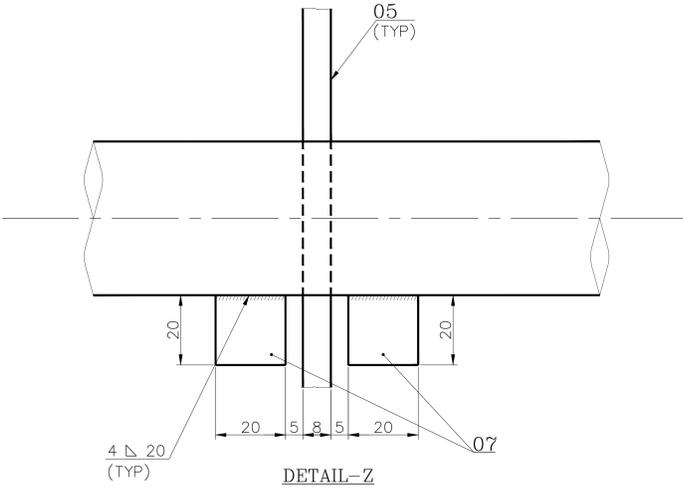
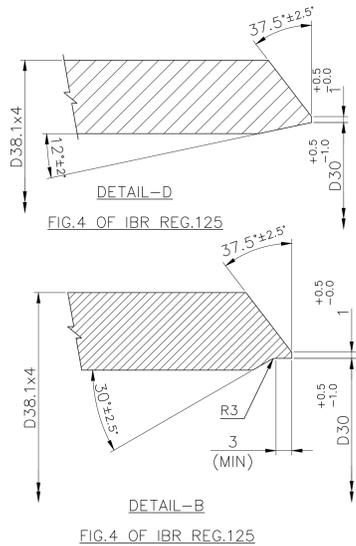
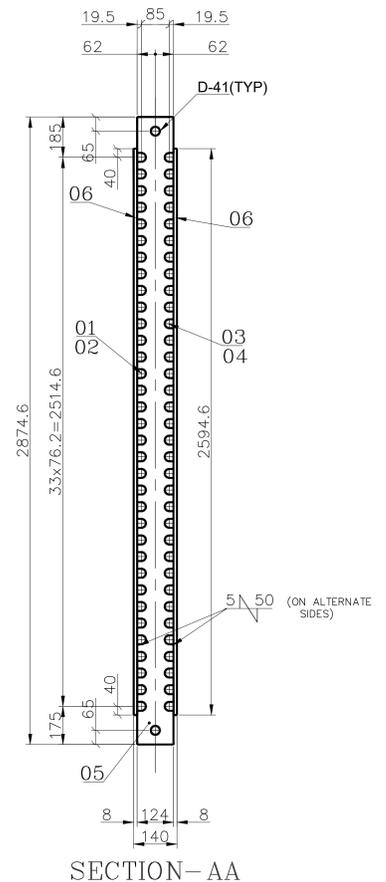
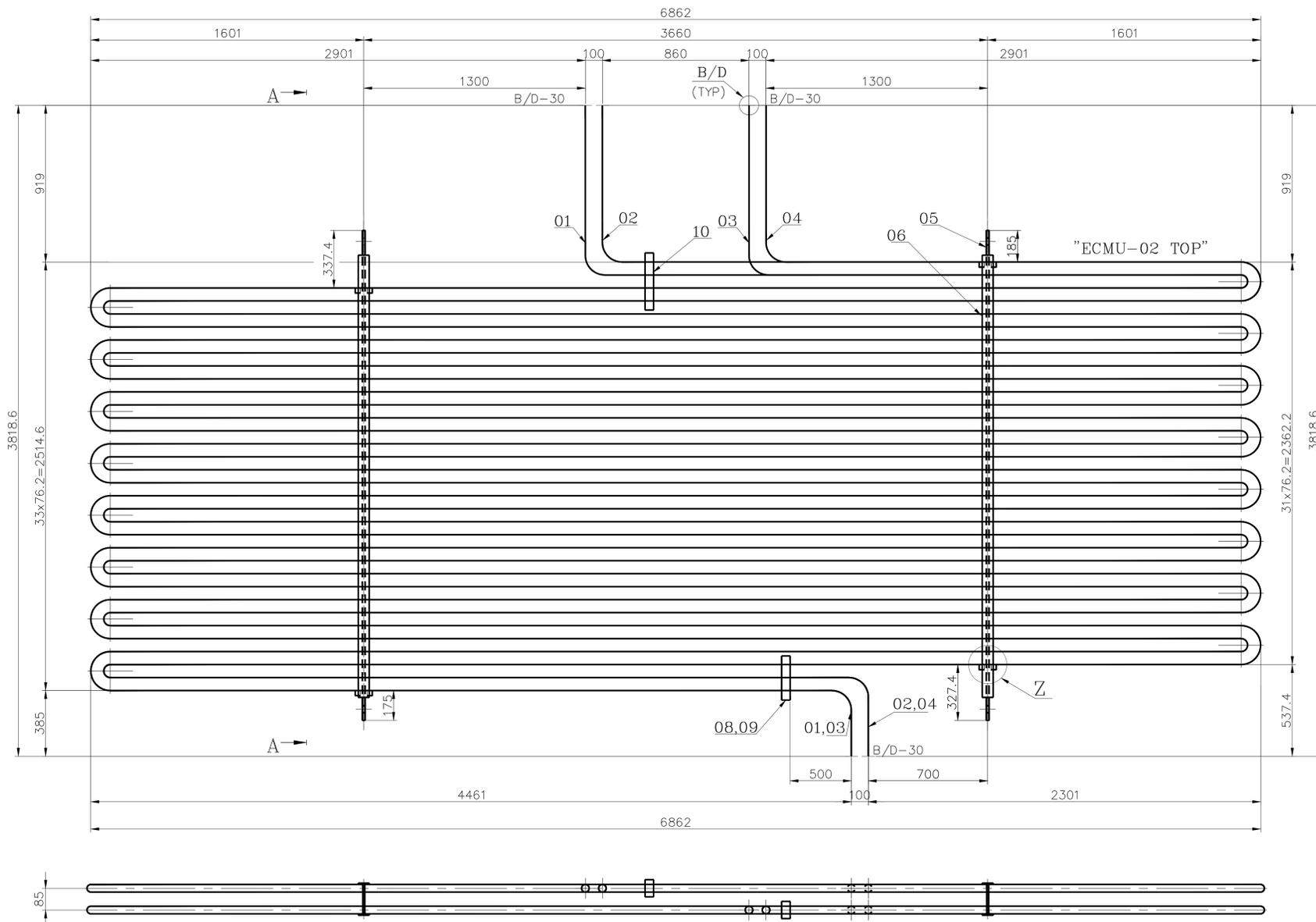


