

DRAWING NO. 2-V-0000-15100/2

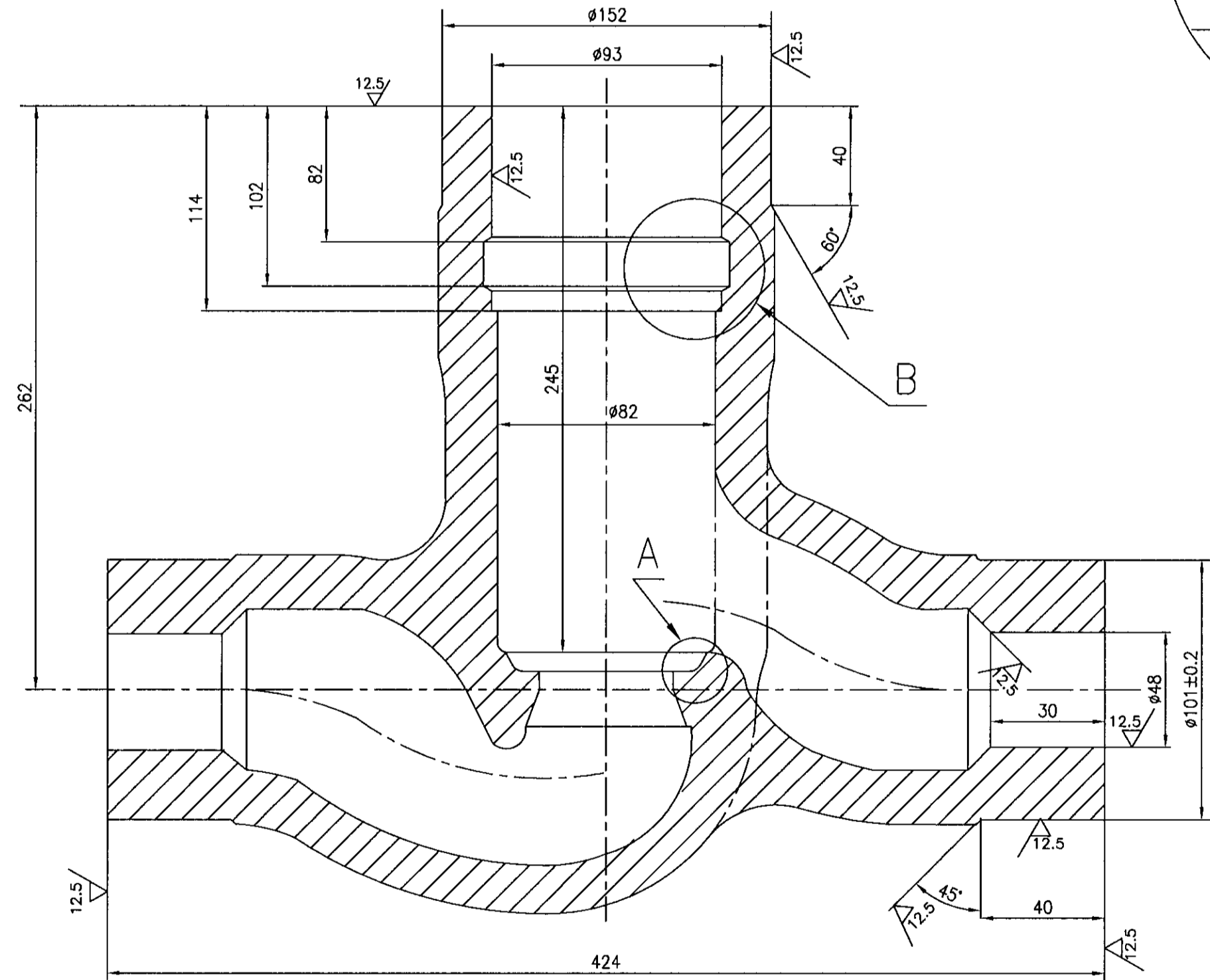
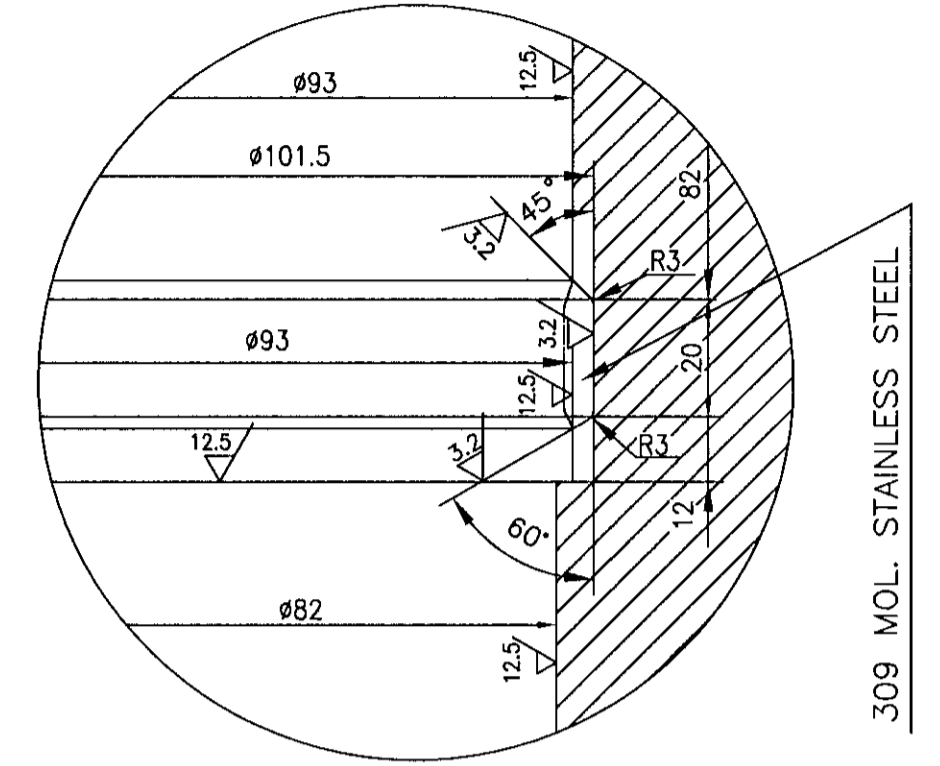
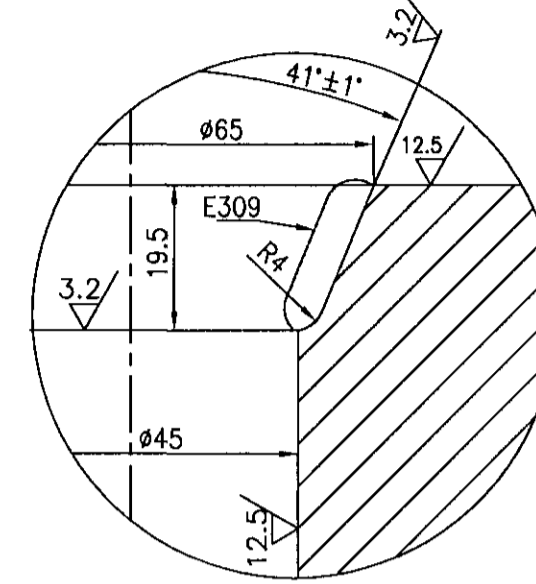
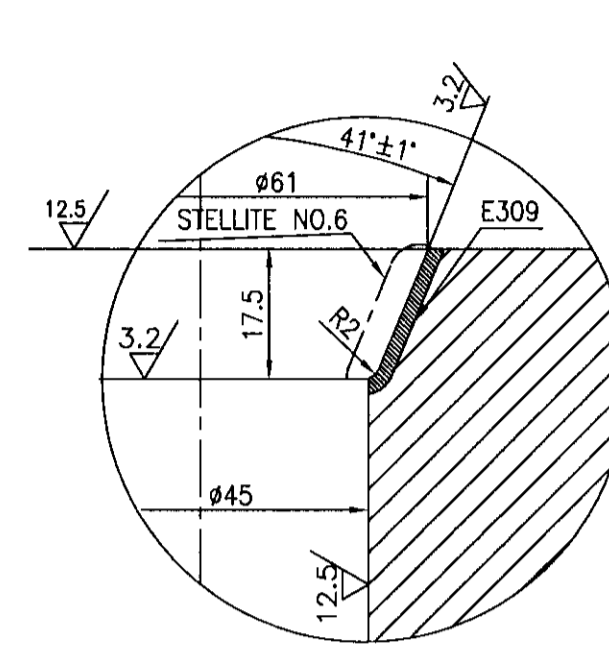
ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

DETAIL-A

DETAIL-B

MACHINING BEFORE STELLITE-6 WELD

MACHINING BEFORE BUFFER LAYER WELD



NOTES:-

- 1* MARKED TYPES ARE SPECIAL CLASS RATINGS.
- 2. LATEST APPLICABLE QUALITY WORK INSTRUCTION SHALL BE FOLLOWED IN ALL RESPECTS.

SL.NO	DRAWING NO.	MATERIAL SPECN.	COMPONENT CODE	SCRAP SORT
* 08	2-V-G040-15100/2	A217-WC9,NT	93 111 930 8000	20
* 07	2-V-G039-15100/2	A217-WC6,NT	93 111 929 8000	20
* 06	2-V-G038-15100/2	A216-WCC,AN	93 111 928 8000	10
* 05	2-V-G037-15100/2	A216-WCB,AN	93 111 927 8000	10
04	2-V-G036-15100/2	A217-WC9,NT	93 111 926 8000	20
03	2-V-G035-15100/2	A217-WC6,NT	93 111 925 8000	20
02	2-V-G034-15100/2	A216-WCC,AN	93 111 924 8000	10
01	2-V-G033-15100/2	A216-WCB,AN	93 111 923 8000	10

No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		REDRAWN WITH REV NO.2 ON 4.12.04				
BHARAT HEAVY ELECTRICALS LTD. UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI - 620014.		DRN	V.BAIRAVAN	SIGN	DATE 4.12.04	NO.OF VAR.
DEPT VL		CHD	K.RAJASEKARAN	APPD	M.RAJKUMAR	4.12.04
CODE 320	SCALE N.T.S	WEIGHT (KG)		REFERENCE INFORMATIONS		NO. OF PENS
TITLE		CARD CODE		DRAWING NO.		REV
BODY (ROUGH) (2 1/2 "/2500 CL.)		U 01		2-V-0000-15100		2

REV 2	DATE 4.12.04	ALTERED CHD & APPD	V.B KRS&MRK
ZONE E309 BUFFER WELD INCLUDED			
DCP No. 800397			

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

DRAWING NO. 2-V-0000-15100/2

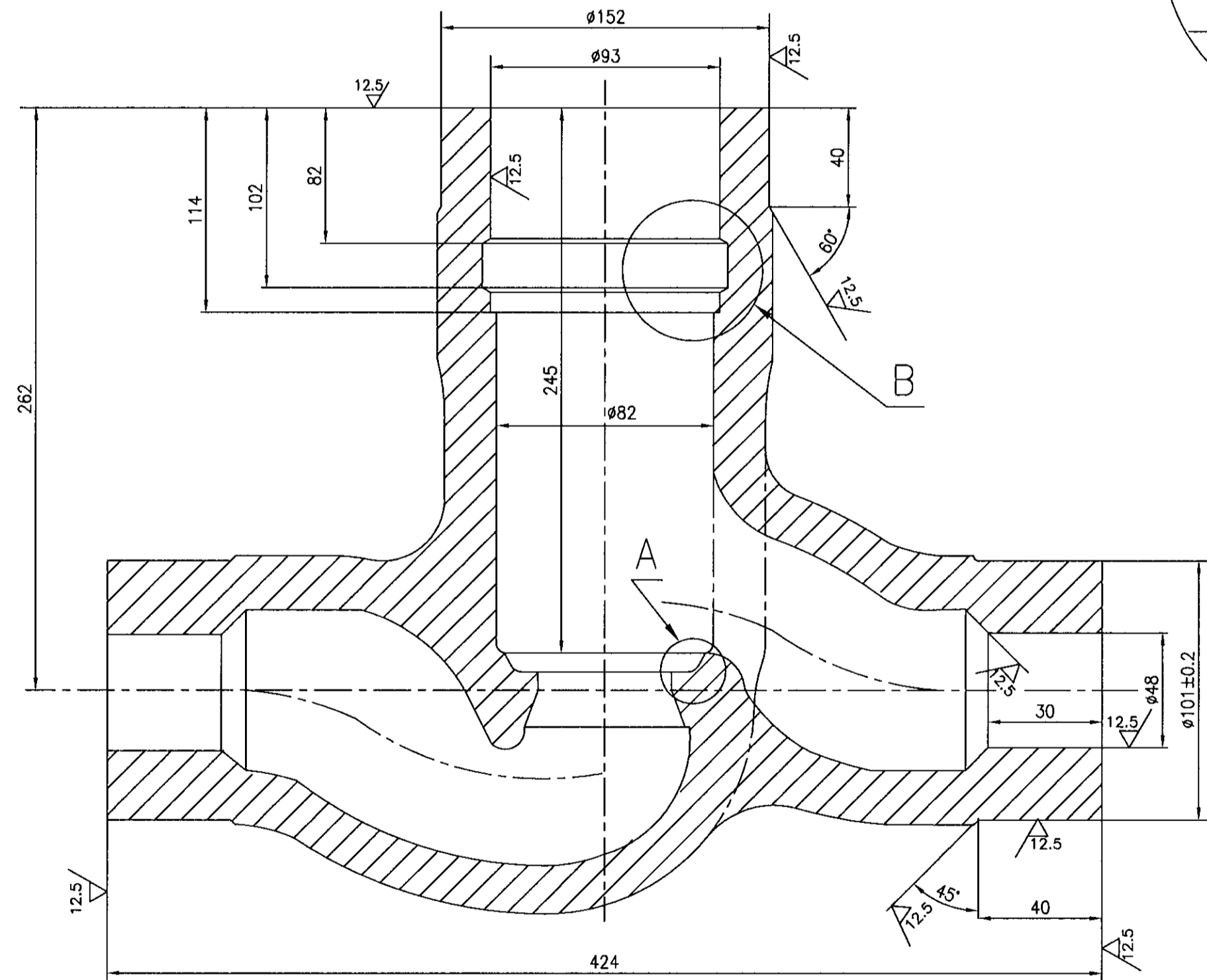
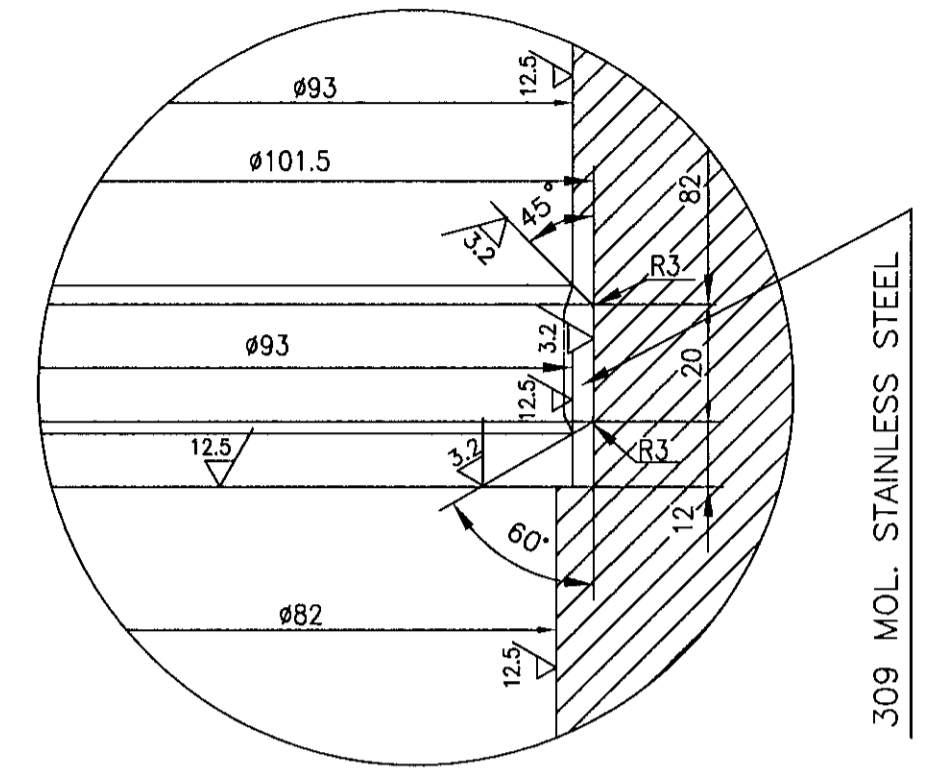
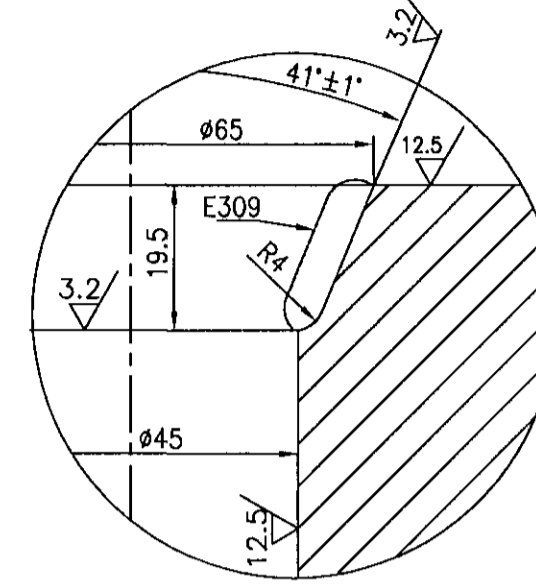
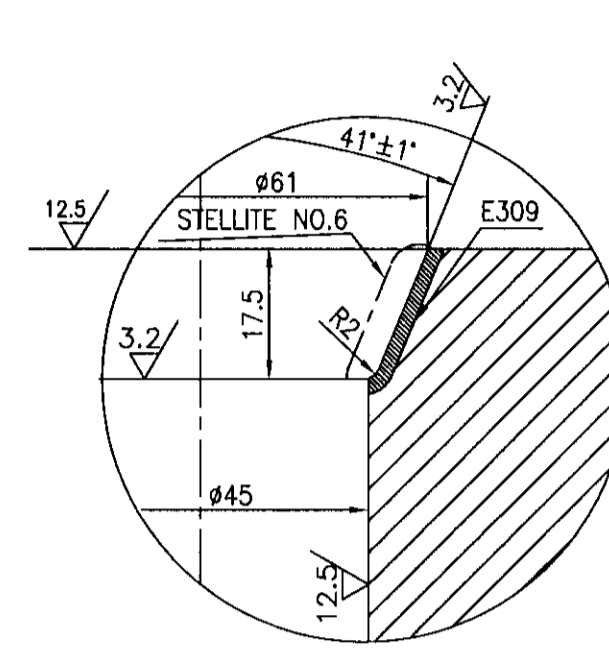
ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

