

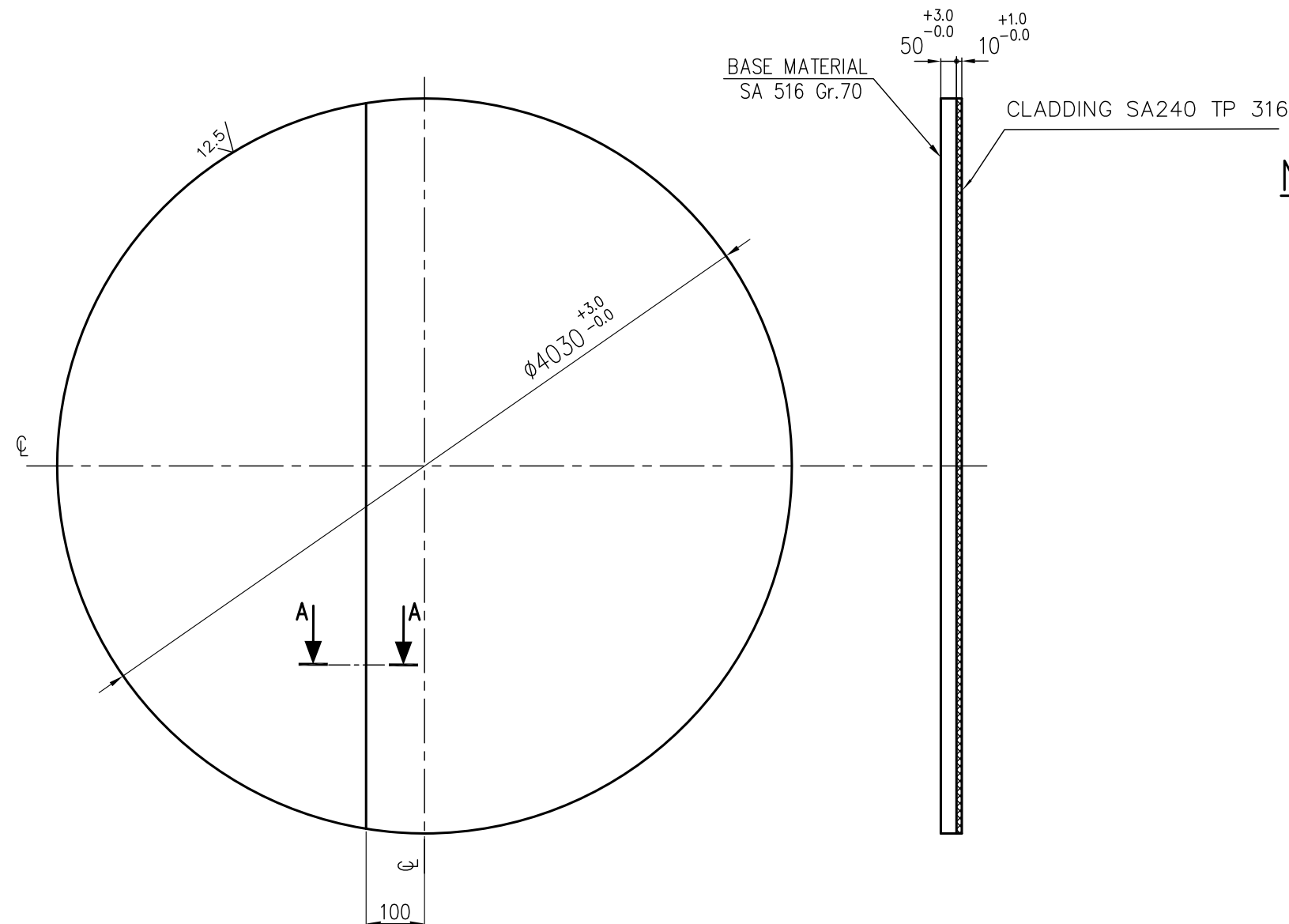
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DRG. NO. 3-160-10-02420