| VARIANT NUMBER | ITEM NUMBER | DESCRIPTION | STD | DRAWING NUMBER | ITEM NO VAR NO | MATERIAL CODE MATERIAL SPECN | A/G/P DI | UNIT QUANTITY | UNIT WEIGHT G/S | ZONE |
|----------------|-------------|--------------------------|-----|----------------|-------------------|---------------------------------|-------------|------------------|--------------------|------|
| | 08 | ALIGNMENT BAND | | 3-19-124-03693 | | WELDMENT | | 1.470 | 1 | |
| | 07 | PL: 5x20x20 | | | | 150110290000 IS2062GrA | | 0.020 | 16 | |
| | 06 | PL 8x32x2594.6 | | | | 150422780000 SA387Gr12CL2 | C | 5.210 | 4 | |
| | 05 | PANTO PLATE 8 THK | | 4-19-114-U8506 | | 150422780000 SA387Gr12CL2 | C | 15.500 | 2 | |
| | 04 | CIRCUIT-IV D38.1x4.0 | | 2-19-114-U8039 | | AA1049046099 SA210GrA1 | A | 402.500 | 1 | |
| | 03 | CIRCUIT-III D38.1x4.0 | | 2-19-114-U8038 | | AA1049046099 SA210GrA1 | A | 402.500 | 1 | |
| | 02 | CIRCUIT-II D38.1x4.0 | | 2-19-114-U8037 | | AA1049046099 SA210GrA1 | A | 410.200 | 1 | |
| | 01 | CIRCUIT-I D38.1x4.0 | | 2-19-114-U8036 | | AA1049046099 SA210GrA1 | A | 410.200 | 1 | |

- NOTES: -**
- DESIGN, MANUFACTURE & INSPECTION AS PER IBR.
 - DESIGN PRESSURE : 168.3 Kg/cm²(g)
 - DESIGN TEMPERATURE : 293+11=304°C
 - HEAT TREATMENT AS PER IBR.
 - BUTT WELD EDGE PREPARATION AS PER DETAIL-B/D
 - FABRICATION TOLERANCE AS PER DRG. 1-03-000-U6007.
 - RADIUS OF BEND R=38.1 AND R=114.3 TO BE USED.
 - HYDRAULIC TEST NEED NOT BE DONE AT SHOP.
 - QUANTITY TO BE PRODUCED : 61 NOS/BOILER
 - PAINT MARK NO : ECMU-01 (TOP)
 - MATERIALS OF EQUIVALENT/SUPERIOR SPECIFICATION & HIGHER THICKNESS ARE ACCEPTABLE FOR ALL ITEMS.
 - WELDING SEQUENCE AS PER PROCESS SHEET.
 - COIL ENDS ARE TO BE CLOSED BEFORE DESPATCH.
 - FOR SHOP WELDING "REFER RELEVANT WPS".
 - MIN. THICKNESS OF BENT TUBE AT ANY CROSS SECTION FOR TUBE D38.1x4-SA210GRA1 IS 3.0MM.

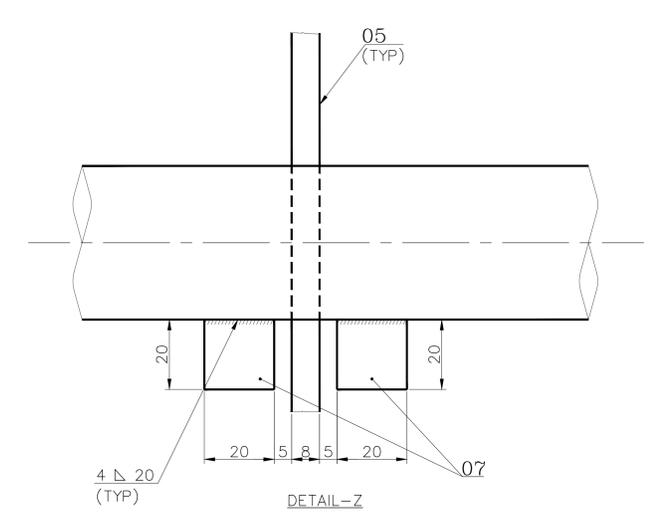
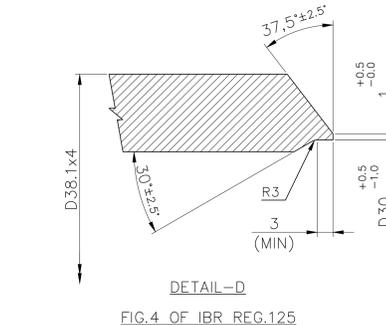
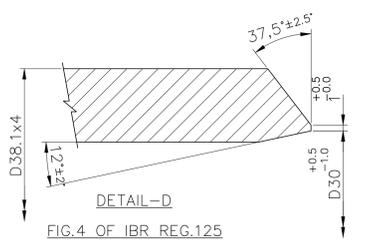


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|--|--|--|--|---|-----------------|
| CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used for any purpose other than that for which it was prepared or the interest of the company. | | TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT | | PROJECT : HINDALCO-SAMBALPUR BOILER MAKER NO. : 8136 | |
| DEPT HTE | | Bharat Heavy Electricals Ltd UNIT: HEAVY PLATES & VESSELS PLANT VISAKHAPATNAM - 530012 | | DRN RAJU | DATE 28-12-2025 |
| CODE 320 | | PROJECTION N.T.S | | CHD ANVK KISHORE | 01-01-2026 |
| REV 01 | | SCALE 1679.030 | | APPD K TARAKESH | 03-01-2026 |
| ZONE | | WEIGHT (Kg) 1-19-114-01949/02 | | REF TO ASSY / OLD DWG | |
| | | TITLE ECO. UPPER COIL ASSY. (ECMU-01) | | DRAWING NO : 1-19-114-U8129 | |
| | | | | REV 00 | |



| VARIANT NUMBER | ITEM NUMBER | DESCRIPTION | STD | DRAWING NUMBER | ITEM NO VAR NO | MATERIAL CODE MATERIAL SPECN | A/G/P UNIT DI | UNIT WEIGHT QUANTITY | OS | ZONE |
|----------------|-------------|---------------------------|-----|----------------|----------------|------------------------------|---------------|----------------------|----|------|
| | 10 | ALIGNMENT BAND | | 3-19-124-03693 | | WELDMENT | | 1.470 | | |
| | 09 | PLATE 6x50; 290.5 LONG | | | | 152110920000 | | 0.700 | | |
| | | | | | | IS2062GrA | | 2 | | |
| | 08 | ANGLE 50x50x6 125 LONG | | | | 150131560000 | | 0.560 | | |
| | | | | | | IS2062GrA | | 2 | | |
| | 07 | PL: 5x20x20 | | | | 150110290000 | | 0.020 | | |
| | | | | | | IS2062GrA | | 16 | | |
| | 06 | PL 8x32x2594.6 | | | | 150422780000 | C | 5.210 | | |
| | | | | | | SA387Gr12CL2 | | 4 | | |
| | 05 | PANTO PLATE 8 THK | | | | 150422780000 | C | 15.500 | | |
| | | | | | | SA387Gr12CL2 | | 2 | | |
| | 04 | CIRCUIT-VIII D38.1x4.0 | | | | AA1049046099 | A | 399.300 | | |
| | | | | | | SA210GrA1 | | 1 | | |
| | 03 | CIRCUIT-VII D38.1x4.0 | | | | AA1049046099 | A | 399.300 | | |
| | | | | | | SA210GrA1 | | 1 | | |
| | 02 | CIRCUIT-VI D38.1x4.0 | | | | AA1049046099 | A | 410.200 | | |
| | | | | | | SA210GrA1 | | 1 | | |
| | 01 | CIRCUIT-V D38.1x4.0 | | | | AA1049046099 | A | 410.200 | | |
| | | | | | | SA210GrA1 | | 1 | | |