DETAIL-A

DETAIL-B

MACHINING BEFORE STELLITE-6 WELD

MACHINING BEFORE BUFFER LAYER WELD



NOTES:-

- 1* MARKED TYPES ARE SPECIAL CLASS RATINGS.
- 2. LATEST APPLICABLE QUALITY WORK INSTRUCTION SHALL BE FOLLOWED IN ALL RESPECTS.

SL.NO	DRAWING NO.	MATERIAL SPECN.	COMPONENT CODE	SCRAP SORT
* 08	2-V-G040-15100/2	A217-WC9,NT	93 111 930 8000	20
* 07	2-V-G039-15100/2	A217-WC6,NT	93 111 929 8000	20
* 06	2-V-G038-15100/2	A216-WCC,AN	93 111 928 8000	10
* 05	2-V-G037-15100/2	A216-WCB,AN	93 111 927 8000	10
04	2-V-G036-15100/2	A217-WC9,NT	93 111 926 8000	20
03	2-V-G035-15100/2	A217-WC6,NT	93 111 925 8000	20
02	2-V-G034-15100/2	A216-WCC,AN	93 111 924 8000	10
01	2-V-G033-15100/2	A216-WCB,AN	93 111 923 8000	10

No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No

CAUTION: The information on this drawing is the property of BHARAT HEAVY ELECTRICALS LTD. 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: REDRAWN WITH REV NO.2 ON 4.12.04

DRN	V.BAIRAVAN	SIGN	DATE	NO.OF VAR.
CHD	K.RAJASEKARAN		4.12.04	
APPD	M.RAJKUMAR		4.12.04	

DEPT: VL, SCALE: N.T.S, WEIGHT (KG):

REFERENCE INFORMATION: CAD:REF:T215100

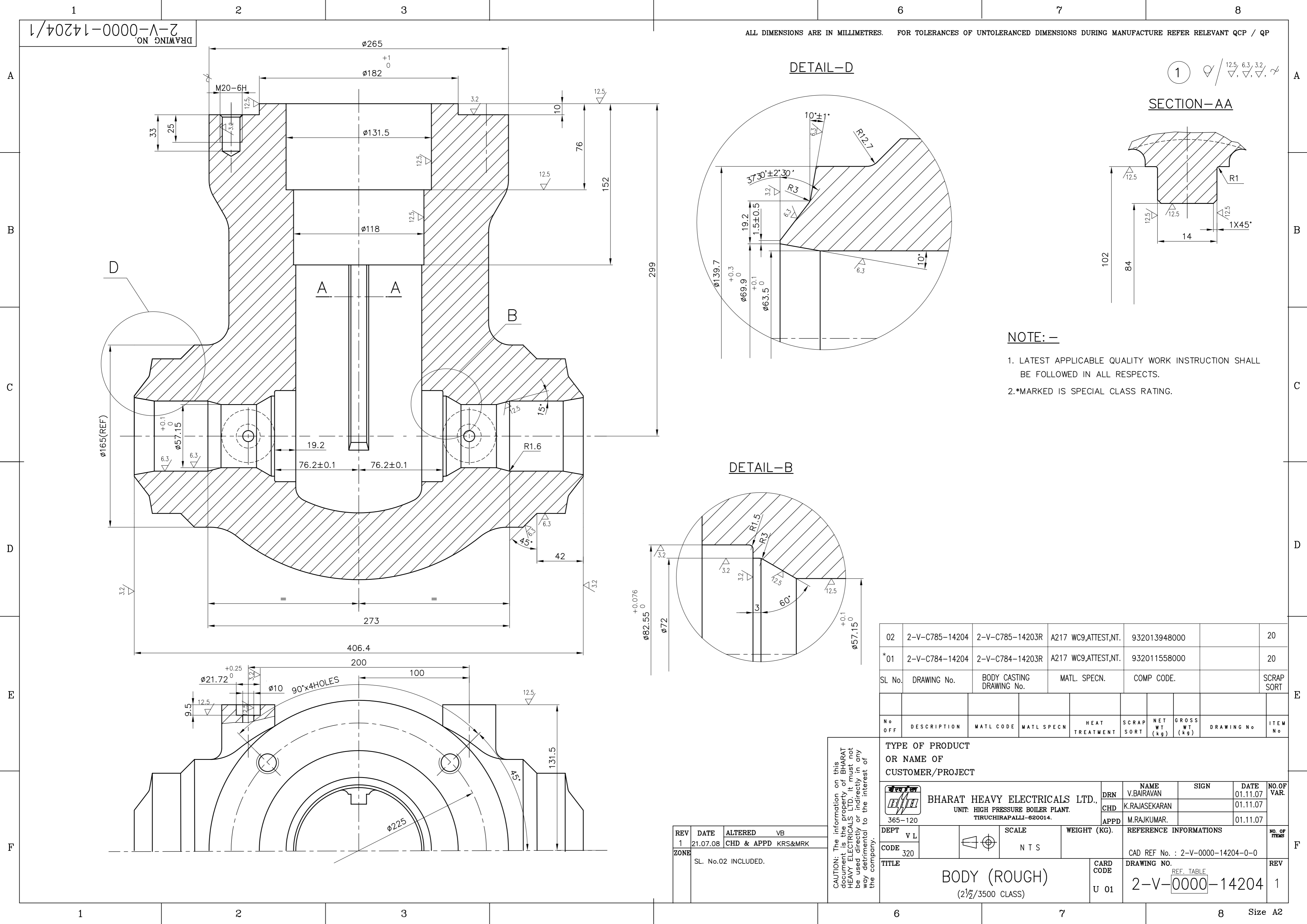
TITLE: BODY (ROUGH) (2 1/2 "/2500 CL.)

CARD CODE: U 01, DRAWING NO: 2-V-0000-15100, REV: 2

REV	DATE	ALTERED	V.B
2	4.12.04	CHD & APPD	KRS&MRK

ZONE: E309 BUFFER WELD INCLUDED

DCP No. 800397



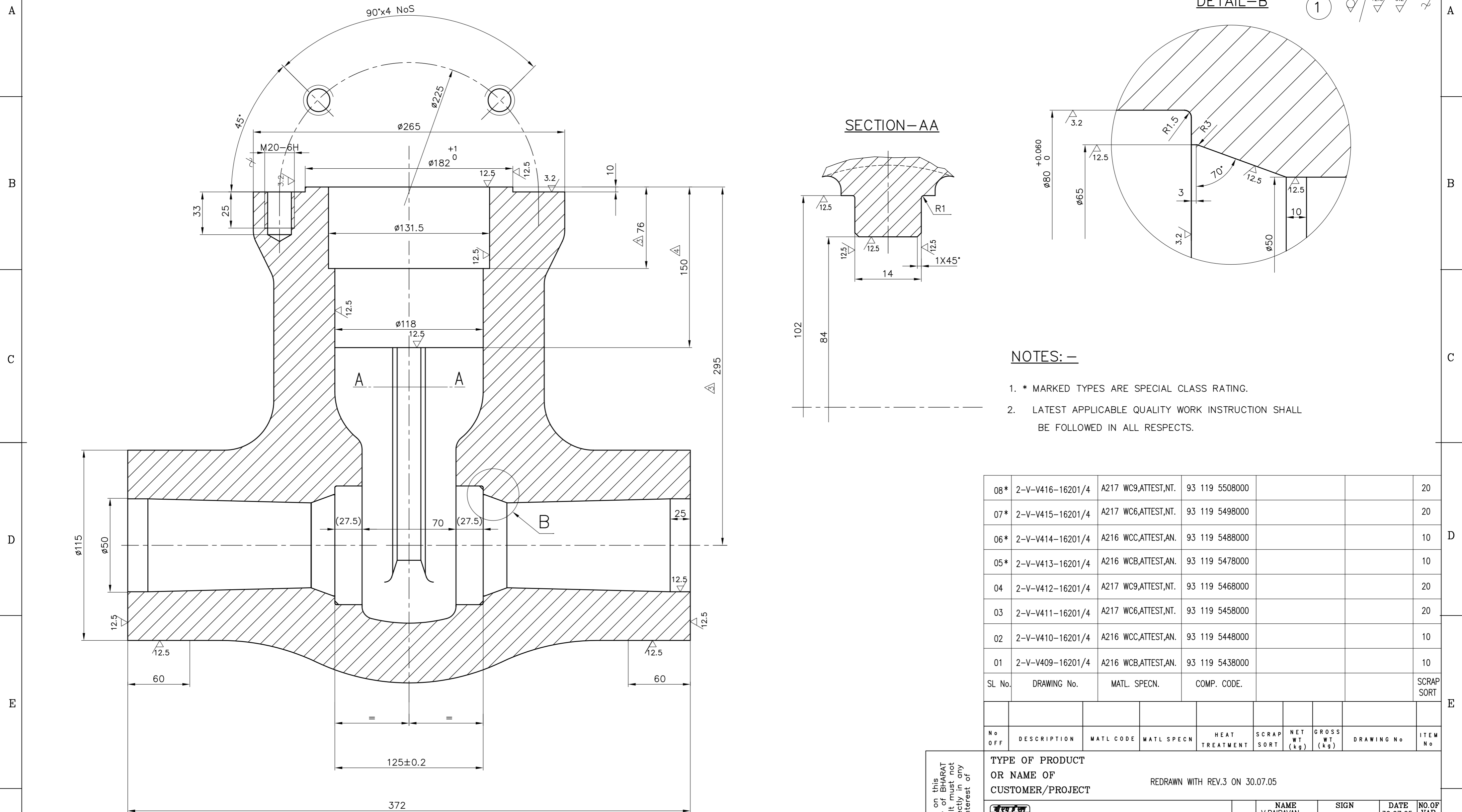
NOTE: -
 1. LATEST APPLICABLE QUALITY WORK INSTRUCTION SHALL BE FOLLOWED IN ALL RESPECTS.
 2.*MARKED IS SPECIAL CLASS RATING.

02	2-V-C785-14204	2-V-C785-14203R	A217 WC9,ATTEST,NT.	932013948000	20				
*01	2-V-C784-14204	2-V-C784-14203R	A217 WC9,ATTEST,NT.	932011558000	20				
SL No.	DRAWING No.	BODY CASTING DRAWING No.	MATL. SPECN.	COMP CODE.	SCRAP SORT				
No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT						
BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.		DRN	V.BAIRAVAN	SIGN	DATE 01.11.07	NO. OF VAR.
DEPT	365-120	CHD	K.RAJASEKARAN	APPD	M.RAJKUMAR.	01.11.07
SCALE	NTS	REFERENCE INFORMATION				NO. OF ITEMS
CODE	320	CAD REF No. : 2-V-0000-14204-0-0				REV
TITLE		CARD CODE	DRAWING NO.		REF. TABLE	REV
BODY (ROUGH) (2 1/2/3500 CLASS)		U 01	2-V-0000-14204		1	

REV	DATE	ALTERED	VB
1	21.07.08	CHD & APPD	KRS&MRK
ZONE	SL. No.02 INCLUDED.		

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NOTES: -

- * MARKED TYPES ARE SPECIAL CLASS RATING.
- LATEST APPLICABLE QUALITY WORK INSTRUCTION SHALL BE FOLLOWED IN ALL RESPECTS.

08*	2-V-V416-16201/4	A217 WC9,ATTEST,NT.	93 119 5508000		20
07*	2-V-V415-16201/4	A217 WC6,ATTEST,NT.	93 119 5498000		20
06*	2-V-V414-16201/4	A216 WCC,ATTEST,AN.	93 119 5488000		10
05*	2-V-V413-16201/4	A216 WCB,ATTEST,AN.	93 119 5478000		10
04	2-V-V412-16201/4	A217 WC9,ATTEST,NT.	93 119 5468000		20
03	2-V-V411-16201/4	A217 WC6,ATTEST,NT.	93 119 5458000		20
02	2-V-V410-16201/4	A216 WCC,ATTEST,AN.	93 119 5448000		10
01	2-V-V409-16201/4	A216 WCB,ATTEST,AN.	93 119 5438000		10
SL No.	DRAWING No.	MATL. SPECN.	COMP. CODE.		SCRAP SORT

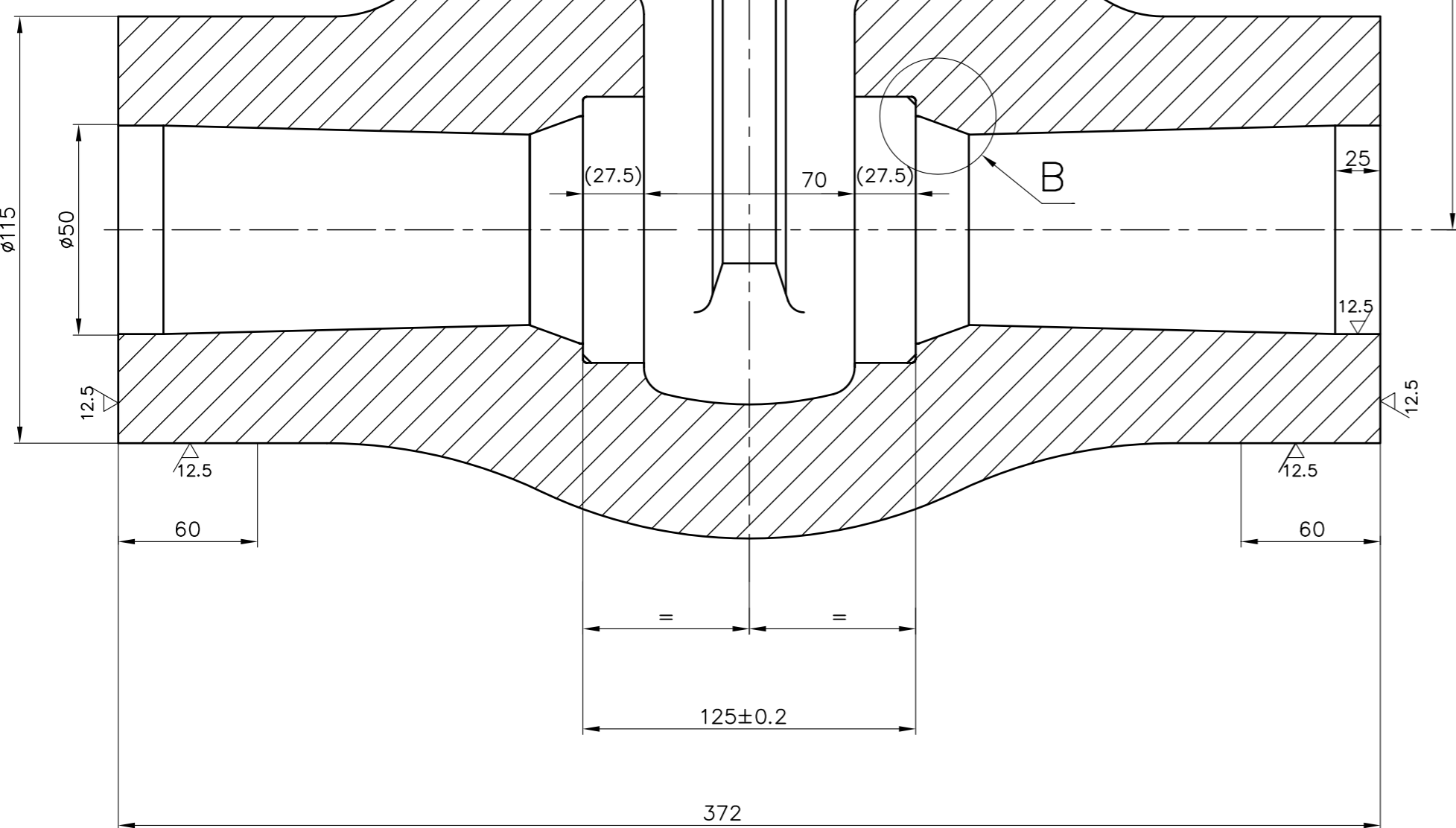
No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
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TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT REDRAWN WITH REV.3 ON 30.07.05

	BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI-620014.		DRN	V.BAIRAVAN	SIGN	DATE	NO.OF VAR.		
	CHD	K.RAJASEKARAN	APPD	M.RAJKUMAR.		30.07.05			
	DEPT	365-120	SCALE	N T S	WEIGHT (KG).	116	REFERENCE INFORMATION	NO. OF ITEMS	
CODE	320	TITLE	BODY (ROUGH) 3"/3000 CLASS		CARD CODE	U 01	TOA DRG No. : 3-38339(899) CAD REF No. : T216201 DRAWING NO. REFER TABLE 2-V-0000-16201	REV	4

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

REV	DATE	ALTERED	VB	REV	DATE	ALTERED	VB
4	12.02.08	CHD & APPD	KRS&MRK	3	30.7.05	CHD & APPD	K.R.S.&M.R.K
DIMENSION 150 WAS 152 DCP.NO.800797				M20-6H x 4 NoS OF TAPPED HOLES INTRODUCED DIMENSIONS 295 & 76 WERE 297 & 78 RESPECTIVELY DCP.NO.800494			



REV	DATE	ALTERED	VB	REV	DATE	ALTERED	VB
4	12.02.08	CHD & APPD	KRS&MRK	3	30.7.05	CHD & APPD	K.R.S.&M.R.K
DIMENSION 150 WAS 152 DCP.NO.800797				M20-6H x 4 NoS OF TAPPED HOLES INTRODUCED DIMENSIONS 295 & 76 WERE 297 & 78 RESPECTIVELY DCP.NO.800494			

DRAWING NO. 2-V-0000-15536/2

ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

1 ✓ / 12.5 / 3.2

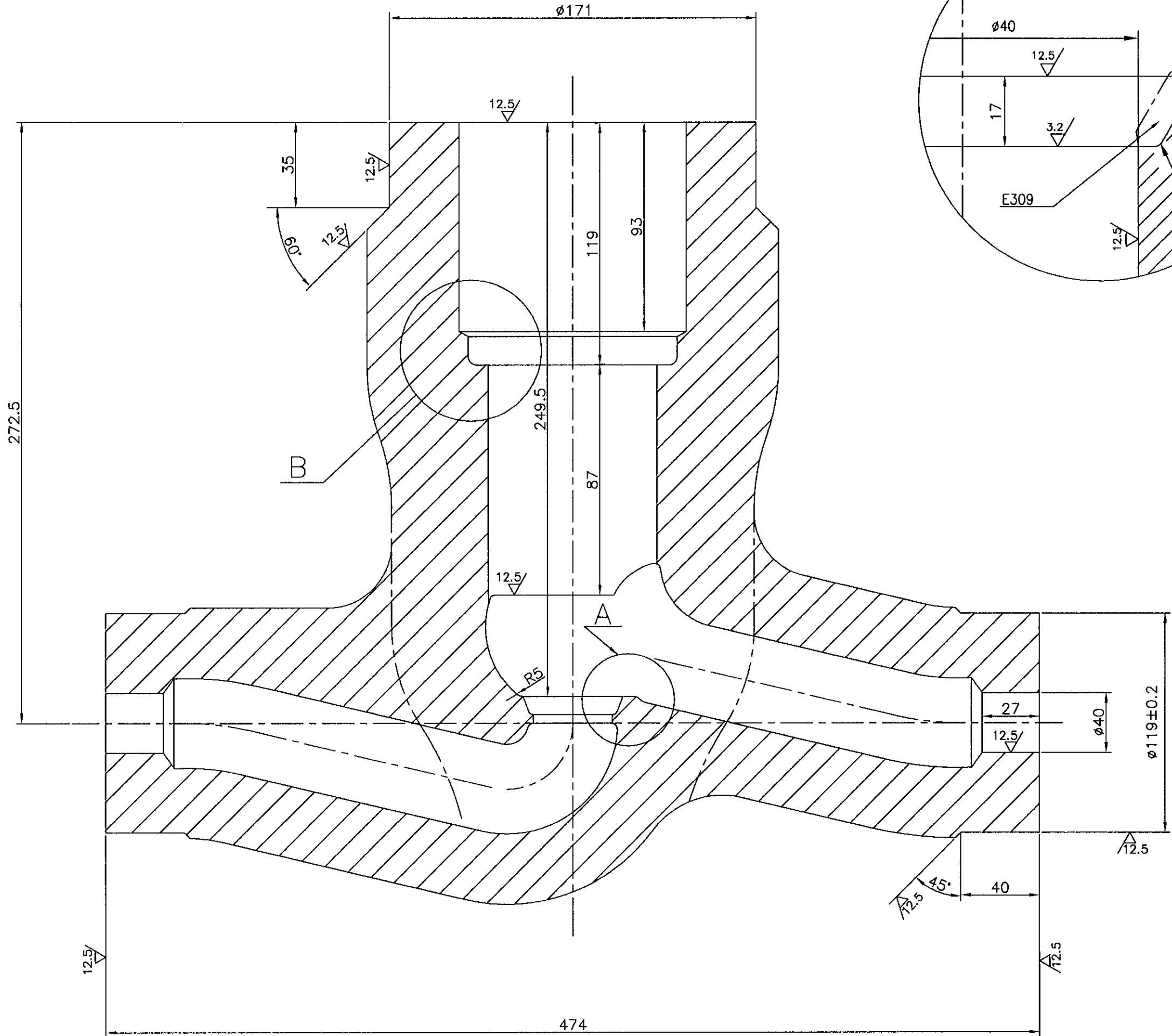
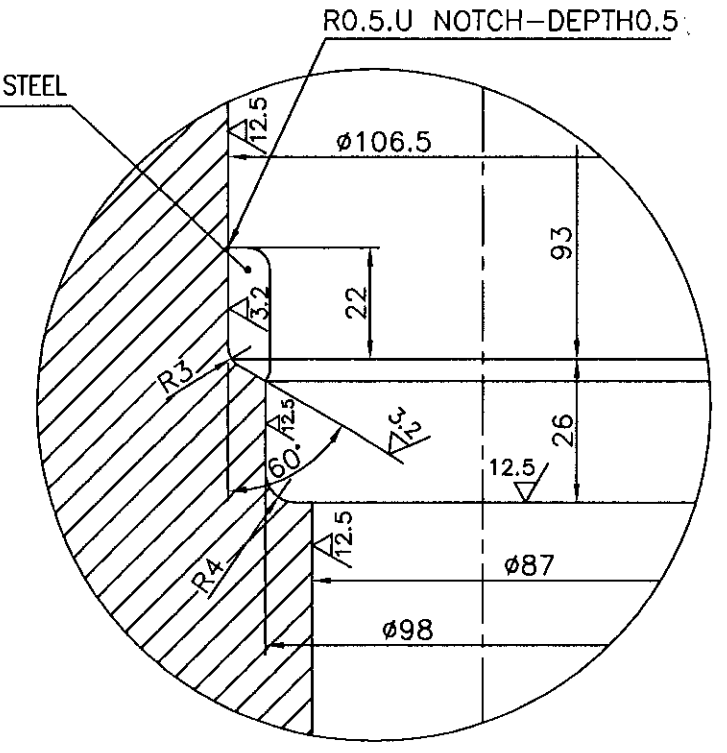
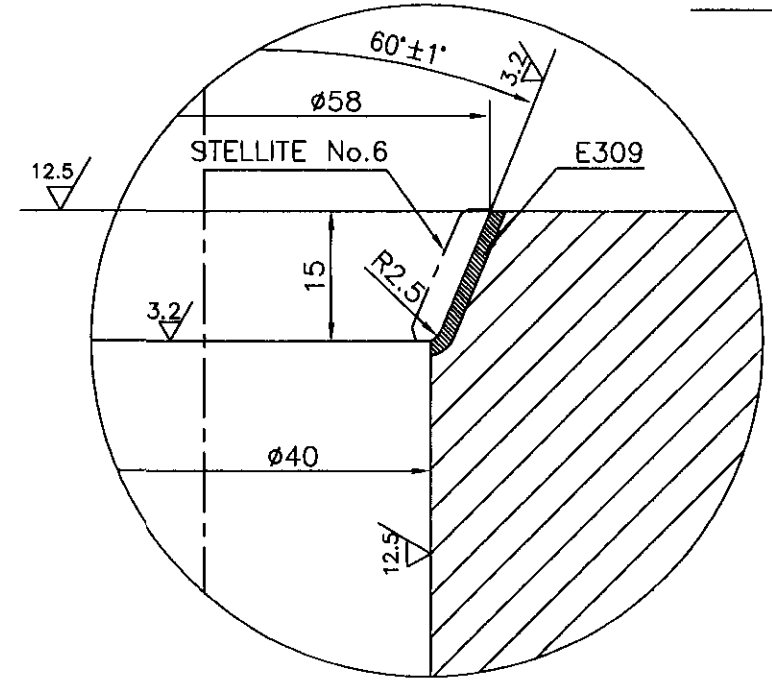
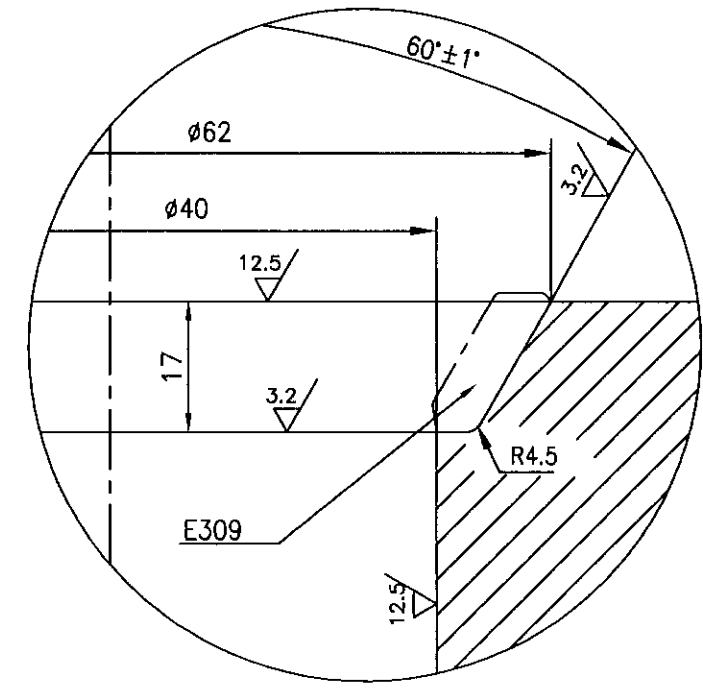
DETAIL-A

MACHINING BEFORE BUFFER LAYER WELD

MACHINING BEFORE STELLITE-6 WELD

DETAIL-B

309 MOL STAINLESS STEEL



NOTES:

- LATEST APPLICABLE QUALITY WORK INSTRUCTION SHALL BE FOLLOWED IN ALL RESPECTS.
- * MARKED TYPES ARE SPECIAL CLASS RATINGS.

SL. NO.	DRAWING NO.	MATERIAL SPECN.	COMP. CODE	SCRAP SORT
8.	2-V-R148-15536/2	A217 WC9, ATTEST, NT	93 115 612 8000	20
7.	2-V-R147-15536/2	A217 WC6, ATTEST, NT	93 115 611 8000	20
6.	2-V-R146-15536/2	A216 WCC, ATTEST, AN	93 115 610 8000	10
5.	2-V-R145-15536/2	A216 WCB, ATTEST, AN	93 115 609 8000	10
4.	2-V-R144-15536/2	A217 WC9, ATTEST, NT	93 115 608 8000	20
3.	2-V-R143-15536/2	A217 WC6, ATTEST, NT	93 115 607 8000	20
2.	2-V-R142-15536/2	A216 WCC, ATTEST, AN	93 115 606 8000	10
1.	2-V-R141-15536/2	A216 WCB, ATTEST, AN	93 115 605 8000	10

No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
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TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: REDRAWN WITH REV.No.2 ON 4.12.04

BHARAT HEAVY ELECTRICALS LTD.
UNIT: HIGH PRESSURE BOILER PLANT.
TIRUCHIRAPPALLI - 620014.

