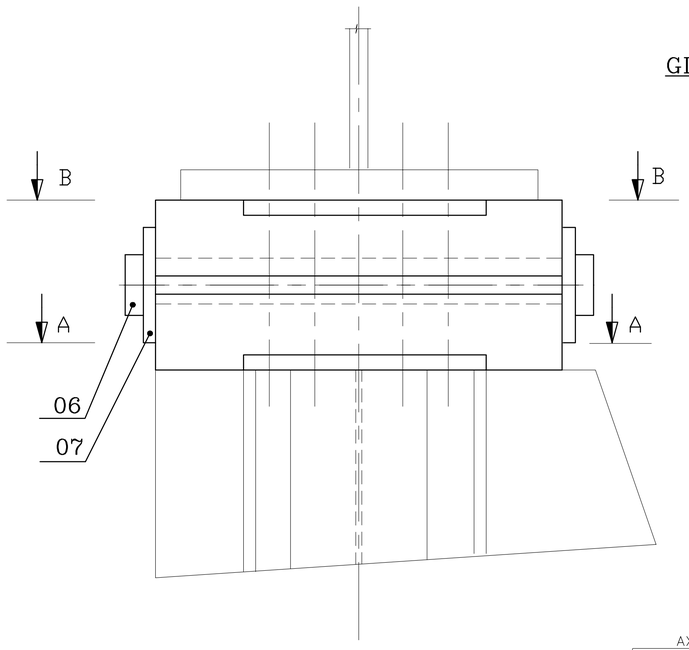
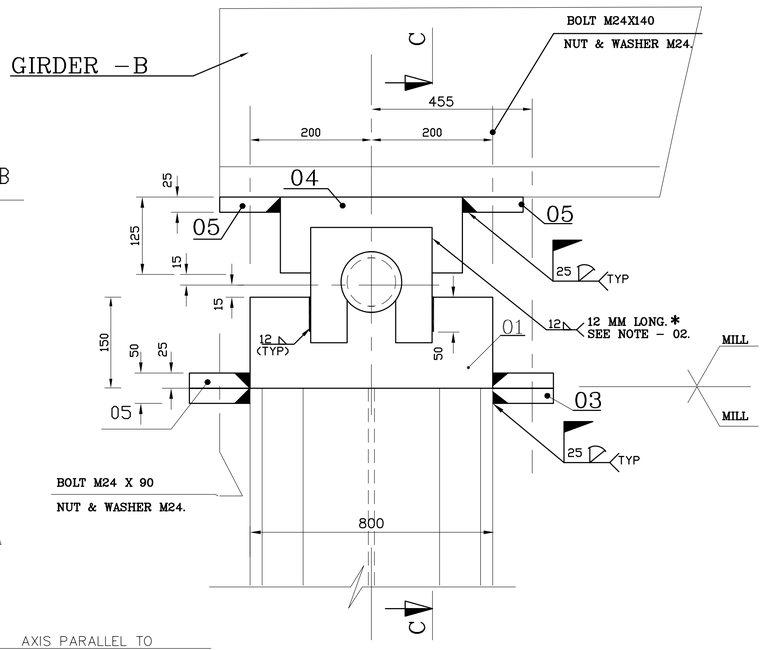
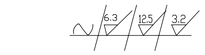
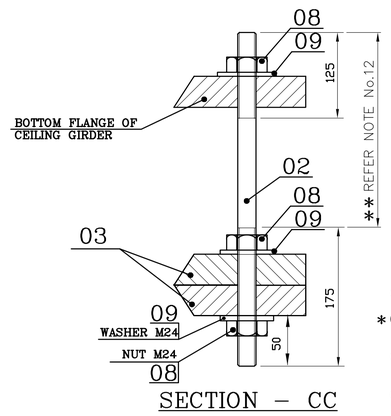
DRAWING NO: 1-35-190-04840

FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER PLANT STD. NO TP 023 0299