- NOTES: -**
- DESIGN, MANUFACTURE & INSPECTION AS PER IBR.
 - DESIGN PRESSURE : 168.3 Kg/cm²(g)
 - DESIGN TEMPERATURE : 293+11=304°C
 - HEAT TREATMENT AS PER IBR.
 - BUTT WELD EDGE PREPARATION AS PER DETAIL-B/D
 - FABRICATION TOLERANCE AS PER DRG. 1-03-000-U6007.
 - RADIUS OF BEND R-38.1 AND R-114.3 TO BE USED.
 - HYDRAULIC TEST NEED NOT BE DONE AT SHOP.
 - QUANTITY TO BE PRODUCED : 6 NOS/BOILER
 - PAINT MARK NO : ECMU-02 (TOP)
 - ITEM NOS 08 & 09 ARE FOR TRANSPORTATION PURPOSE ONLY.
 - MATERIALS OF EQUIVALENT/SUPERIOR SPECIFICATION & HIGHER THICKNESS ARE ACCEPTABLE FOR ALL ITEMS.
 - WELDING SEQUENCE AS PER PROCESS SHEET.
 - COIL ENDS ARE TO BE CLOSED BEFORE DESPATCH.
 - FOR SHOP WELDING "REFER RELEVANT WPS".
 - MIN. THICKNESS OF BENT TUBE AT ANY CROSS SECTION FOR TUBE D38.1x4-SA210GRA1 IS 3.0MM.



| | | | |
|---|--|--|------------------------------------|
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| DEPT HTE CODE 320 | ALL DIMENSIONS ARE IN MM PROJECTION | SCALE N.T.S | WEIGHT (Kg) 1660.150 |
| TITLE ECO. UPPER COIL ASSY. (ECMU-02) | | DRN RAJU CHD ANVK KISHORE APPD K TARAKESH | NAME ANVK KISHORE K TARAKESH |
| REF TO ASSY / OLD DWG 1-19-114-01950/02 | | DATE 28-12-2025 01-01-2026 03-01-2026 | DRAWING NO : 1-19-114-U8130 |
| REV DATE ALTERED : CHD & APPD : | | ZONE | REV 00 |

BRAWG NO. 1-19-124-U8131

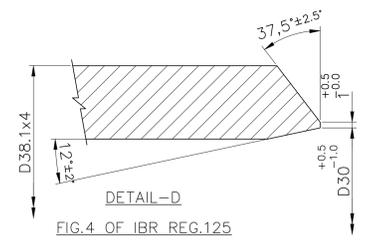
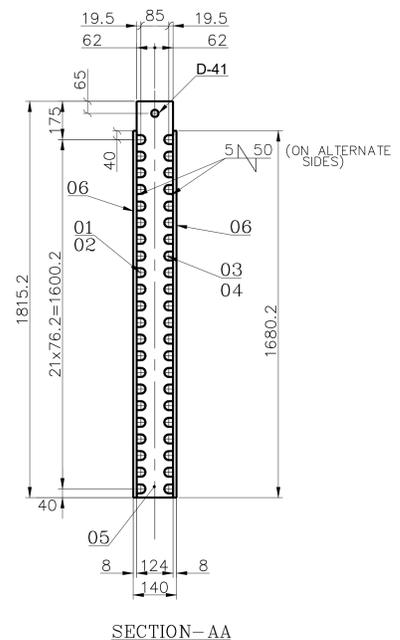
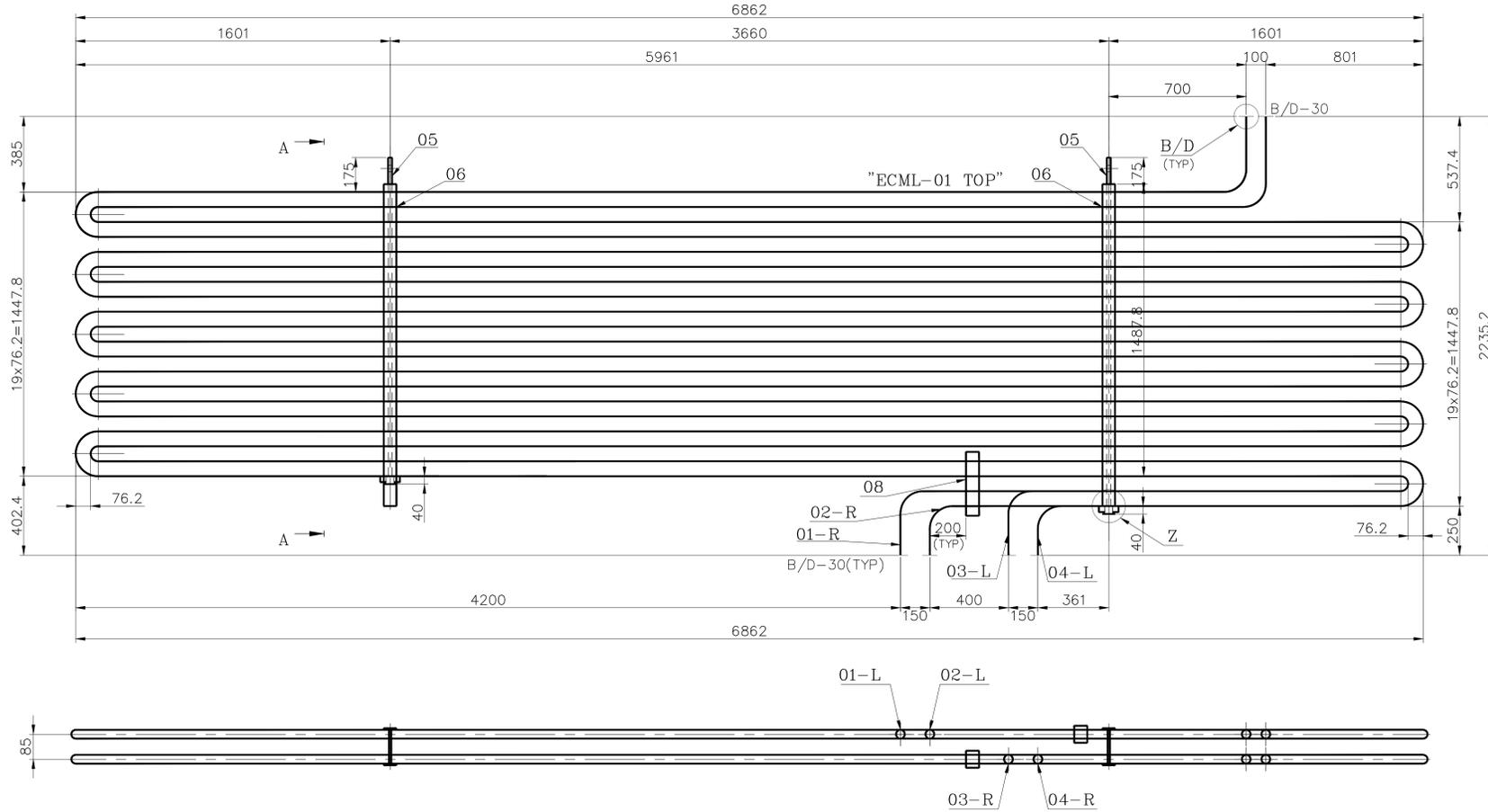