DRN	V.BAIRAVAN	SIGN	DATE	NO.OF VAR.
CHD	K.RAJASEKARAN		4.12.04	
APPD	M.RAJAKUMAR		4.12.04	

DEPT VL: 365-120
SCALE: N.T.S.
WEIGHT (KG):
REFERENCE INFORMATIONS: 3-E 40250 (2459)
CAD:REF:T215536

TITLE: BODY (ROUGH)
CARD CODE: U 01
DRAWING NO.: 2-V-0000-15536
REV: 2

REV	DATE	ALTERED	V.B
2	4.12.04	CHD & APPD	KRS&MRK

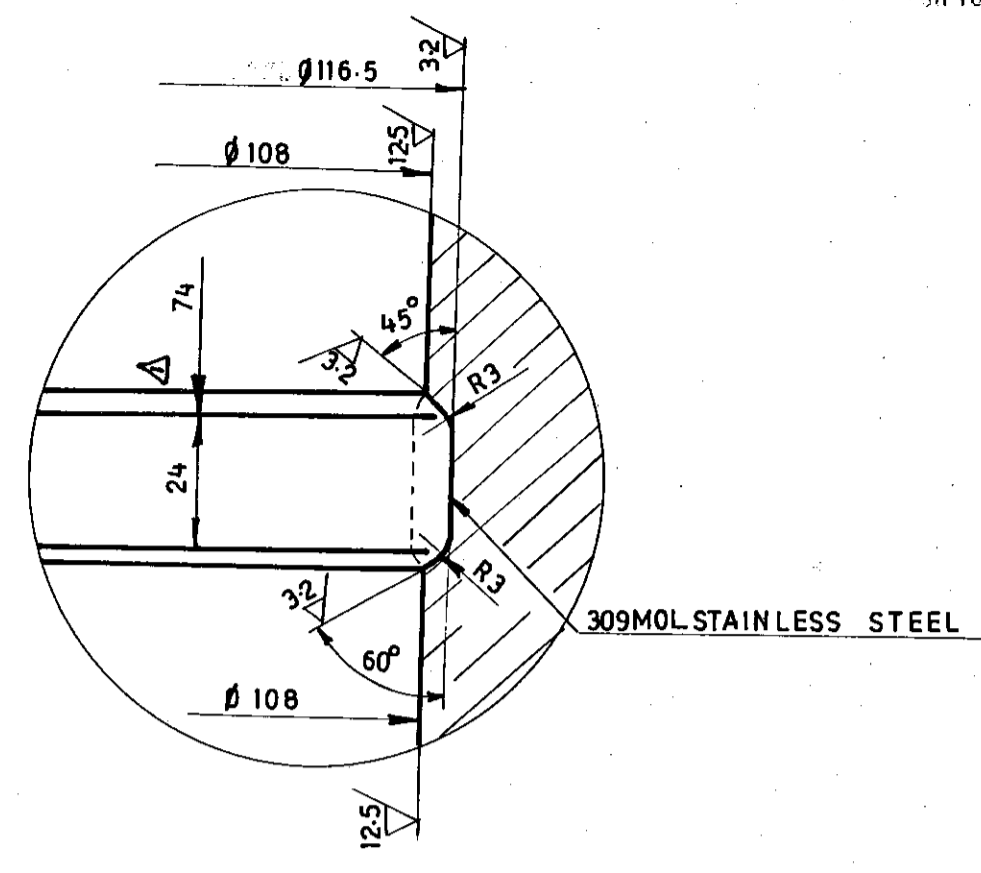
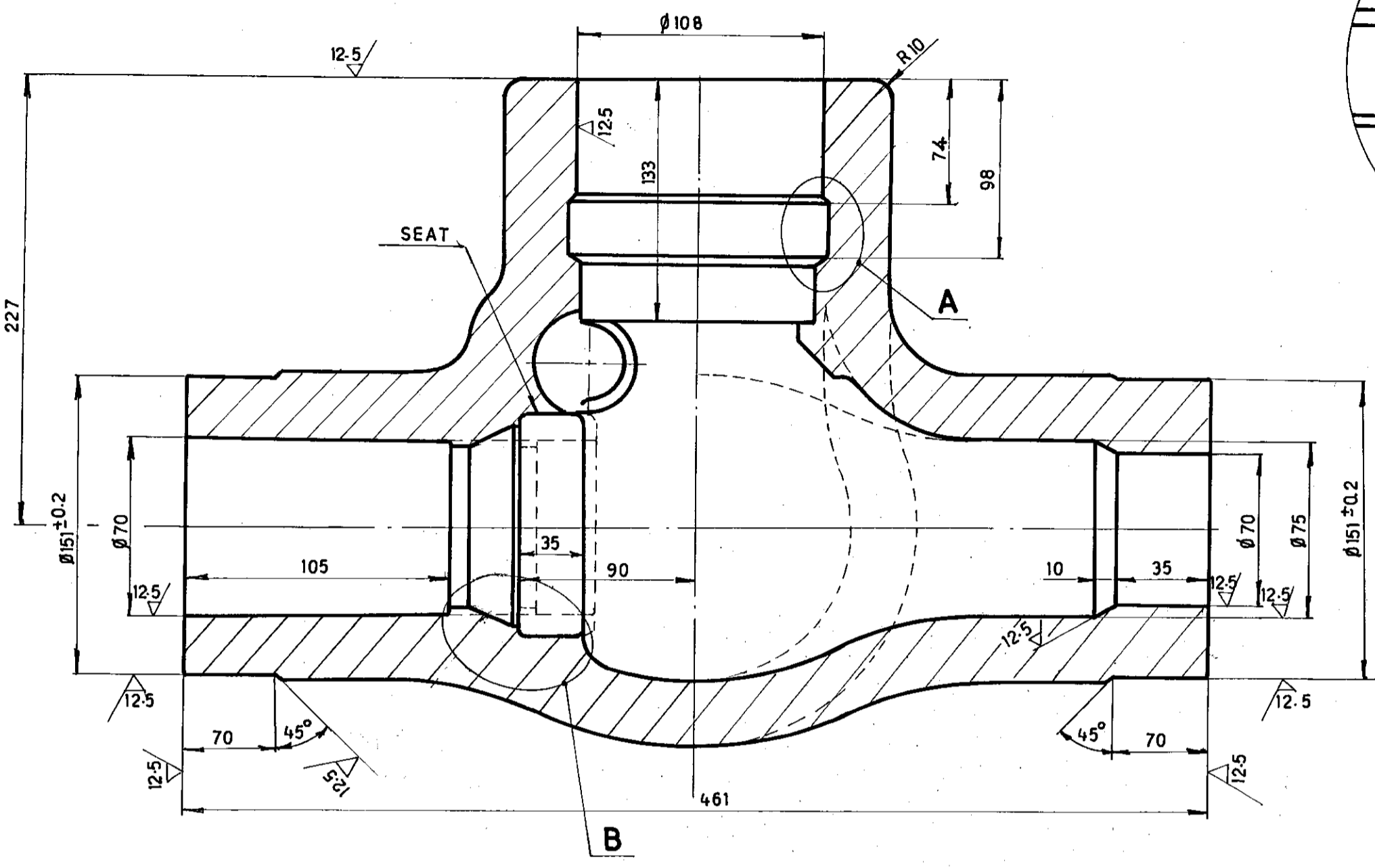
E309 BUFFER WELD INCLUDED
DCP.NO.800397

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

DRG NO. 2-V-0000-15325/02

FOR TOLERANCES OF UNDIMENSIONED DIMENSIONS DURING MANUFACTURE REFER RELEVANT ISIRI/IS

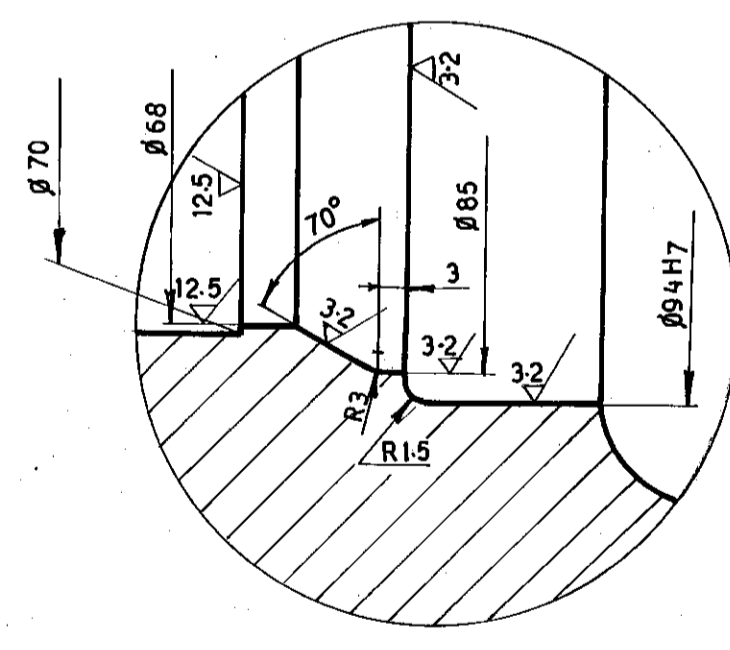
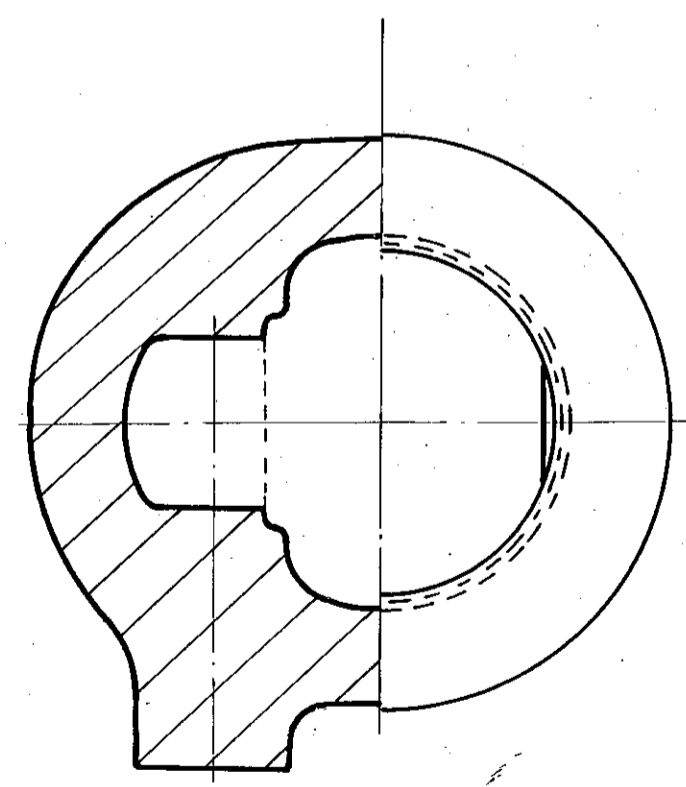
12.5	3-2
1	
φ94 H7	+0.035 0



DETAIL - A

NOTES :-

- ★ MARK INDICATES SPECIAL CLASS RATING.
- LATEST APPLICABLE QUALITY PROCEDURE SHALL BE FOLLOWED IN ALL RESPECTS.



DETAIL - B

SL.NO.	DRG. NO.	MATL. SPECN.	COMP. CODE	SCRAP SORT
8★	2-V-L104-15325	A 217 WC9, ATTEST, NT	93 112 690 8000	20
7★	2-V-L103-15325	A 217 WC6, ATTEST, NT	93 112 689 8000	20
6★	2-V-L102-15325	A 216 WCC, ATTEST, AN	93 112 688 8000	10
5★	2-V-L101-15325	A 216 WCB, ATTEST, AN	93 112 687 8000	10
4	2-V-L100-15325	A 217 WC9, ATTEST, NT	93 112 686 8000	20
3	2-V-L099-15325	A 217 WC6, ATTEST, NT	93 112 685 8000	20
2	2-V-L098-15325	A 216 WCC, ATTEST, AN	93 112 684 8000	10
1	2-V-L097-15325	A 216 WCB, ATTEST, AN	93 112 683 8000	10

BHARAT HEAVY ELECTRICALS LTD.,
BOILER PLANT UNIT, TIRUCHIRAPALLI-14

FIRST ANGLE	SCALE	DRAWN	EC	TOTAL NET WT.(KG)
	NTS	CHECKED	L. RENGAMMY	TYPE
ALL DIMENSIONS IN MILLIMETRES		APPROVED	S. KUMAR	
		DATE	19/6/87	TOA DRG NO. 3-E 30841 (1728)

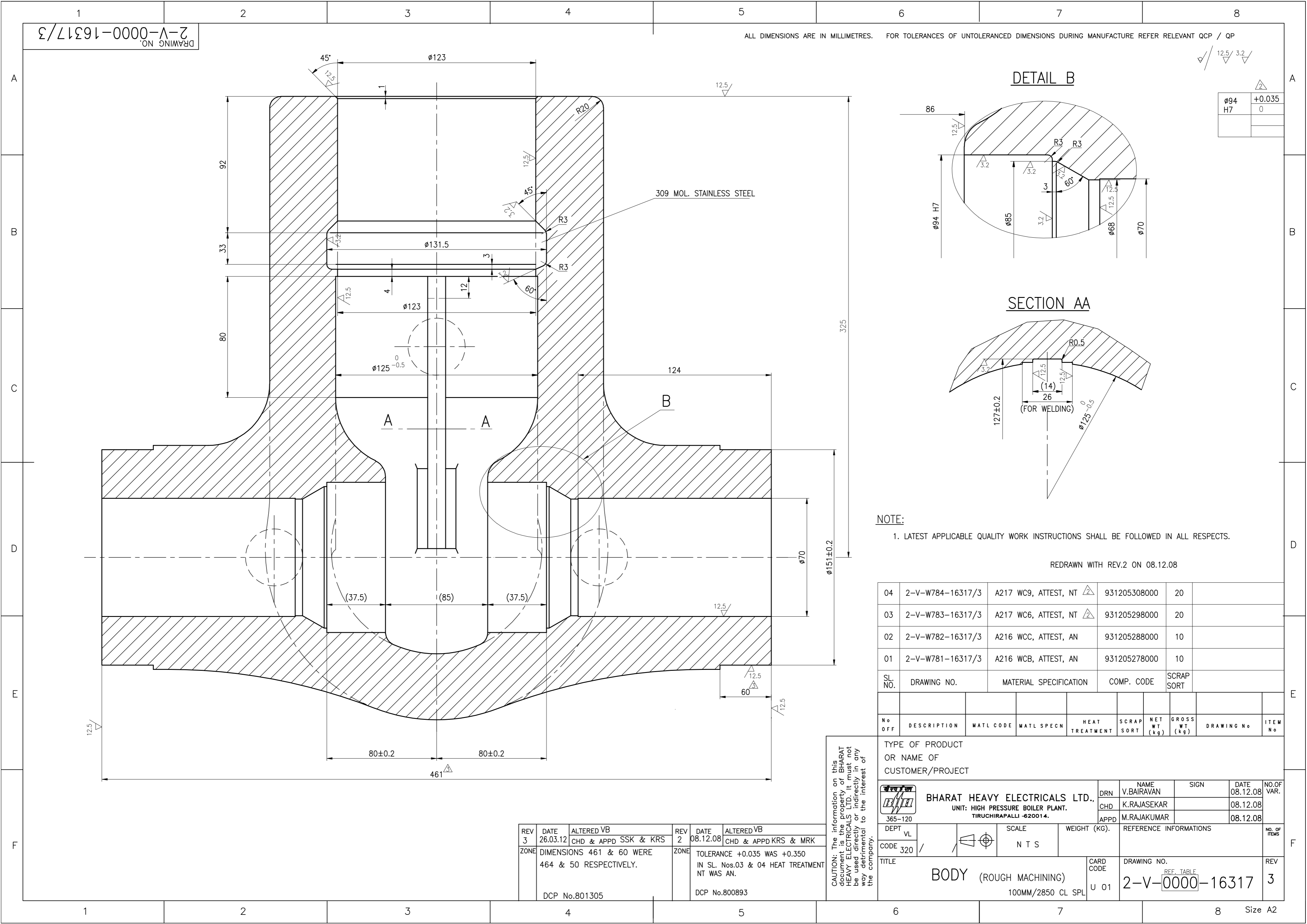
CAUTION		BODY	
THE INFORMATION CONTAINED IN THIS DRAWING IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LTD., BOILER PLANT UNIT, TIRUCHY-14 AND SHALL NOT BE USED WITHOUT THEIR EXPRESS WRITTEN PERMISSION IN ANY FORM OR PART THEREOF FOR ANY OTHER PURPOSE THAN FOR WHICH IT IS SENT TO YOU.		ROUGH MACHINING DRG (100/2500C)	
DRAWING NO. A4728 B-10		REVISION	
REF. TABLE		02	
2-V-0000-15325			

REV.	DATE	ALT. Y.A.	REV.	DATE	ALTERED
02	28.01.97	CHD&APD.M.R.K.	01	5.12.89	K.R.S.K. L.
NOTES UPDATED. DCN No. TA 0766		ZONE		ARROW HEAD FOR DIMEN, 74 CORRECTED IN DETAIL-A DCN No. TA 0115	

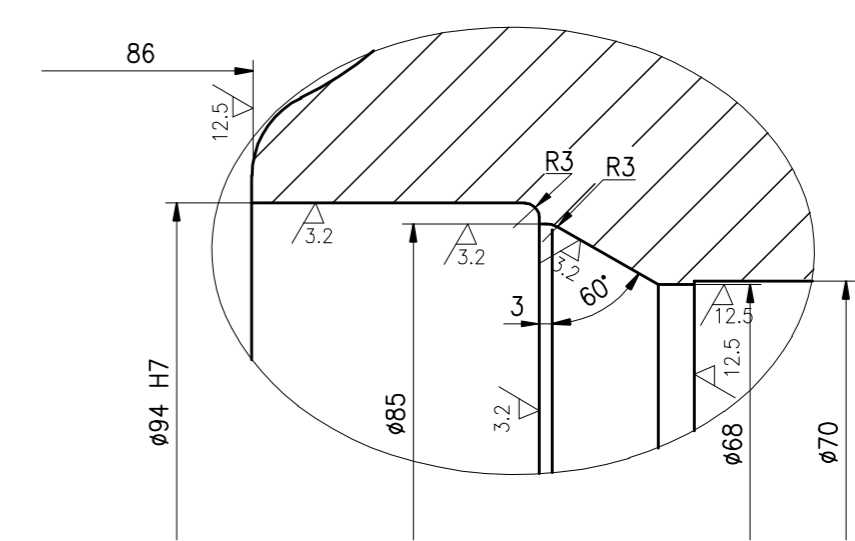
DRAWING NO. 2-V-0000-16317/3

ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

12.5/3.2

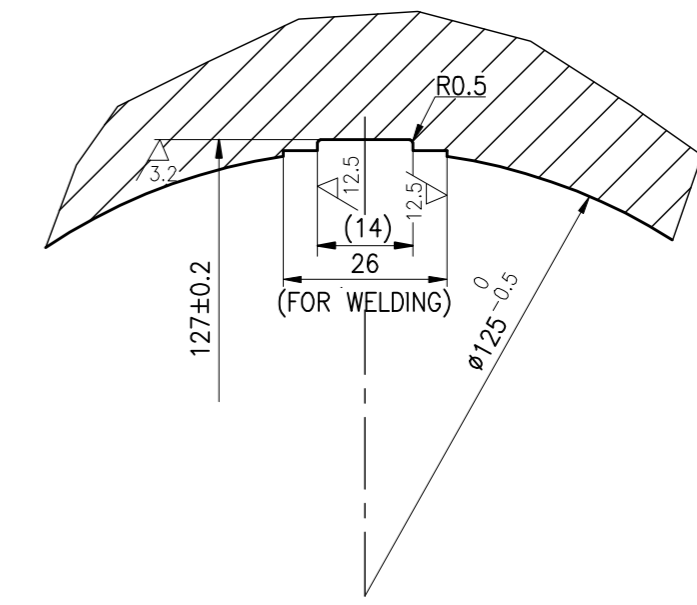


DETAIL B



Ø94	+0.035
H7	0

SECTION AA



NOTE:

