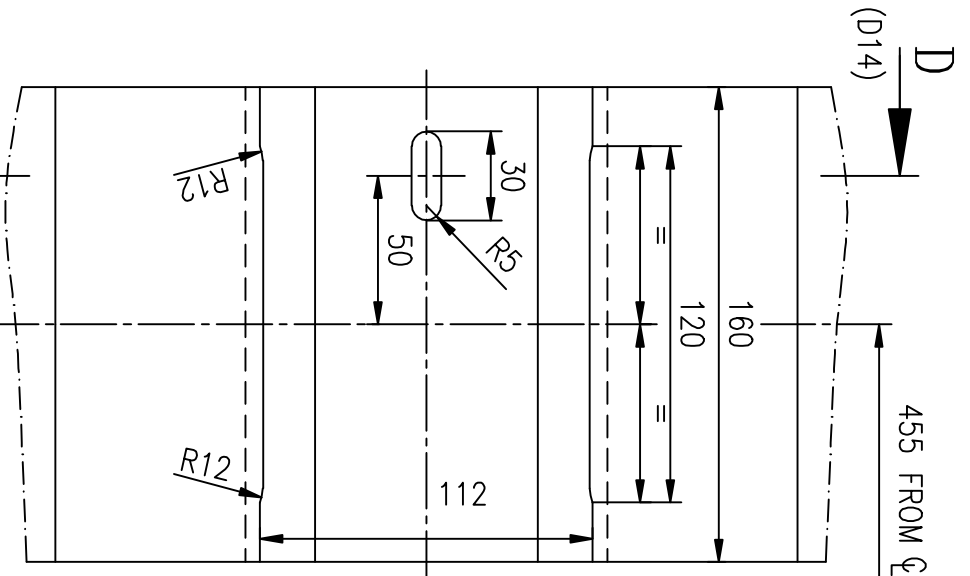
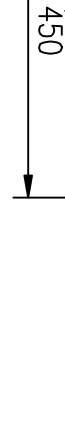
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DRAWING No.

DRAWING No.



TECHNICAL REQUIREMENTS :

1. ALL CORNER JOINT WELDS ARE WELDED FULL.
2. ALL UNSUPPORTED FLUET SHEET STEMS ARE OF R.N.
3. WELD CLASSIFICATION GROUPS CS, CX (WH/OUTI OPEN ROOT DEFECT).
4. BE SHALL BE ACC. TO HW 062009, 100% PRT OF WELD FOR ITEM NOS.33 AND 34.
5. TEST SCOP SHALL CONFORM TO HW 080139 WITH CSR 30.1.
6. LP INNER COUSING SHALL BE STRESS RELEASED ACCORDING TO HW 041109.
6. ----- REPRESENTS DIMENSIONS TO BE CONTROLLED BEFORE ASSEMBLY.
7. DIMENSIONS FOR SIGHT DIMENSIONS SHALL BE ACCORDING TO HW 061003.
7. DIMENSIONS WITH ----- ARE CRITICAL TO QUALITY (C/O).
8. HANGERS/SE CENTER END SHALL BE WELD PLACED AS PER DETAIL EX.
9. ----- FOR THE THROUGS TO GO AS PER SPT 380.4 EXCEPT OTHERWISE MENTIONED ON THE DRAWING.
10. AFTER ALTERNATE ROOT TIGHTENING THE FEELER OF 0.03 SHOULD NOT GO THROUGH AND THROUGH.
11. INSERTION PIECE ITEM NO.28 TO BE WELDED TO RING FLANGES ITEM NO.31 AFTER CLEANING THE EXTRACTION CHAMBER DURING ASSEMBLY IN SHOP.
12. IDENTIFICATION SHOULD BE ACC. TO HW 040039 AT THE PLACE INDICATED WITH IN 

INVENTORY No.	SIGN & DATE	STE-TD-169-L REF.DRAWING No.
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SECTION EE
(100% MAX)
SCALE: 1/5 (1:1)

[illegible]

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DATE	TIME	STATUS
0-10742-19000		OK
WT	VAKUMAR	SAF - 05/11/08
SIT	VBMNSAL	SAF - 07/11/08
REV	DATE	ALTERED
CHECKED		

TYPE OF PRODUCT		STEAM TURBINE	
OR			
NAME OF CUSTOMER/PROJECT			
 BHARAT HEAVY ELECTRICALS LTD. RAIPUR, HARYANA			
DEPT	SITE	SCALE	WEIGHT (KG)
CODE	4011	1:10	(16/20)
			
TITLE :		DRAWING NO.	
LP INNER INNER CASING		CARD	
(300-266.5 WITH ADVANCE BUILDING)		0-1-10742-19000	
22 10742-19000		22 10742-19000	