FIG.4 OF IBR REG.125

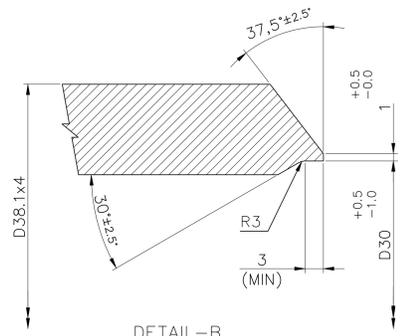
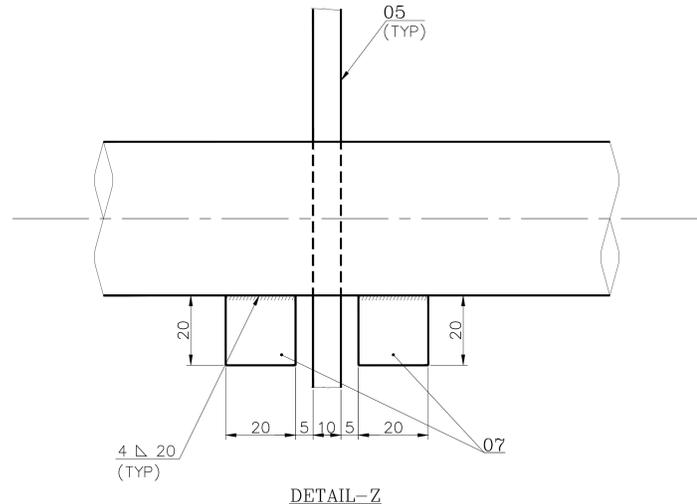


FIG.4 OF IBR REG.125



DETAIL-Z

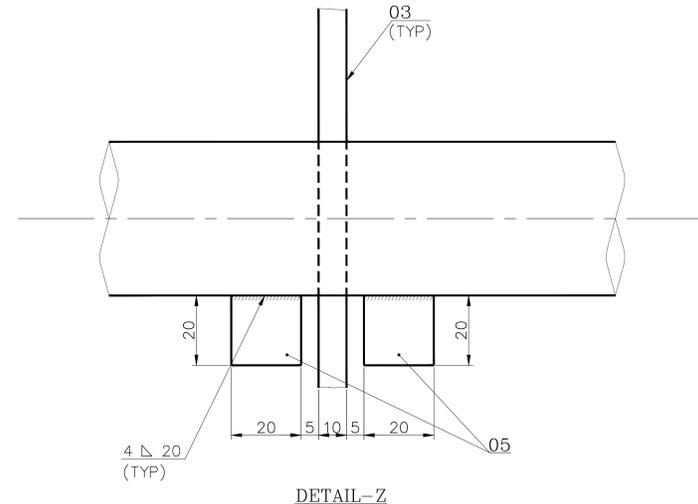
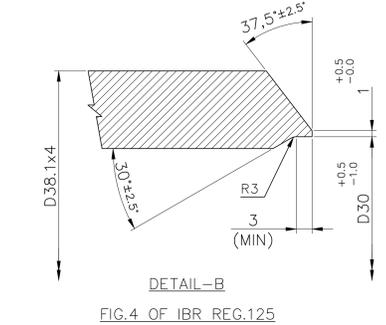
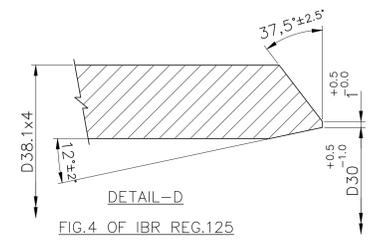
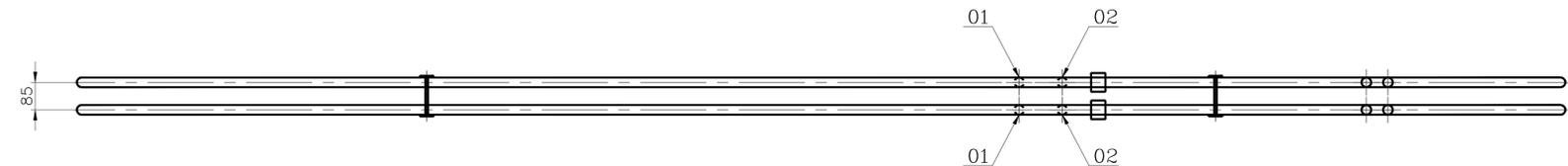
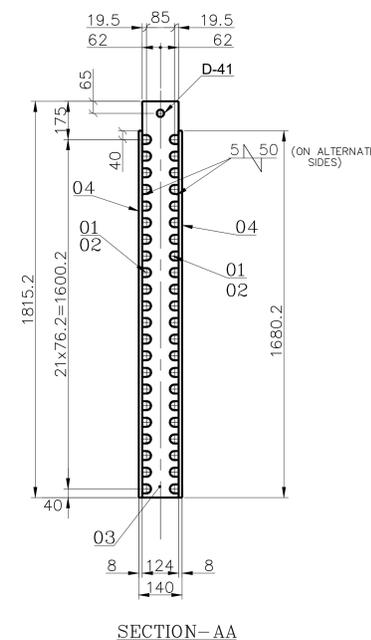
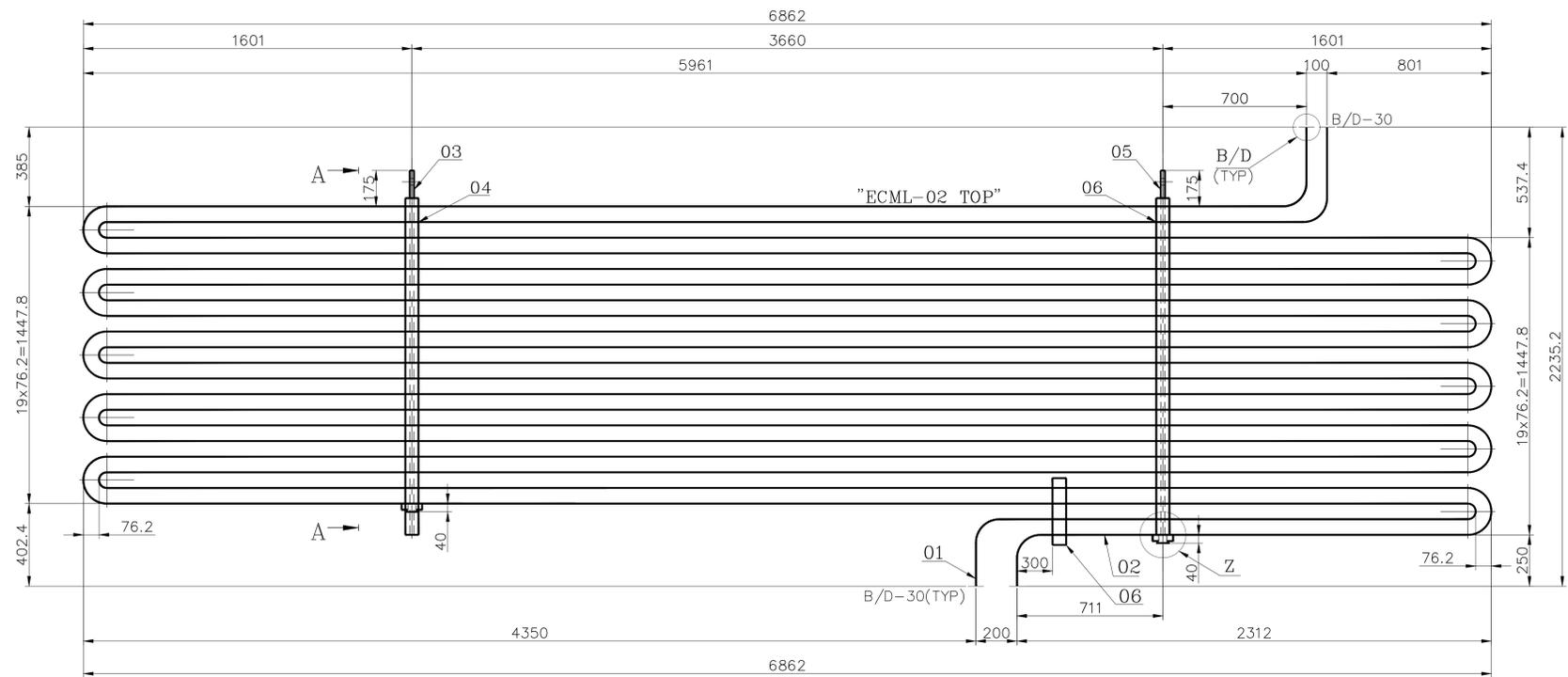
NOTES: -