1. LATEST APPLICABLE QUALITY WORK INSTRUCTIONS SHALL BE FOLLOWED IN ALL RESPECTS.

REDRAWN WITH REV.2 ON 08.12.08

04	2-V-W784-16317/3	A217 WC9, ATTEST, NT	931205308000	20
03	2-V-W783-16317/3	A217 WC6, ATTEST, NT	931205298000	20
02	2-V-W782-16317/3	A216 WCC, ATTEST, AN	931205288000	10
01	2-V-W781-16317/3	A216 WCB, ATTEST, AN	931205278000	10

SL. NO.	DRAWING NO.	MATERIAL SPECIFICATION	COMP. CODE	SCRAP SORT					
No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No

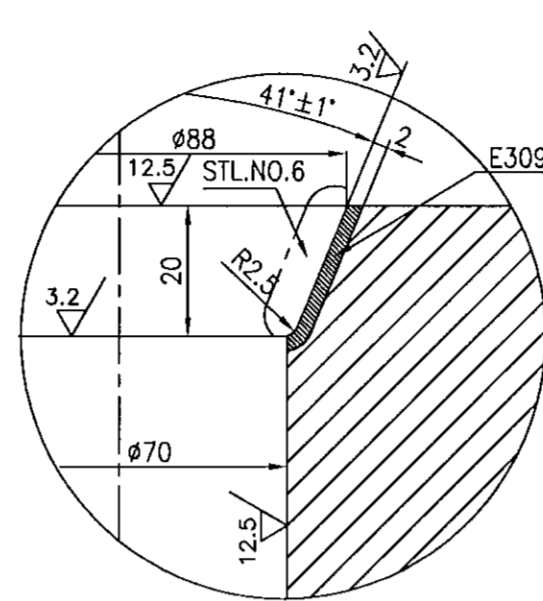
CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI -620014.		DRN	V.BAIRAVAN	SIGN	DATE	NO.OF VAR.
DEPT	VL	SCALE	WEIGHT (KG).	APPD	M.RAJAKUMAR		08.12.08	
CODE	320	N T S	REFERENCE INFORMATIONS	CARD CODE	U 01	DRAWING NO.	2-V-0000-16317	REV
TITLE		BODY (ROUGH MACHINING)		DRAWING NO.		REF. TABLE		3
		100MM/2850 CL SPL						

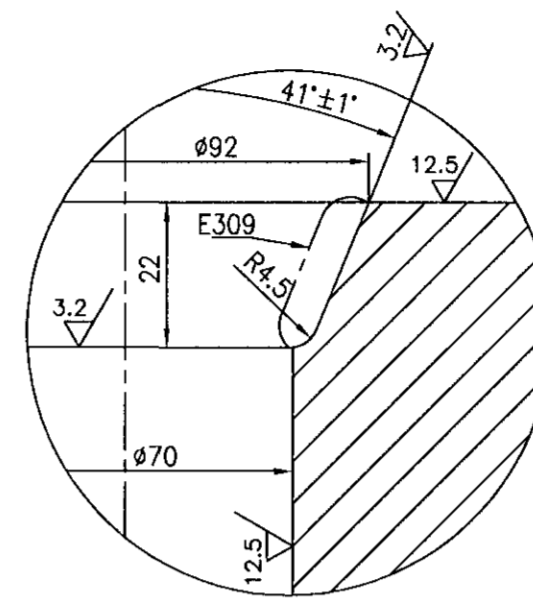
REV 3	DATE 26.03.12	ALTERED VB CHD & APPD SSK & KRS	REV 2	DATE 08.12.08	ALTERED VB CHD & APPD KRS & MRK
DIMENSIONS 461 & 60 WERE 464 & 50 RESPECTIVELY.			TOLERANCE +0.035 WAS +0.350 IN SL. Nos.03 & 04 HEAT TREATMENT NT WAS AN.		
DCP No.801305			DCP No.800893		

DETAIL-A

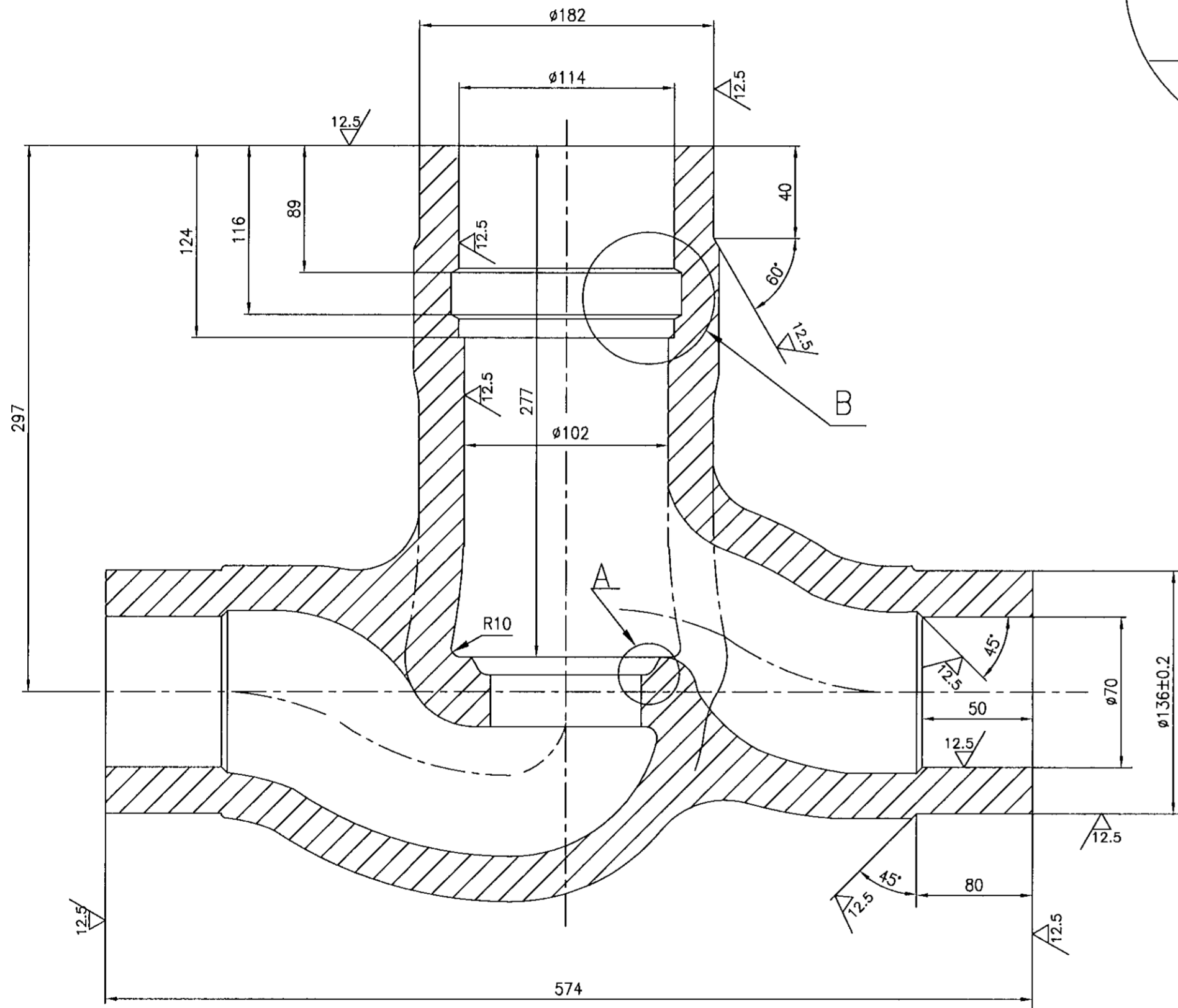
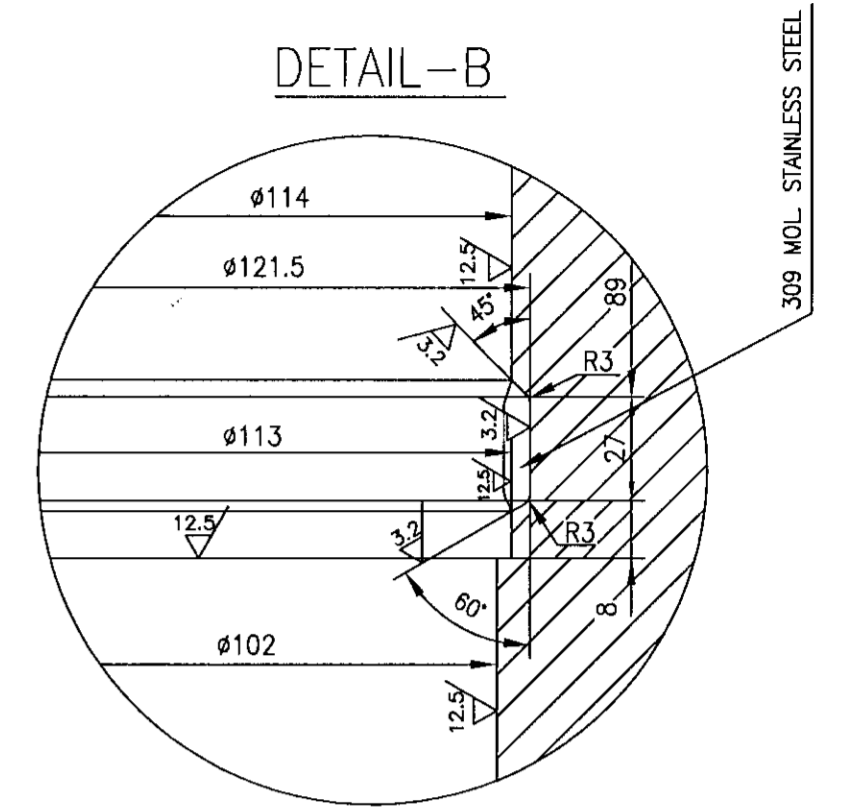
MACHINING BEFORE
STELLITE-6 WELD



MACHINING BEFORE
BUFFER LAYER WELD



DETAIL-B



NOTES:-

- * MARKED TYPES ARE SPECIAL CLASS RATINGS.
- LATEST APPLICABLE QUALITY WORK INSTRUCTION SHALL BE FOLLOWED IN ALL RESPECTS

SL. NO.	DRAWING NO.	MATERIAL SPECIFICATION	COMP. CODE	SCRAP SORT
* 08	2-V-G029-15036/3	A 217 WC9, NT	93 111 274 8000	20
* 07	2-V-G028-15036/3	A 217 WC6, NT	93 111 273 8000	20
* 06	2-V-G027-15036/3	A 216 WCC, AN	93 111 272 8000	10
* 05	2-V-G019-15036/3	A 216 WCB, AN	93 111 271 8000	10
04	2-V-G013-15036/3	A 217 WC9, NT	93 111 270 8000	20
03	2-V-G012-15036/3	A 217 WC6, NT	93 111 269 8000	20
02	2-V-G011-15036/3	A 216 WCC, AN	93 111 268 8000	10
01	2-V-G003-15036/3	A 216 WCB, AN	93 111 267 8000	10

No OFF	DESCRIPTION	MATL CODE	MATL SPECH	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No

CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. 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: REDRAWN WITH REV.No.3 ON 04-12-04

DRN	V.BAIRAVAN	SIGN	DATE	NO.OF VAR.
CHD	K.RAJASEKARAN		04-12-04	
APPD	M.RAJKUMAR		04-12-04	

BHARAT HEAVY ELECTRICALS LTD., UNIT: HIGH PRESSURE BOILER PLANT, TIRUCHIRAPALLI - 620014.

DEPT: VL, SCALE: N.T.S., WEIGHT (KG):

REFERENCE INFORMATIONS: 3-E25621 (0328), CAD:REF:T215036

TITLE: BODY (ROUGH) 4"/2500 CL.

CARD CODE: U 01, DRAWING NO. REF:TABLE 2-V-0000-15036, REV: 3

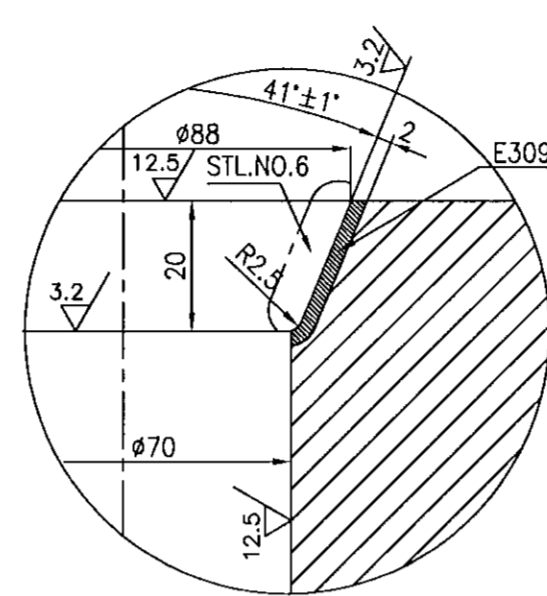
REV	DATE	ALTERED	V.B
3	04-12-04	CHD & APPD	KRS&MRK