FIRST ANGLE PROJECTION

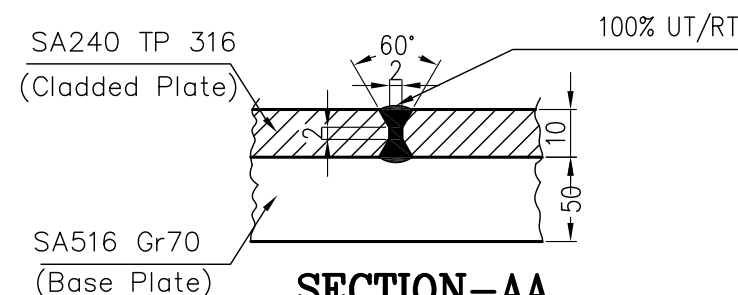
(ALL DIMENSIONS ARE IN mm)

12.5/



NOTE :-

1. MATERIAL:-
 - a) BASE MATERIAL SHALL BE AS PER SA 516 Gr.70 OF ASME SEC.II PART-'A' 2010 UP TO AND INCLUD. ADDENDA 2011
 - b) CLADDED MATERIAL SHALL BE AS PER SA 240 TP 316 OF ASME SEC.II PART 'A' 2010 UP TO AND INCLUD.ADDENDA 2011
2. CLADDING SHALL BE INTEGRALLY AND CONTINUEOUSLY BONDED TO THE BASE MATL. AND CLADDING REQUIRED ON ONE SIDE ONLY.
3. BOND BETWEEN CLADDING AND THE BASE METAL SHALL BE CHECKED FOR A MINIMUM STRENGTH OF 14 kgf/sq.mm IN SHEAR BY CONDUCTING SHEAR TEST.
4. CLAD PLATE SHALL BE ULTRASONICALLY EXAMINED FROM THE CLAD SURFACE AS PER SA 578. SCANNING SHALL BE 100 % OF THE PLATE SURFACE. ACCEPTANCE STD. SHALL BE LEVEL - C. CLAD PLATE SHALL MEET THE SUPPLIMENTARY RQUIREMENTS S7 OF SA 578.
5. BASE MATERIAL C.S.PLATE TO BE SUPPLIED IN NORMALISED CONDITION AND THE CARBON CONTENT SHALL NOT BE GREATER THAN 0.25 %.
6. FLATNESS ON THE CLADDED SURFACE SHOULD BE LIMITED TO 1 mm PER METER AND MAXIMUM OF 3.5 mm ON ENTIRE SURFACE OF TUBE PLATE.
7. THE CLADDED PLATE SHALL BE SUPPLIED IN HEAT TREATED CONDITION.
8. INSPECTION AND CERTIFICATION SHALL BE AS PER BY BHEL APPROVED TPIA
9. A WELD JOINT IS PERMITTED IN THE CLAD MATERIAL ONLY AS SHOWN IN SECTION-AA OF THE DRAWING.BASE MATERIAL SHALL BE FROM SINGLE PLATE.



SECTION-AA

- UTMOST CARE TO BE TAKEN TO AVOID THE POINT OF IGNITION AT THE WELD JOINT LOCATION.

TYPE OF PRODUCT
OR
NAME OF CUSTOMER/PROJECT

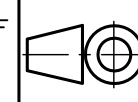
BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

DRN.	VS RAO	SIGN.	VS RAO	DATE	NO.OF
CHD.	LKM	LKM		28.08.13	VAR.
APPD	M.VENKAT			28.08.13	NA

REV.	DATE	ALTERED	CHECKED	APPD
ZONE				

DEPT.
HEE
CODE 405

GRADE OF
TOL.DIM.
C/M/F



SCALE
NTS

WEIGHT (KG)
6027

REF. TO ASSY DRG.
NA

ITEM
NO.
NA

NO.OF
ITEMS
NA

TITLE

SS CLADDED TUBE PLATE

CARD
CODE

DRAWING NO.
3-160-10-02420

REV.
00

SHEET No. 1 NO OF SHEETS 1