1. DESIGN, MANUFACTURE & INSPECTION AS PER IBR.
2. DESIGN PRESSURE : 168.3 Kg/cm²(g)
3. DESIGN TEMPERATURE : 293+11=304°C
4. HEAT TREATMENT AS PER IBR.
5. BUTT WELD EDGE PREPARATION AS PER DETAIL-B/D
6. FABRICATION TOLERANCE AS PER DRG. 1-03-000-U6007.
7. RADIUS OF BEND R-38.1 AND R-114.3 TO BE USED.
8. HYDRAULIC TEST NEED NOT BE DONE AT SHOP.
9. QUANTITY TO BE PRODUCED : 1 NO/BOILER
10. PAINT MARK NO : ECML-01 (TOP)
11. ITEM NOS 08 & 09 ARE FOR TRANSPORTATION PURPOSE ONLY.
12. MATERIALS OF EQUIVALENT/SUPERIOR SPECIFICATION & HIGHER THICKNESS ARE ACCEPTABLE FOR ALL ITEMS.
13. WELDING SEQUENCE AS PER PROCESS SHEET.
14. COIL ENDS ARE TO BE CLOSED BEFORE DESPATCH.
15. FOR SHOP WELDING "REFER RELEVANT WPS".
16. MIN. THICKNESS OF BENT TUBE AT ANY CROSS SECTION FOR TUBE D38.1x4-SA210GRA1 IS 3.0MM.

| VARIANT NUMBER | ITEM NUMBER | DESCRIPTION | STD | DRAWING NUMBER | ITEM NO | MATERIAL CODE | UNIT | UNIT WEIGHT | ZONE |
|----------------|-------------|--------------------------|-----|----------------|---------|----------------|------|-------------|------|
| | | | | | VAR NO | MATERIAL SPECN | DI | QUANTITY | |
| | 08 | ALIGNMENT BAND | | 3-19-124-03692 | | WELDMNT | | 1.470 | |
| | | | | | | 150110290000 | | 1 | |
| | 07 | PL: 5x20x20 | | | | IS2062GrA | | 0.016 | |
| | | | | | | 150422780000 | | 16 | |
| | 06 | PL 8x32x1680.2 | | | | SA387Gr12CL2 | C | 3.380 | |
| | | | | | | 150422780000 | | 4 | |
| | 05 | PANTO PLATE 8 THK | | 4-19-124-U8507 | | SA387Gr12CL2 | C | 11.000 | |
| | | | | | | 150422780000 | | 2 | |
| | 04 | CIRCUIT-IV D38.1x4.0 | | 2-19-124-U8047 | | AA1049046099 | A | 251.700 | |
| | | | | | | SA210GrA1 | | 1 | |
| | 03 | CIRCUIT-III D38.1x4.0 | | 2-19-124-U8046 | | AA1049046099 | A | 251.870 | |
| | | | | | | SA210GrA1 | | 1 | |
| | 02 | CIRCUIT-II D38.1x4.0 | | 2-19-124-U8045 | | AA1049046099 | A | 253.660 | |
| | | | | | | SA210GrA1 | | 1 | |
| | 01 | CIRCUIT-I D38.1x4.0 | | 2-19-124-U8044 | | AA1049046099 | A | 253.850 | |
| | | | | | | SA210GrA1 | | 1 | |

| | | | | | |
|---|--|---|--|---|-----------------|
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| DEPT HTE | | Bharat Heavy Electricals Ltd | | DRN RAJU | DATE 02-01-2026 |
| CODE 320 | | UNIT: HEAVY PLATES & VESSELS PLANT VISA KHAPATNAM - 530012 | | CHD ANVK KISHORE | 06-01-2026 |
| TITLE | | ECO.LOWER COIL ASSY. (ECML-01) | | APPD K TARAKESH | 08-01-2026 |
| SCALE N.T.S | | WEIGHT (Kg) 1048.326 | | REF TO ASSY / OLD DWG | |
| DRAWING NO : 1-19-124-U8131 | | DRAWING NO : 1-19-124-01942/01 | | REV 00 | |

BRAVING NO. 1-19-124-U8132



- NOTES: -**
- DESIGN, MANUFACTURE & INSPECTION AS PER IBR.
 - DESIGN PRESSURE : 168.3 Kg/cm²(g)
 - DESIGN TEMPERATURE : 293+11=304°C
 - HEAT TREATMENT AS PER IBR.
 - BUTT WELD EDGE PREPARATION AS PER DETAIL-B/D
 - FABRICATION TOLERANCE AS PER DRG. 1-03-000-U6007.
 - RADIUS OF BEND R-38.1 AND R-114.3 TO BE USED.
 - HYDRAULIC TEST NEED NOT BE DONE AT SHOP.
 - QUANTITY TO BE PRODUCED : 59 NOS/BOILER
 - PAINT MARK NO : ECML-02 (TOP)
 - ITEM NOS 08 & 09 ARE FOR TRANSPORTATION PURPOSE ONLY.
 - MATERIALS OF EQUIVALENT/SUPERIOR SPECIFICATION & HIGHER THICKNESS ARE ACCEPTABLE FOR ALL ITEMS.
 - WELDING SEQUENCE AS PER PROCESS SHEET.
 - COIL ENDS ARE TO BE CLOSED BEFORE DESPATCH.
 - FOR SHOP WELDING "REFER RELEVANT WPS".
 - MIN. THICKNESS OF BENT TUBE AT ANY CROSS SECTION FOR TUBE D38.1x4-SA210GRA1 IS 3.0MM.