ZONE: E309 BUFFER WELD INCLUDED

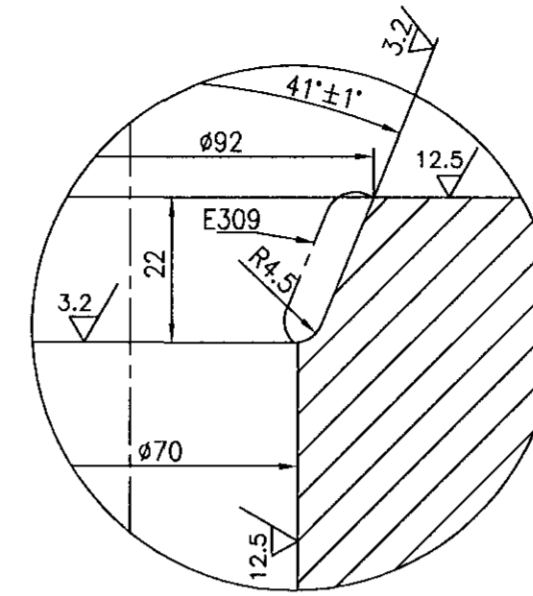
DCP No. 800397

DETAIL-A

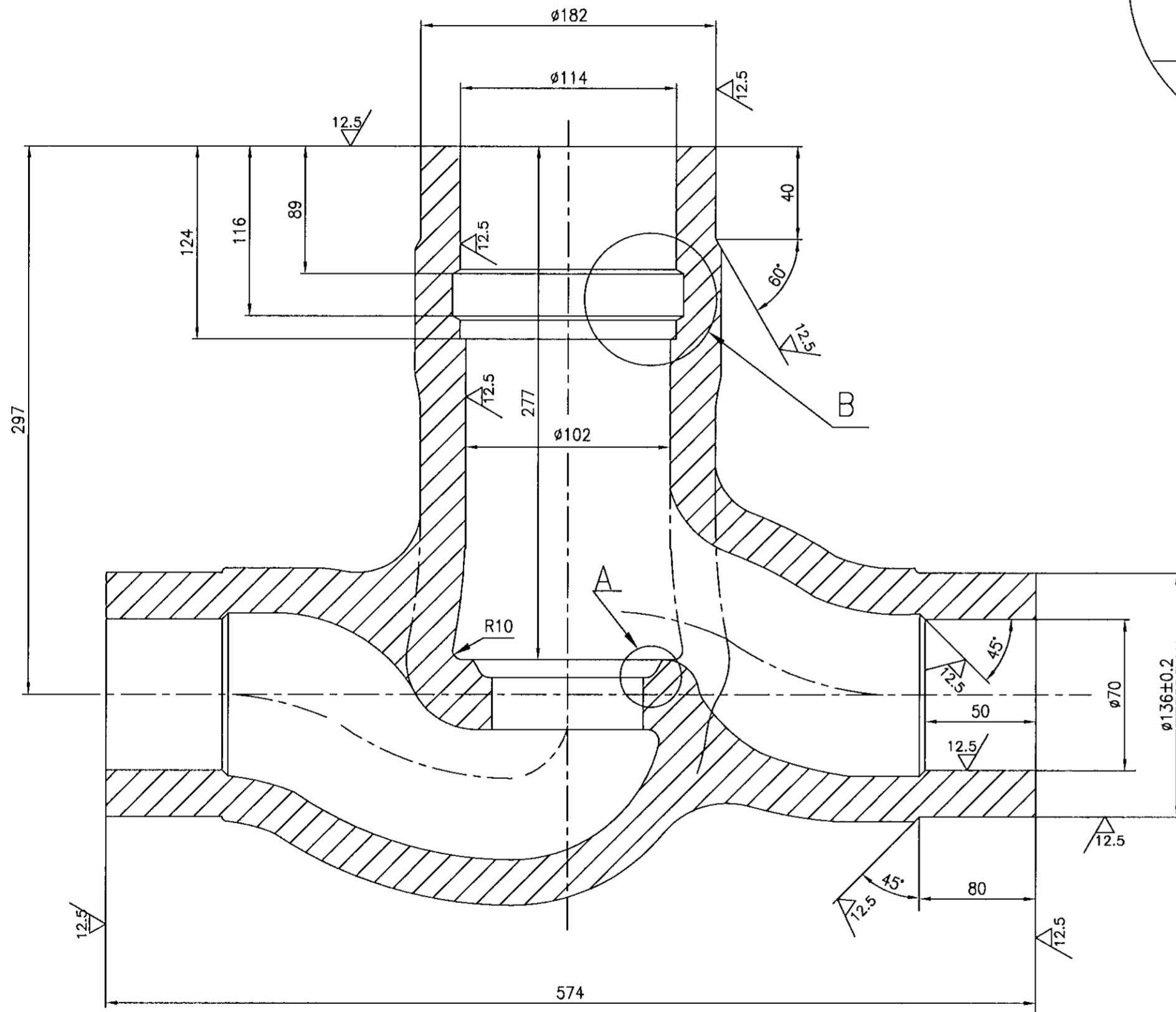
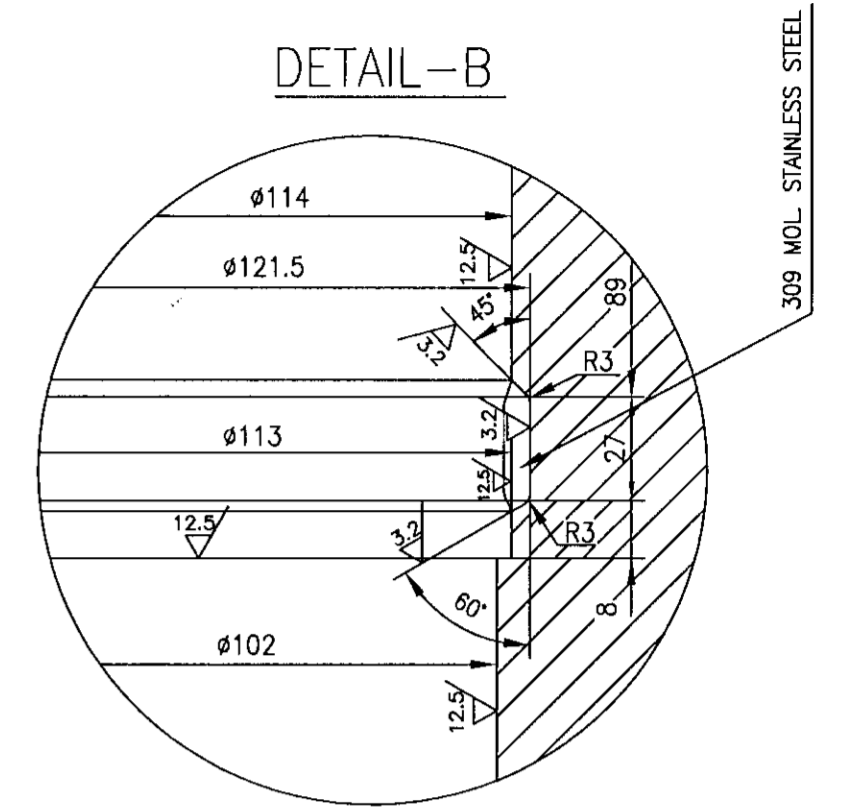
MACHINING BEFORE
STELLITE-6 WELD



MACHINING BEFORE
BUFFER LAYER WELD



DETAIL-B



NOTES:-

- * MARKED TYPES ARE SPECIAL CLASS RATINGS.
- LATEST APPLICABLE QUALITY WORK INSTRUCTION SHALL BE FOLLOWED IN ALL RESPECTS

SL. NO.	DRAWING NO.	MATERIAL SPECIFICATION	COMP. CODE	SCRAP SORT
* 08	2-V-G029-15036/3	A 217 WC9, NT	93 111 274 8000	20
* 07	2-V-G028-15036/3	A 217 WC6, NT	93 111 273 8000	20
* 06	2-V-G027-15036/3	A 216 WCC, AN	93 111 272 8000	10
* 05	2-V-G019-15036/3	A 216 WCB, AN	93 111 271 8000	10
04	2-V-G013-15036/3	A 217 WC9, NT	93 111 270 8000	20
03	2-V-G012-15036/3	A 217 WC6, NT	93 111 269 8000	20
02	2-V-G011-15036/3	A 216 WCC, AN	93 111 268 8000	10
01	2-V-G003-15036/3	A 216 WCB, AN	93 111 267 8000	10

No OFF	DESCRIPTION	MATL CODE	MATL SPECH	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No

CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. 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: REDRAWN WITH REV.No.3 ON 04-12-04

DRN	V.BAIRAVAN	SIGN	DATE	NO.OF VAR.
CHD	K.RAJASEKARAN		04-12-04	
APPD	M.RAJKUMAR		04-12-04	

DEPT: VL
SCALE: N.T.S
WEIGHT (KG):
REFERENCE INFORMATION: 3-E25621 (0328)
CAD:REF:T215036

TITLE: BODY (ROUGH)
4"/2500 CL.

CARD CODE: U 01
DRAWING NO: 2-V-0000-15036
REV: 3

REV	DATE	ALTERED	V.B
3	04-12-04	CHD & APPD	KRS&MRK
ZONE: E309 BUFFER WELD INCLUDED			
DCP No. 800397			

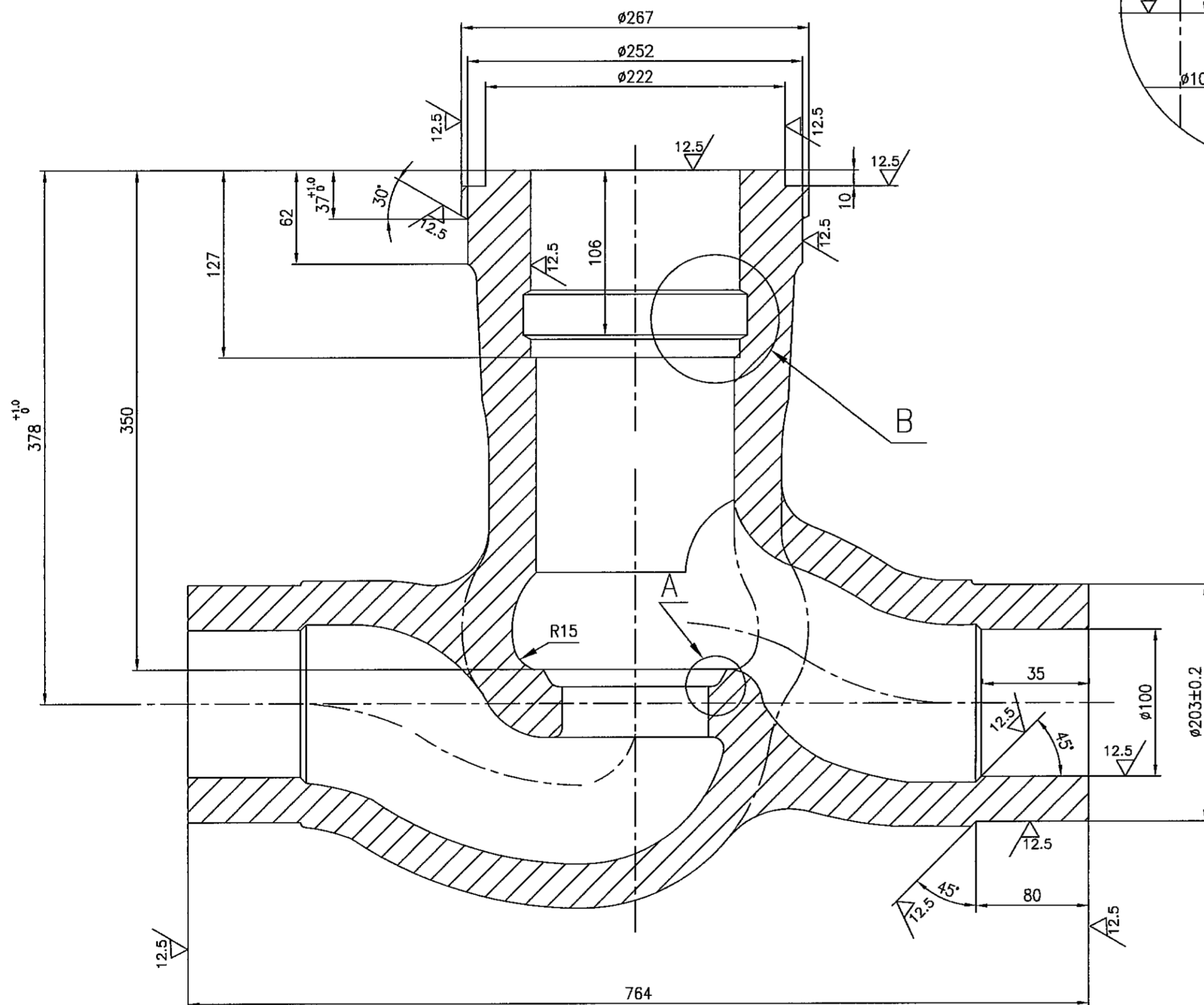
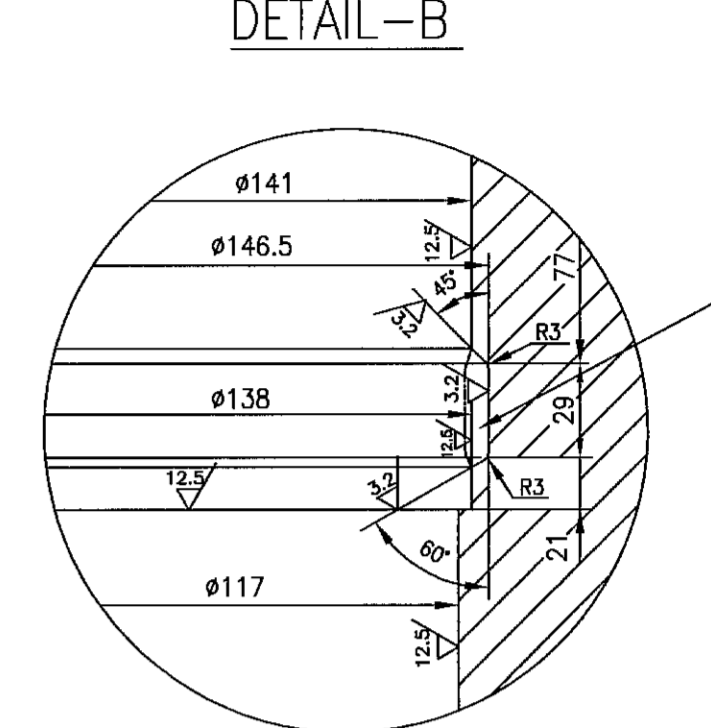
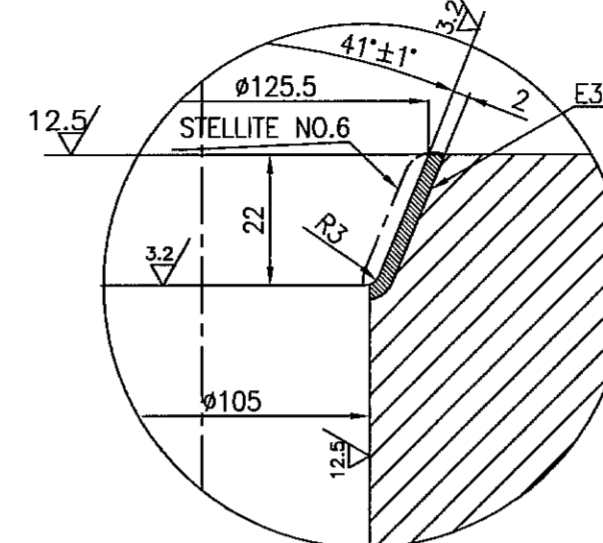
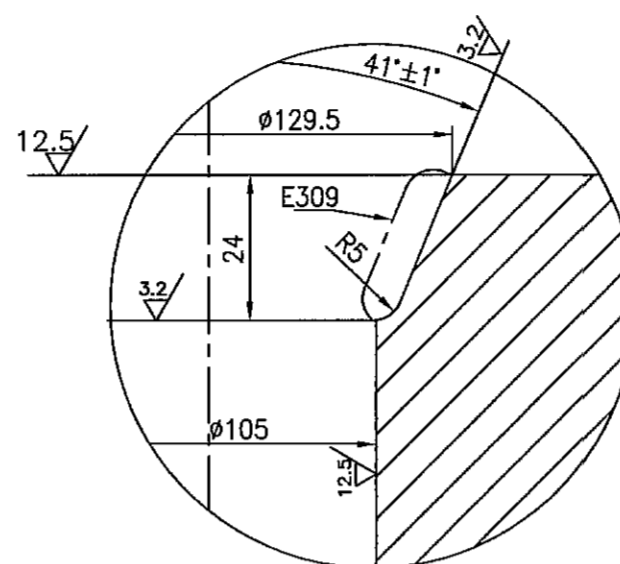
DETAIL-A

① 12.5/ 3.2/

MACHINING BEFORE
BUFFER LAYER WELD

MACHINING BEFORE
STELLITE-6 WELD

DETAIL-B



NOTES:-

- * MARKED TYPES ARE SPECIAL CLASS RATINGS.
- LATEST APPLICABLE QUALITY WORK INSTRUCTION SHALL BE FOLLOWED IN ALL RESPECTS

SL. NO.	DRAWING NO.	MATERIAL SPECIFICATION	COMP. CODE	SCRAP SORT
* 08	2-V-G026-15089/5	A217 WC9, NT	93 111 912 8000	20
* 07	2-V-G025-15089/5	A217 WC6, NT	93 111 911 8000	20
* 06	2-V-G024-15089/5	A216 WCC, AN	93 111 910 8000	10
* 05	2-V-G018-15089/5	A216 WCB, AN	93 111 909 8000	10
04	2-V-G010-15089/5	A217 WC9, NT	93 111 908 8000	20
03	2-V-G009-15089/5	A217 WC6, NT	93 111 907 8000	20
02	2-V-G008-15089/5	A216 WCC, AN	93 111 913 8000	10
01	2-V-G002-15089/5	A216 WCB, AN	93 111 906 8000	10

No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: REDRAWN WITH REV.No.5 ON 04.12.04

DRN	NAME	SIGN	DATE	NO.OF VAR.
	V.BAIRAVAN		4.12.04	
CHD	K.RAJASEKARAN		4.12.04	
APPD	M.RAJKUMAR		4.12.04	

DEPT	VL	SCALE	WEIGHT (KG)	REFERENCE INFORMATION	NO. OF ITEMS
365-120		N.T.S		3-E26065/1 (0238) CAD:REF:T215089	

TITLE	CARD CODE	DRAWING NO.	REV
BODY (ROUGH) 6"/1500 CL.	U 01	2-V-0000-15089	5

REV	DATE	ALTERED	V.B
5	4.12.04	CHD & APPD KRS&MRK	
E309 BUFFER WELD INCLUDED			
DCP No. 800397			

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DRAWING NO. 2-V-0000-16649/1