SECTION – CC

SIZE AND TYPE OF WELD	TYPE OF ELECTRODE	TOTAL LENGTH OF WELDING
12 ◺	E 7018	1.50
25 ▷ ◤	E 7018	10.25

REQUIREMENT OF FASTENERS

DESCRIPTION	MATL.CODE	QTY	RELESED UNDER PGMA
HSFG BOLT WITH NUT M24X140	41240–24140	16	35–700
HSFG BOLT WITH NUT M24X90	41240–24090	8	35–700
WASHER HSS A24	41418–00024	48	35–700

NOTES

01 FOR GIRDER DETAILS REFER GIRDER DRG IN PG 35–211.

*02 REMOVE THIS WELD AFTER THE GIRDER HAS BEEN ERECTED AND BOLTED IN PLACE.

03 LUBRICATED PIN SEATS BEFORE INSTALLATION (USE ONLY MOLYBDINUM DI–SULPHIDE GREASE – TO BE PROCURED BY ERECTOR.

04 THREADED ROD (ITEM NO:02) MUST BE INSTALLED FOR RESISTANCE TO OVER TURNING DUE TO WIND DURING ERECTION.

05 MATERIALS AND OTHER REQUIREMENTS ARE GIVEN FOR ONE ASSY.ONLY

06 ø26 HOLES TO BE DRILLED IN ITEM 03 & 05.

07 ITEM 06 TO BE MANUFACTURED AND FINISHED TO A:193 – B7. CHARACTERISTICS.

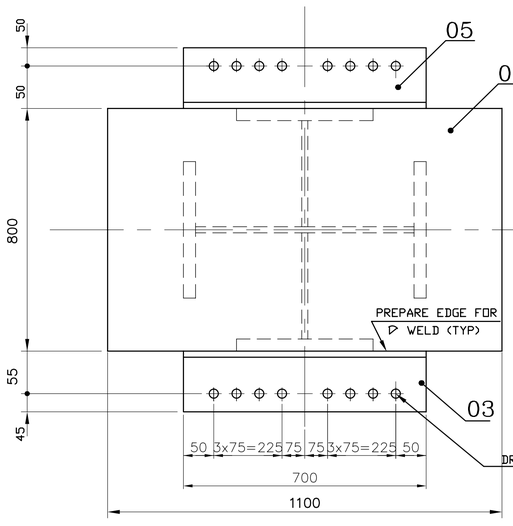
08 ITEMS 01,02,04 & 06 NEED NOT BE PAINTED.

09 PAINTING AREA – 5 SQ.M.

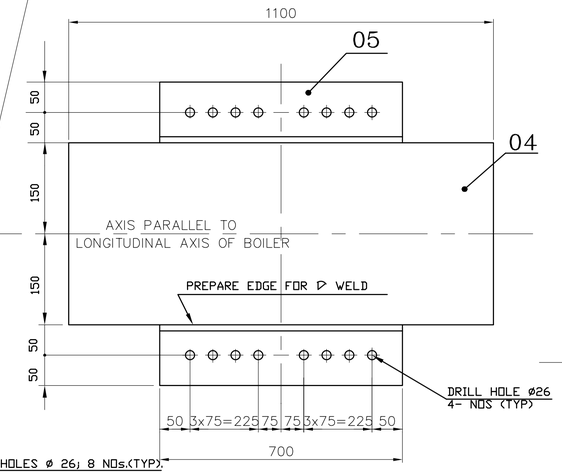
10 ITEMS 01,02,04 & 06 HAVE TO BE PROTECTED AGAINST RUST WITH AN APPLICATION OF A THIN FILM OF RUST PREVENTIVE OIL. THE THIN FILM OF OIL TO BE THROUGHLY WIPED OFF AT SITE BEFORE ERECTION.