| ITEM NUMBER | DESCRIPTION | STD | DRAWING NUMBER | ITEM NO | MATERIAL CODE | UNIT WEIGHT | ZONE |
|-------------|----------------------|----------------|----------------|---------|---------------|-------------|------|
| 06 | ALIGNMENT BAND | 3-19-124-03692 | | | | 1.470 | |
| | | | | | WELDMENT | 2 | |
| 05 | PL: 5x20x20 | | | | 150110290000 | 0.016 | |
| | | | | | IS2062GrA | 16 | |
| 04 | PL 8x32x1680.2 | | | | 150422780000 | 3.380 | |
| | | | | | SA387Gr12CL2 | 4 | |
| 03 | PANTO PLATE 8 THK | 4-19-124-U8507 | | | 150422780000 | 11.000 | |
| | | | | | SA387Gr12CL2 | 2 | |
| 02 | CIRCUIT-VI D38.1x4.0 | 2-19-124-U8049 | | | AA1049046099 | 252.950 | |
| | | | | | SA210GrA1 | 2 | |
| 01 | CIRCUIT-V D38.1x4.0 | 2-19-124-U8048 | | | AA1049046099 | 253.300 | |
| | | | | | SA210GrA1 | 2 | |

| | | | |
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| DEPT HTE CODE 320 | | NAME RAJU DATE 02-01-2026 | |
| ALL DIMENSIONS ARE IN MM PROJECTION SCALE N.T.S WEIGHT (Kg) 1051.216 | | DRN ANVK CHD ANVK KISHORE APPD K TARAKESH DATE 06-01-2026 DATE 08-01-2026 | |
| TITLE ECO.LOWER COIL ASSY. (ECML-02) | | REF TO ASSY / OLD DWG 1-19-124-01943/01 | |
| DRAWING NO : 1-19-124-U8132 | | REV 00 | |

| REV | DATE | ALTERED : |
|-----|------|--------------|
| | | CHD & APPD : |

1-19-124-U8133
DRAWING NO.

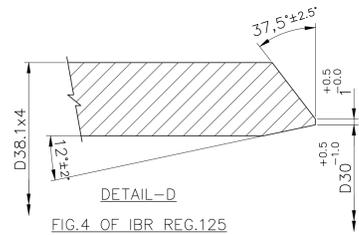
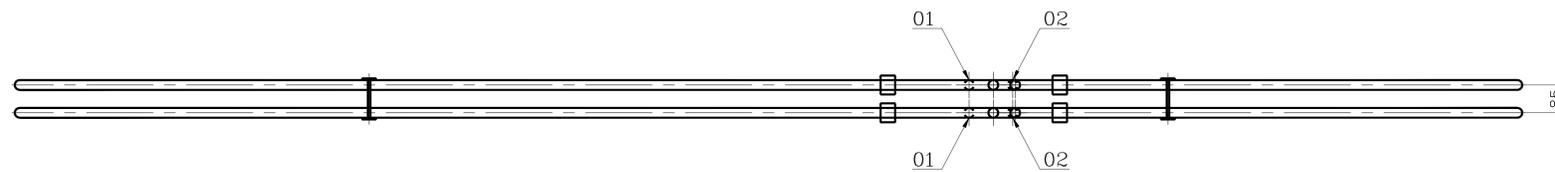
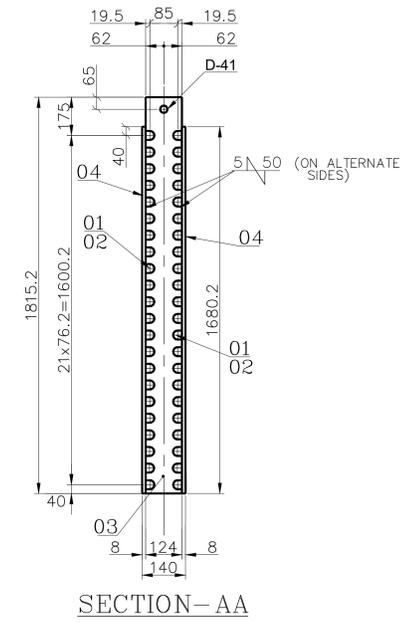
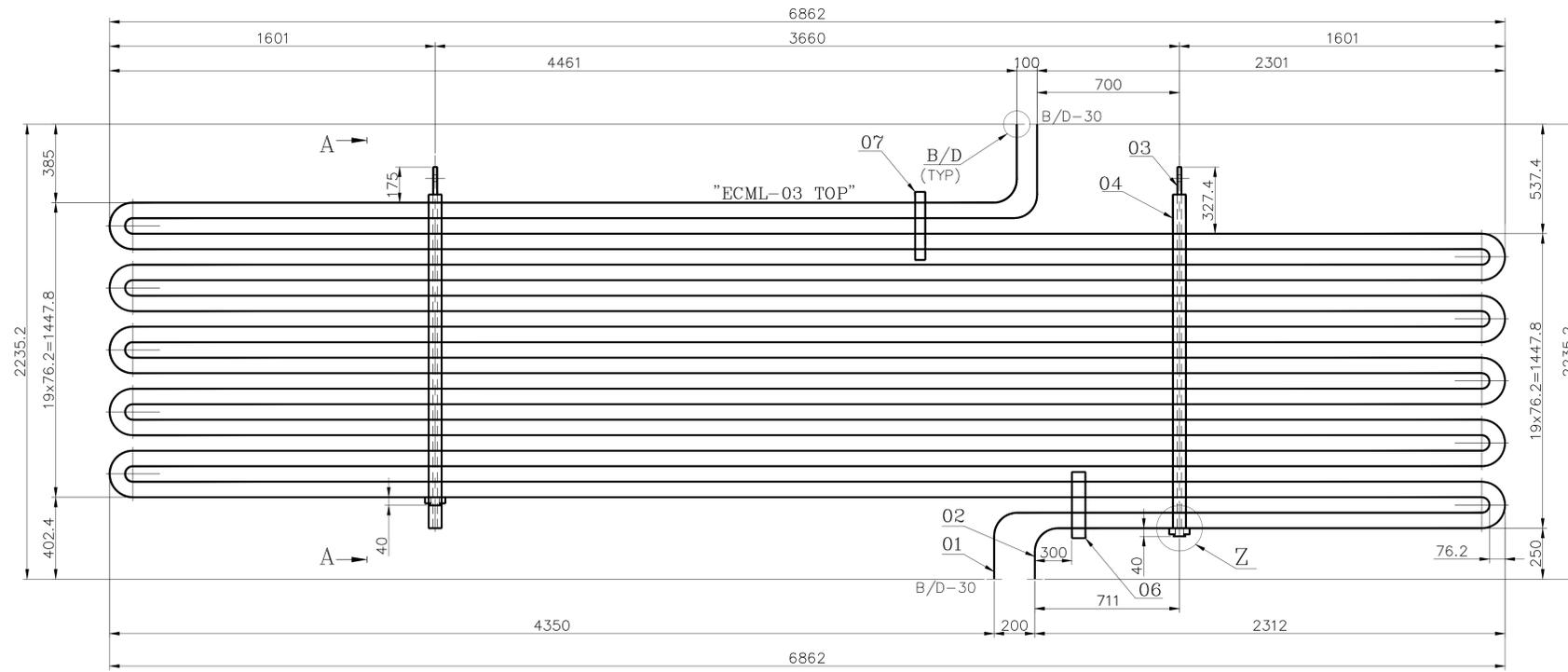
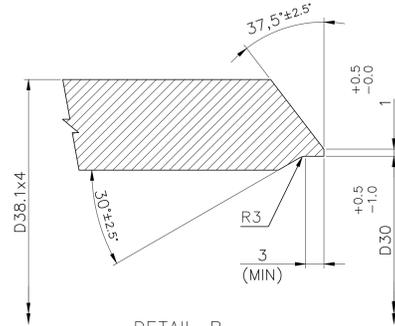
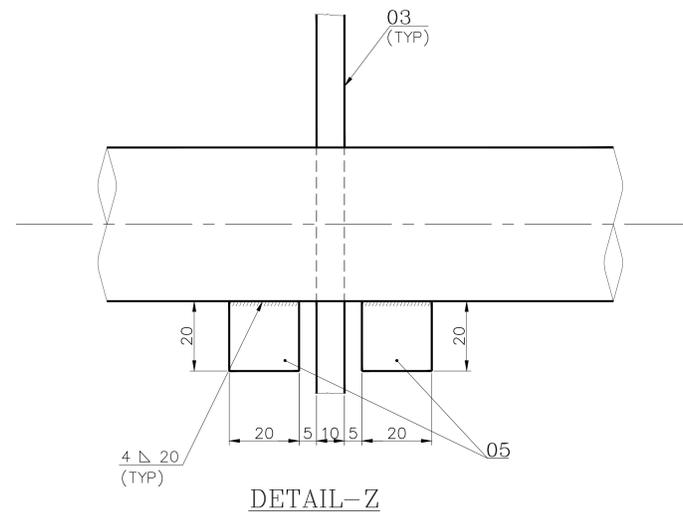