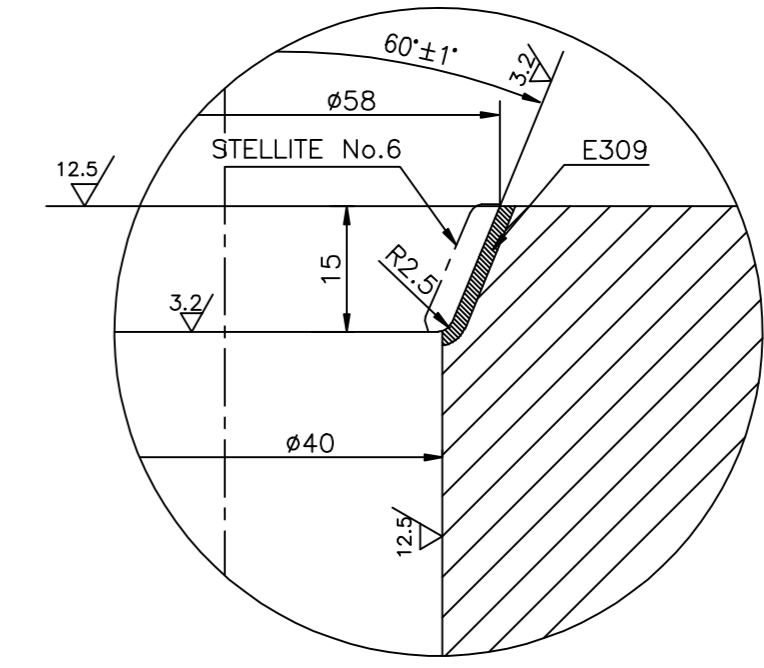
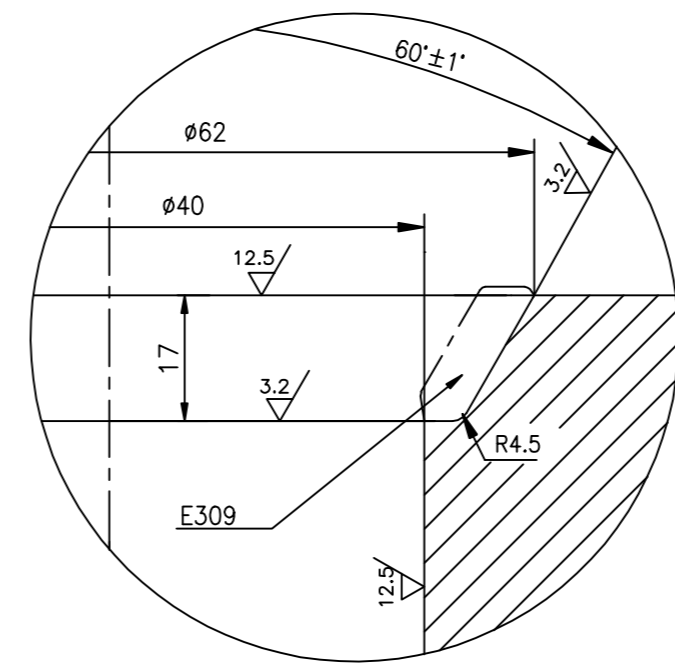
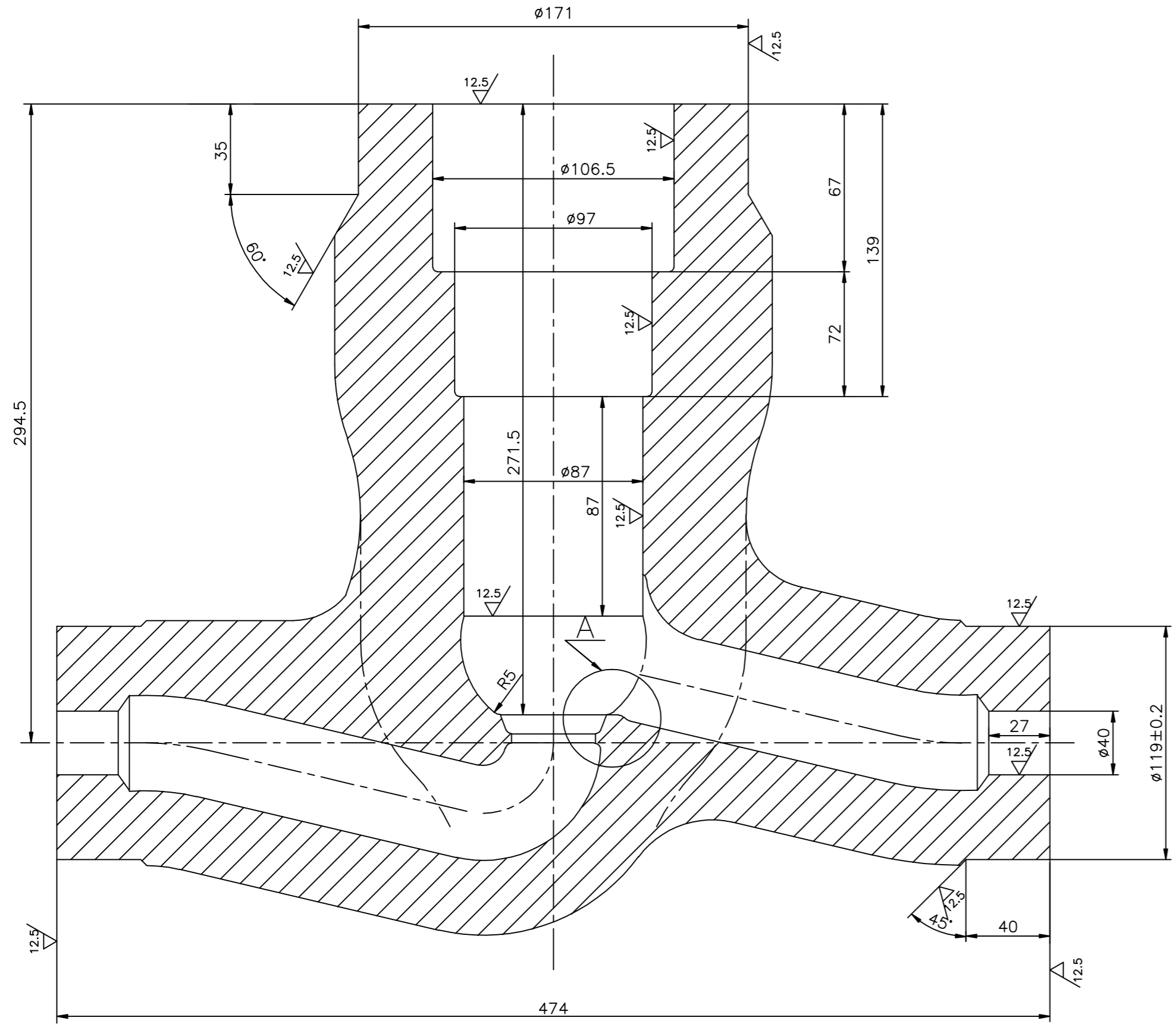
ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

DETAIL-A

① $\nabla / 12.5$ $\nabla / 3.2$

MACHINING BEFORE
BUFFER LAYER WELD

MACHINING BEFORE
STELLITE-6 WELD



NOTES:

1. LATEST APPLICABLE QUALITY WORK INSTRUCTION SHALL BE FOLLOWED IN ALL RESPECTS.
2. * MARKED TYPE IS SPECIAL CLASS RATING.

03	2-V-R647-16649	A217 WC9, ATTEST, NT	93 123 399 8000		20
*02	2-V-R460-16649	A217 C12A, ATTEST, NT	93 123 239 8000		20
01	2-V-R459-16649	A217 C12A, ATTEST, NT	93 123 227 8000		10
SL. NO.	DRAWING NO.	MATERIAL SPECN.	COMP. CODE		SCRAP SORT

No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
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TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

	BHARAT HEAVY ELECTRICALS LTD. UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI - 620014.		DRN	V.BAIRAVAN	SIGN	DATE	NO.OF VAR.
	CHD	K.RAJASEKARAN				22.11.06	
	APPD	M.RAJAKUMAR				22.11.06	

DEPT	VL	SCALE	WEIGHT (KG).	REFERENCE INFORMATION	NO. OF ITEMS
CODE	320	N.T.S		CAD:REF:T216649	
TITLE	BODY (ROUGH) (3"/3500 CL)		CARD CODE	DRAWING NO.	REV
			U 01	2-V-0000-16649	01

REV	DATE	ALTERED	: VB
01	08.02.10	CHD & APPD:	SSK&KRS
ZONE	S.NO:3 INCLUDED		

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DRAWING NO. 2-V-0000-16649/1

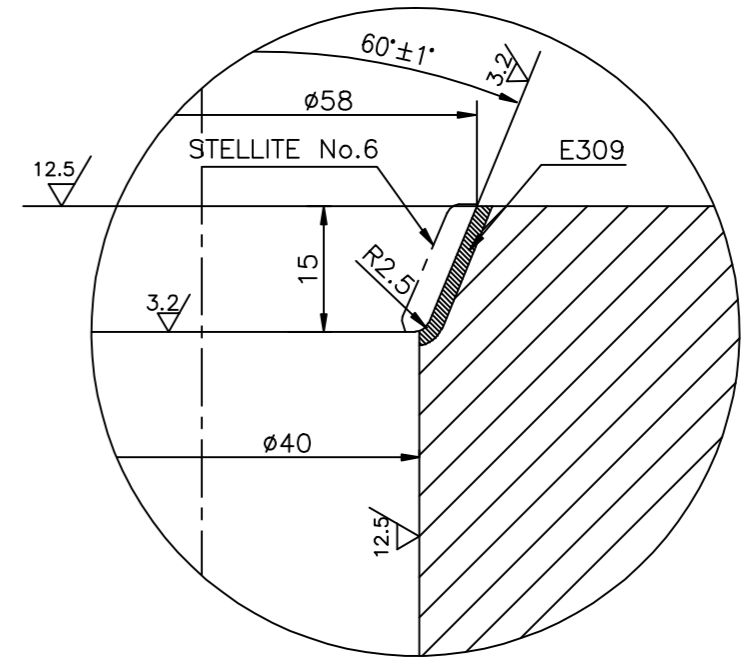
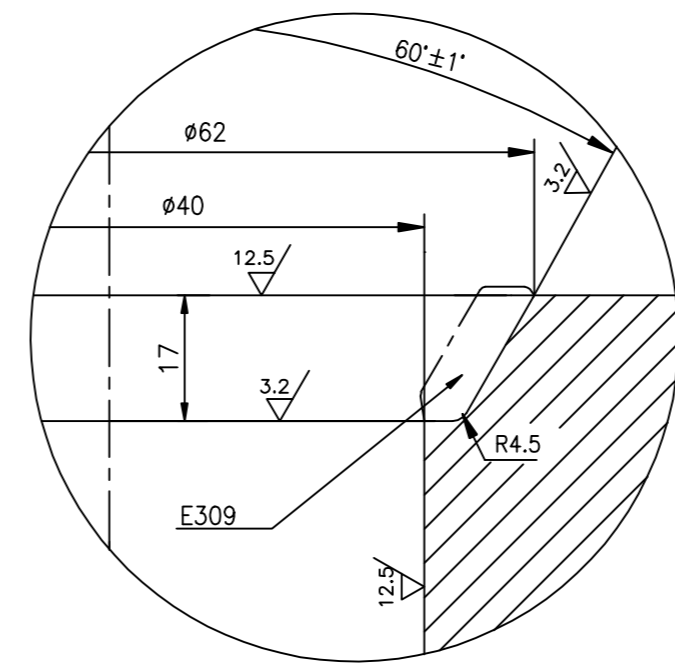
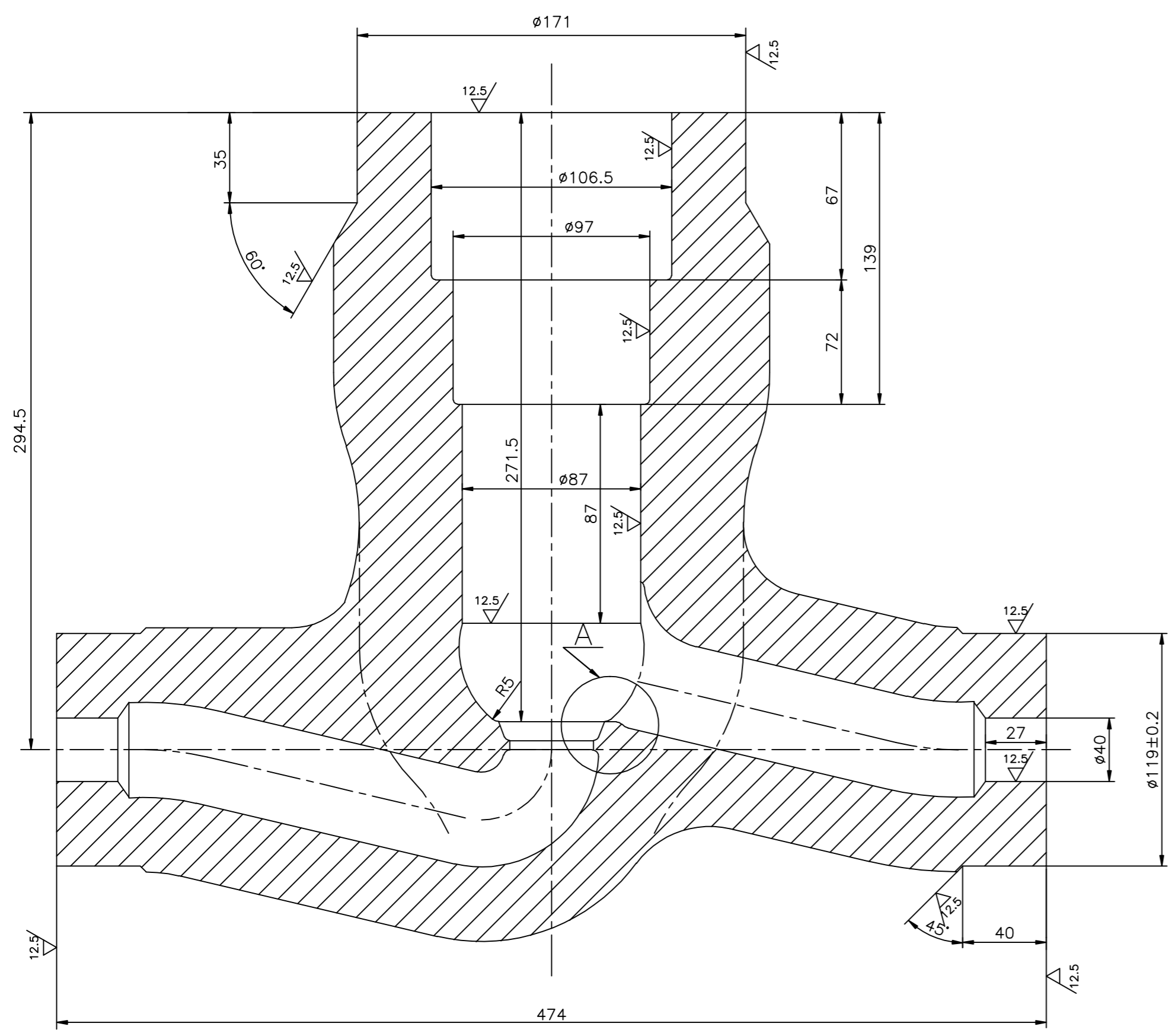
ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

DETAIL-A

① $\nabla / 12.5$ $\nabla / 3.2$

MACHINING BEFORE
BUFFER LAYER WELD

MACHINING BEFORE
STELLITE-6 WELD



NOTES:

1. LATEST APPLICABLE QUALITY WORK INSTRUCTION SHALL BE FOLLOWED IN ALL RESPECTS.
2. * MARKED TYPE IS SPECIAL CLASS RATING.