11 MANUFACTURING REQUIREMENTS SHALL BE AS PER RELEVANT Q.C.P.

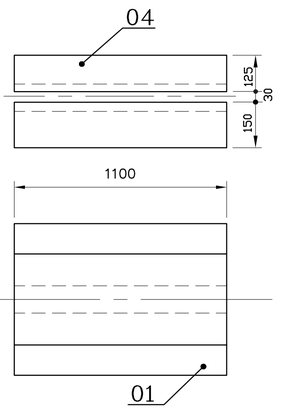
**12 THIS PORTION OF ROD IS TO BE CUT & REMOVED AFTER COMPLETE INSTALLATION OF CEILING STRUCTURE INCLUDING HORIZONTAL BRACING.

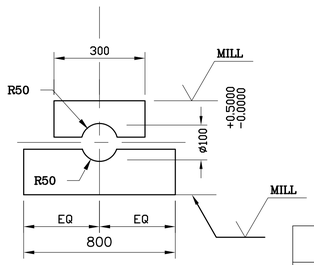


SECTION – AA

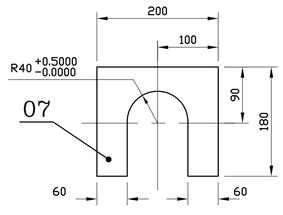


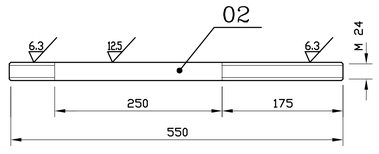
SECTION – BB

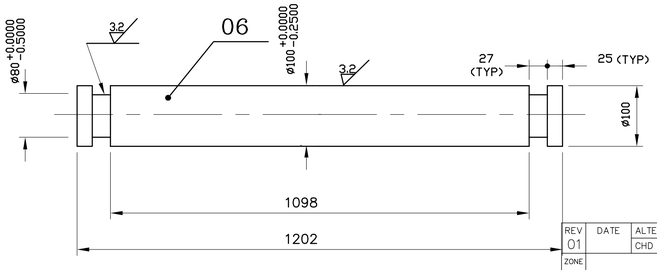




	09	WASHER PNCHD.A24			4140800024					0.093
					––––––––					24
	08	NUT HEX.Gr.C M24			4130400024					0.330
					––––––––					24
	07	PL 200X180X25			15–011–081					7.065
					IS2062Fe410B					2
	06	ROD ø 100; 1202			15–039–358					74.108
					SA193–B7					1
	05	PL 700X100X25			15–011–081					13.738
					IS2062Fe410B					4
	04	PL 1100X300X125			15–911–787					323.812
					ASTM–A36					1
	03	PL 700X100X25			15–011–081					13.738
					IS2062Fe410B					2
	02	ROD ø 25; 550			15–339–139					2.121
					SA–105					8
	01	PL 1100X800X150			15–911–723					1036.2
					ASTM–A36					1
VARIANT NUMBER	ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER	ITEM NO	MATERIAL CODE	A/C/P	UNIT	UNIT WEIGHT	GS ZONE
					VAR NO	MATERIAL SPECN		DI	QUANTITY	







REV	DATE	ALTERED :
01		CHD & APPD :
ZONE		

CAUTION: The information on this document is property of BHARAT HEAVY ELECTRICALS LIMITED. It must not be used directly or indirectly in any way detrimental to the interest of the company.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

Bharat Heavy Electricals Ltd
UNIT: HIGH PRESSURE BOILER PLANT
TIRUCHIRAPALLI – 620014

355–053

	NAME	SIGNATURE	DATE
DRN	S.C.BABU		07.08.2007
CHD	T.CHINNADURAI		07.08.2007
APPD	R.JEYAKUMAR		07.08.2007

DEPT ST | CODE 122 | ALL DIMENSIONS ARE IN MM | PROJECTION | SCALE | WEIGHT (Kg) 1557.798 | REF TO ASSY / OLD DWG

TITLE: GIRDER PIN CONNECTION FOR COLUMNS–S8 L&R

DRAWING NO : 1-35-190-04840 | REV