FIG.4 OF IBR REG.125



DETAIL-B
FIG.4 OF IBR REG.125



DETAIL-Z

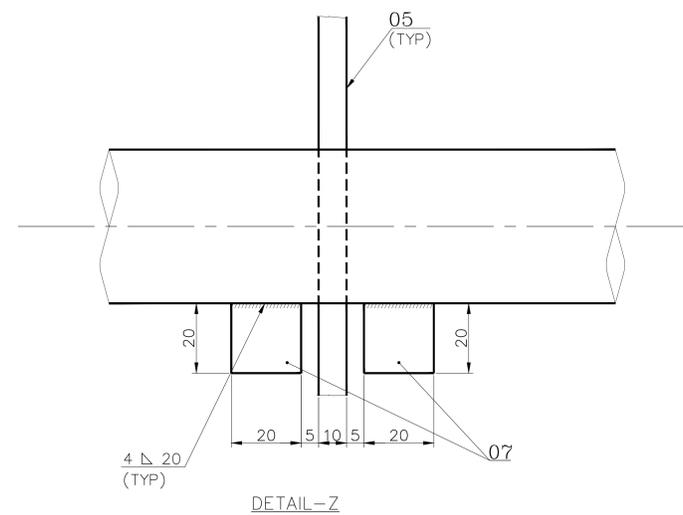
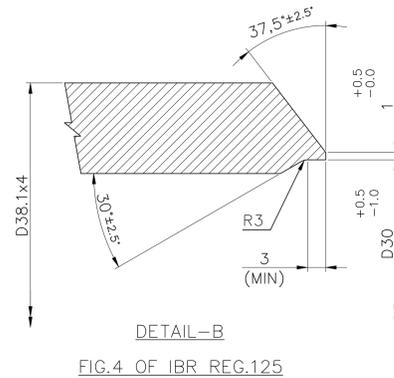
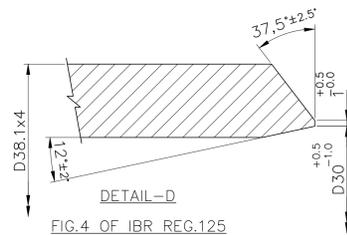
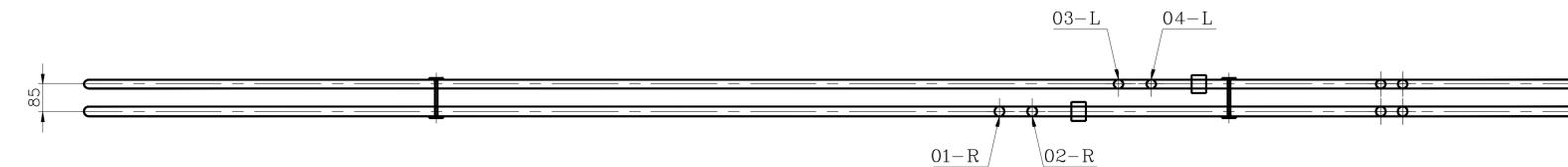
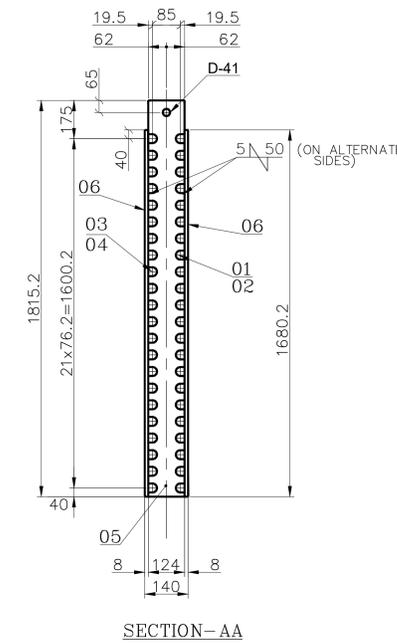
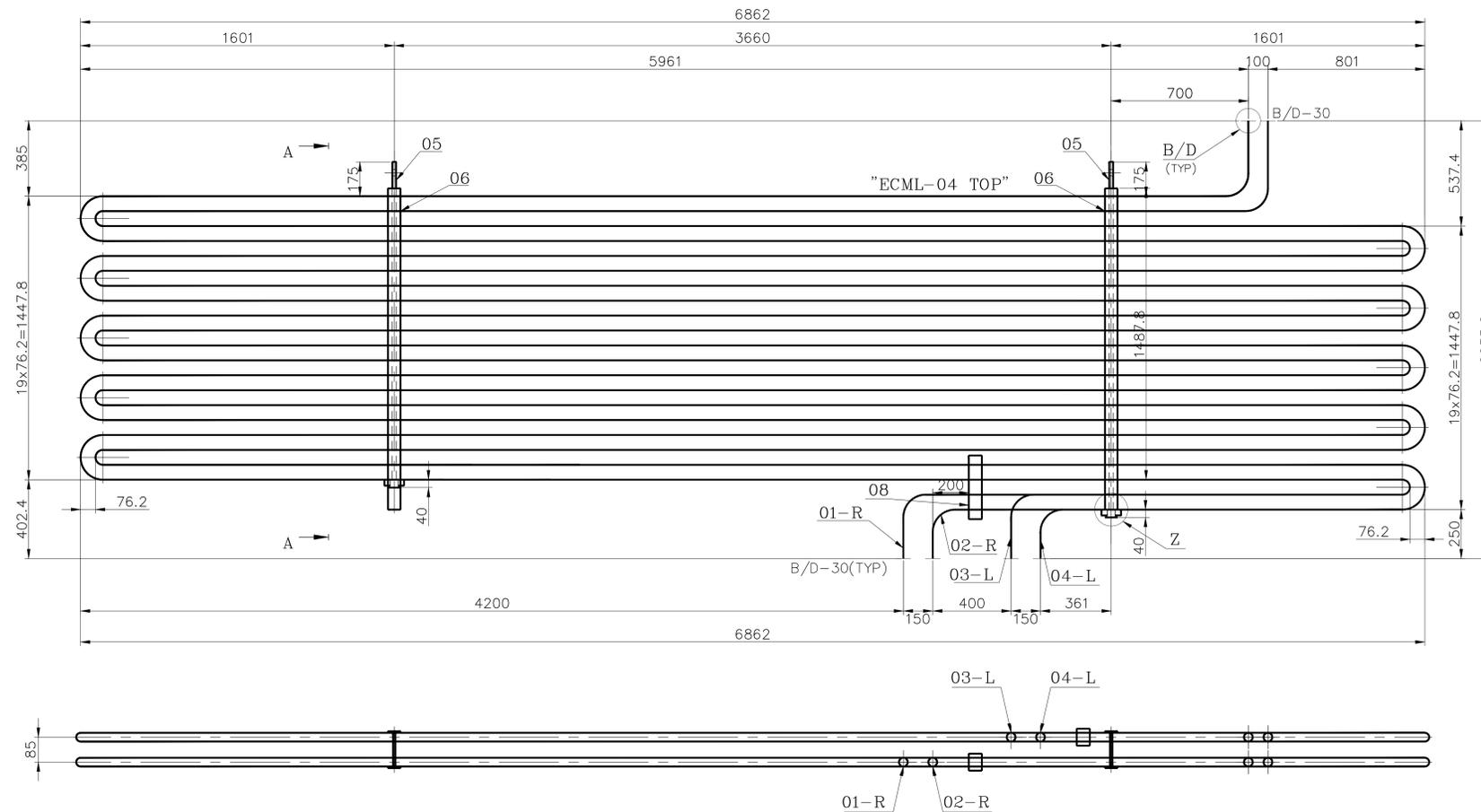
NOTES: -