03	2-V-R647-16649	A217 WC9, ATTEST, NT	93 123 399 8000		20
*02	2-V-R460-16649	A217 C12A, ATTEST, NT	93 123 239 8000		20
01	2-V-R459-16649	A217 C12A, ATTEST, NT	93 123 227 8000		10
SL. NO.	DRAWING NO.	MATERIAL SPECN.	COMP. CODE		SCRAP SORT

No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
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TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

	BHARAT HEAVY ELECTRICALS LTD. UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI -620014.		DRN	V.BAIRAVAN	SIGN	DATE	NO.OF VAR.
	CHD	K.RAJASEKARAN				22.11.06	
	APPD	M.RAJAKUMAR				22.11.06	

DEPT	VL	SCALE	WEIGHT (KG).	REFERENCE INFORMATION	NO. OF ITEMS
CODE	320	N.T.S		CAD:REF:T216649	

TITLE	CARD CODE	DRAWING NO.	REV
BODY (ROUGH) (3"/3500 CL)	U 01	2-V-0000-16649	01

REV	DATE	ALTERED	BY
01	08.02.10	CHD & APPD: SSK&KRS	VB
ZONE	S.NO:3 INCLUDED		

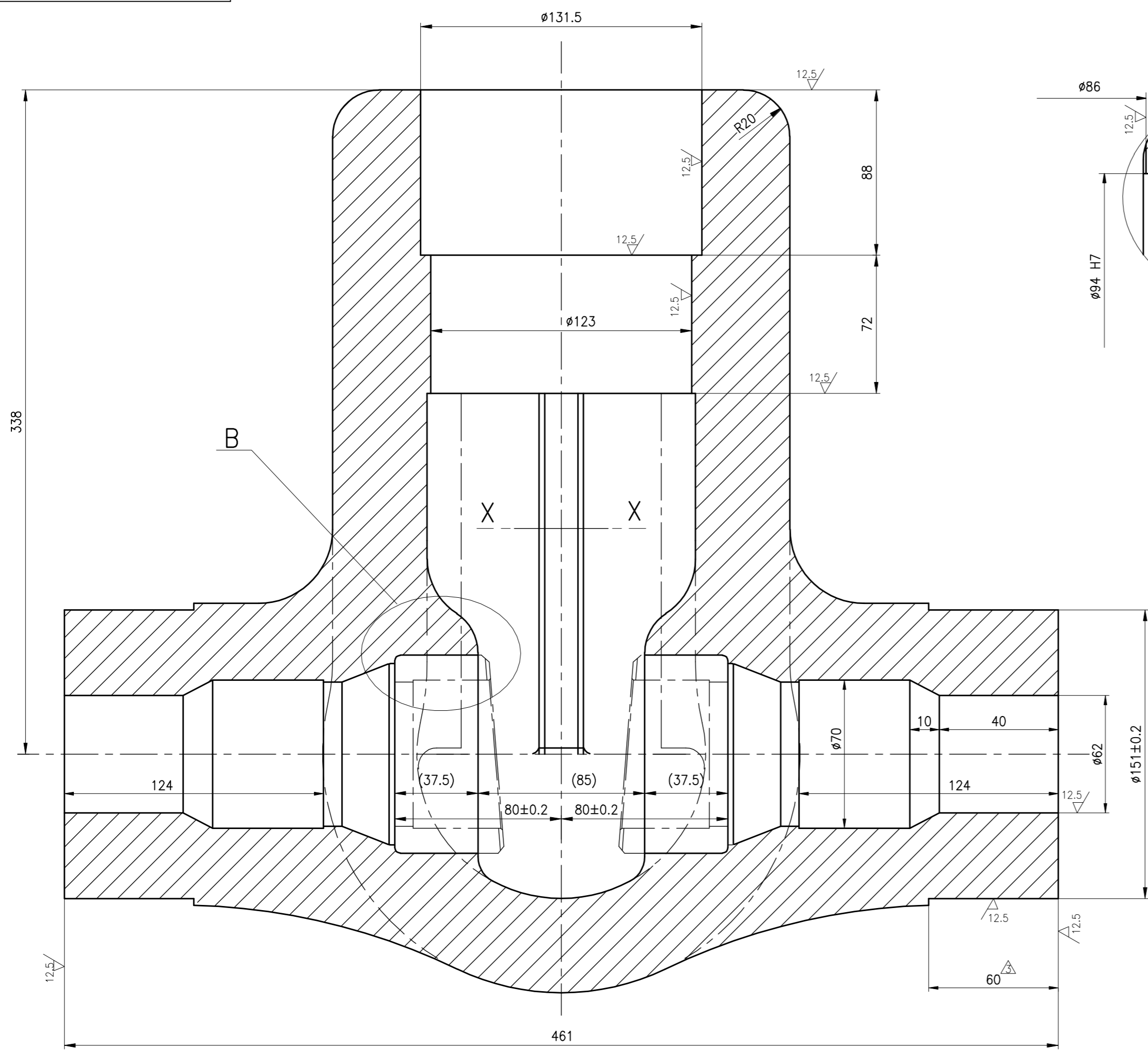
CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

2-V-0000-16959/3
DRAWING NO.

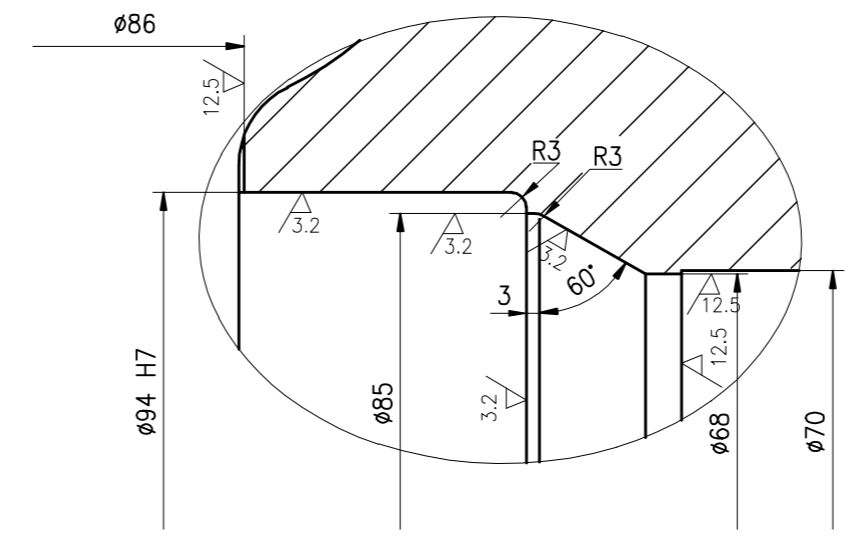
ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

12.5/3.2

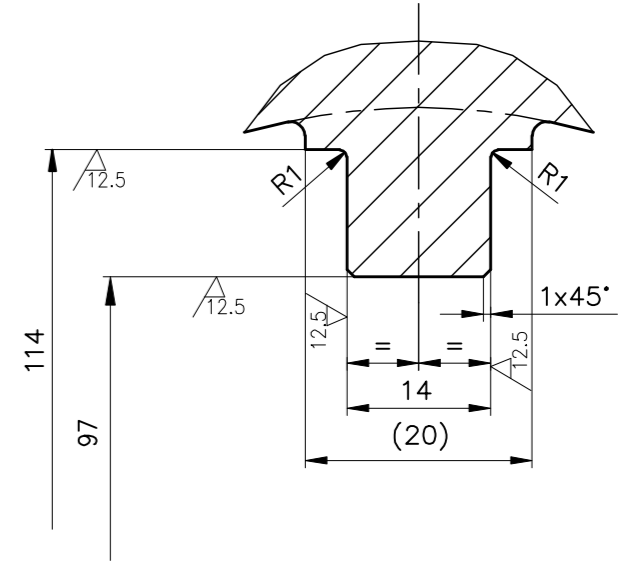
Ø94	+0.035
H7	0



DETAIL B



SECTION-XX



NOTE:

1. LATEST APPLICABLE QUALITY WORK INSTRUCTIONS SHALL BE FOLLOWED IN ALL RESPECTS.

02	2-V-WB73-16959/3	A217 WC9, ATTEST, NT	931243638000	20					
01	2-V-WB71-16959/3	A217 C12A, ATTEST, NT	931243628000	20					
SL NO.	DRAWING NO.	MATERIAL SPECIFICATION	COMP. CODE	SCRAP SORT					
No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No

REDRAWN WITH REV.3 ON 26.03.12

REV	DATE	ALTERED VB
3	26.03.12	CHD & APPD SSK & KRS
ZONE	DIMENSION 60 WAS 50	
DCP No.801305		

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TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT						
BHARAT HEAVY ELECTRICALS LTD. UNIT: HIGH PRESSURE BOILER PLANT. TIRUCHIRAPALLI - 620014.		DRN	NAME	SIGN	DATE	NO.OF VAR.
		CHD	S.SATHEES		26.03.12	
		APPD	K.RAJASEKARAN		26.03.12	
DEPT	VL	SCALE	WEIGHT (KG)	REFERENCE INFORMATIONS		
320		N T S				
TITLE	CARD CODE	DRAWING NO.	REV			
BODY (ROUGH MACHINING) 4"/2850 CL SPL	U 01	2-V-0000-16959	3			

DRAWING NO. 2-V-0000-16869/1

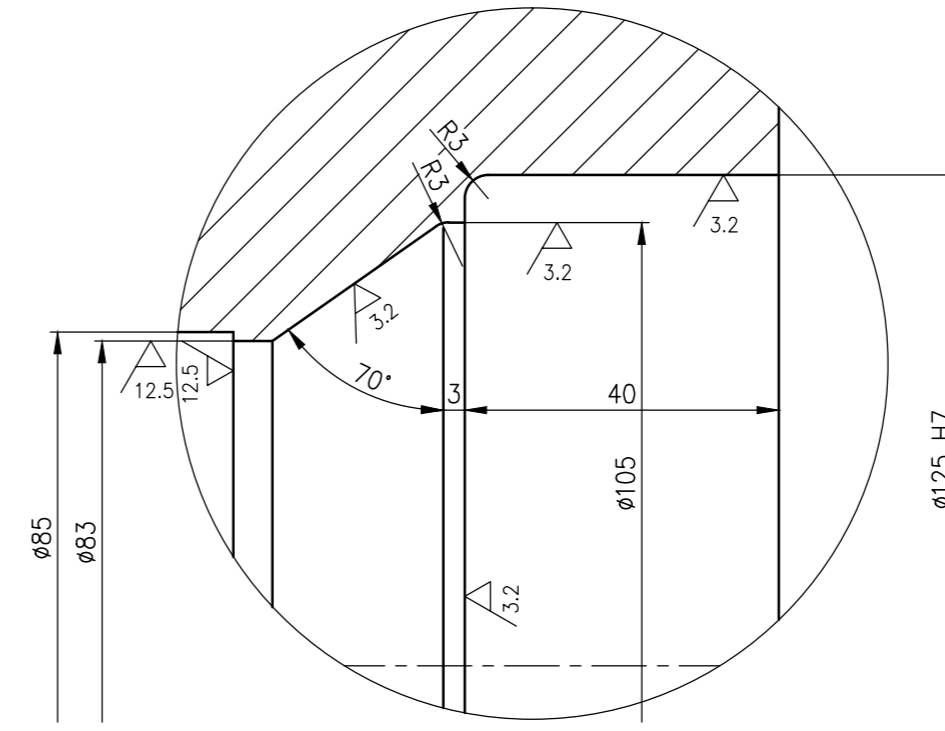
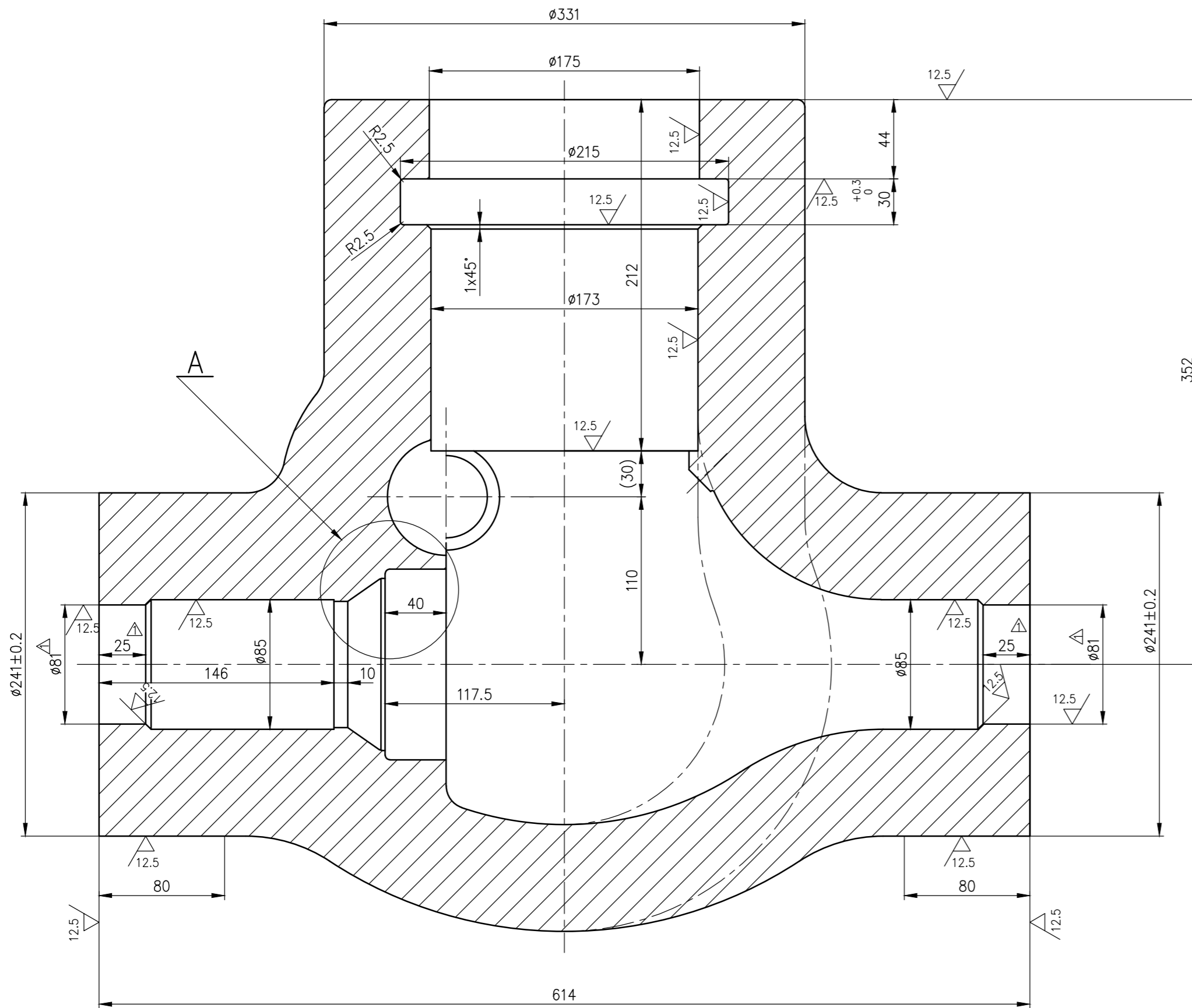
ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

DETAIL A

1

12.5 3.2

Ø125H7	+0.040
	0



NOTES:

- * MARKED TYPES ARE SPECIAL CLASS RATINGS.
- LATEST APPLICABLE QUALITY WORK INSTRUCTION SHALL BE FOLLOWED IN ALL RESPECTS.

SL No.	DRAWING No.	MATERIAL SPECN.	COMP. CODE	SCRAP SORT
*06	2-V-L413-16869/1	A217 C12A, NT,	93 123 925 8000	20
*05	2-V-L418-16869/1	A217 WC9, NT,	93 124 017 8000	20
*04	2-V-L417-16869/1	A216 WCC, AN,	93 124 016 8000	10
03	2-V-L416-16869/1	A217 C12A, NT,	93 124 015 8000	20
02	2-V-L415-16869/1	A217 WC9, NT,	93 124 014 8000	20
01	2-V-L414-16869/1	A216 WCC, AN,	93 124 013 8000	10

No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No
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TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT TA

DRN	NAME	SIGN	DATE	NO. OF VAR.
CHD	V.BAIRAVAN		15.11.08	
APPD	M.RAJASEKARAN		15.11.08	

DEPT	V L	SCALE	WEIGHT (KG)	REFERENCE INFORMATIONS	NO. OF ITEMS
320		N T S			

TITLE BODY (ROUGH)
MACHINING 6"/3500 CLASS

CARD CODE	DRAWING NO.	REV
U 01	2-V-0000-16869	1

REV	DATE	ALTERED VB
1	24.07.10	CHD & APPD SSK & KRS

ZONE DIMENSIONS Ø81 & 25 INCLUDED IN THE INLET AND OUTLET

DCP No.801073

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