1. DESIGN, MANUFACTURE & INSPECTION AS PER IBR.
2. DESIGN PRESSURE : 168.3 Kg/cm²(g)
3. DESIGN TEMPERATURE : 293+11=304°C
4. HEAT TREATMENT AS PER IBR.
5. BUTT WELD EDGE PREPARATION AS PER DETAIL-B/D
6. FABRICATION TOLERANCE AS PER DRG. 1-03-000-U6007.
7. RADIUS OF BEND R=38.1 AND R=114.3 TO BE USED.
8. HYDRAULIC TEST NEED NOT BE DONE AT SHOP.
9. QUANTITY TO BE PRODUCED : 6 NOS/BOILER
10. PAINT MARK NO : ECML-03 (TOP)
11. ITEM NOS 08 & 09 ARE FOR TRANSPORTATION PURPOSE ONLY.
12. MATERIALS OF EQUIVALENT/SUPERIOR SPECIFICATION & HIGHER THICKNESS ARE ACCEPTABLE FOR ALL ITEMS.
13. WELDING SEQUENCE AS PER PROCESS SHEET.
14. COIL ENDS ARE TO BE CLOSED BEFORE DESPATCH.
15. FOR SHOP WELDING "REFER RELEVANT WPS".
16. MIN. THICKNESS OF BENT TUBE AT ANY CROSS SECTION FOR TUBE D38.1x4-SA210GRA1 IS 3.0MM.

| VARIANT NUMBER | ITEM NUMBER | DESCRIPTION | STD | DRAWING NUMBER | ITEM NO | MATERIAL CODE | UNIT WEIGHT | GS | ZONE |
|----------------|----------------|------------------------|----------|----------------|---------|---------------|-------------|----|------|
| VAR NO | MATERIAL SPECN | DI | QUANTITY | | | | | | |
| | 07 | ALIGNMENT BAND | | 3-19-124-03693 | | WELDMENT | 1.470 | | |
| | | | | | | | 2 | | |
| | 06 | ALIGNMENT BAND | | 3-19-124-03692 | | WELDMENT | 1.470 | | |
| | | | | | | | 2 | | |
| | 05 | PL: 5x20x20 | | | | 150110290000 | 0.016 | | |
| | | | | | | IS2062GrA | 16 | | |
| | 04 | PL 8x32x1680.2 | | | | 150422780000 | 3.380 | | |
| | | | | | | SA387Gr12CL2 | 4 | | |
| | 03 | PANTO PLATE 8 THK | | 4-19-124-U8507 | | 150422780000 | 11.000 | | |
| | | | | | | SA387Gr12CL2 | 2 | | |
| | 02 | CIRCUIT-VIII D38.1x4.0 | | 2-19-124-U8051 | | AA1049046099 | 247.600 | | |
| | | | | | | SA210GrA1 | 2 | | |
| | 01 | CIRCUIT-VII D38.1x4.0 | | 2-19-124-U8050 | | AA1049046099 | 247.950 | | |
| | | | | | | SA210GrA1 | 2 | | |

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|--|---|--|--|--|------------------|-----------------|
| CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be reproduced or transmitted in any form or by any means electronic or mechanical, including photocopying, recording, or by any information storage or retrieval system, without the prior written permission of the company. | TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT | | PROJECT : HINDALCO-SAMBALPUR BOILER MAKER NO. : 8136 | | | |
| | DEPT HTE | | Bharat Heavy Electricals Ltd UNIT: HEAVY PLATES & VESSELS PLANT VISAKHAPATNAM - 530012 | | DRN RAJU | DATE 02-01-2026 |
| | CODE 320 | | PROJECTION N.T.S | | CHD ANVK KISHORE | 06-01-2026 |
| | TITLE ECO.LOWER COIL ASSY. (ECML-03) | | WEIGHT (Kg) 1032.756 | | APPD K TARAKESH | 08-01-2026 |
| DRAWING NO : 1-19-124-01944/01 | | | REV 00 | | | |

1-19-124-U8134
DRAWING NO.



NOTES: -

1. DESIGN, MANUFACTURE & INSPECTION AS PER IBR.
2. DESIGN PRESSURE : 168.3 Kg/cm²(g)
3. DESIGN TEMPERATURE : 293+11=304°C
4. HEAT TREATMENT AS PER IBR.
5. BUTT WELD EDGE PREPARATION AS PER DETAIL-B/D
6. FABRICATION TOLERANCE AS PER DRG. 1-03-000-U6007.
7. RADIUS OF BEND R-38.1 AND R-114.3 TO BE USED.
8. HYDRAULIC TEST NEED NOT BE DONE AT SHOP.
9. QUANTITY TO BE PRODUCED : 1 NO/BOILER
10. PAINT MARK NO : ECML-04 (TOP)
11. ITEM NOS 08 & 09 ARE FOR TRANSPORTATION PURPOSE ONLY.
12. MATERIALS OF EQUIVALENT/SUPERIOR SPECIFICATION & HIGHER THICKNESS ARE ACCEPTABLE FOR ALL ITEMS.
13. WELDING SEQUENCE AS PER PROCESS SHEET.
14. COIL ENDS ARE TO BE CLOSED BEFORE DESPATCH.
15. FOR SHOP WELDING "REFER RELEVANT WPS".
16. MIN. THICKNESS OF BENT TUBE AT ANY CROSS SECTION FOR TUBE D38.1x4-SA210GRA1 IS 3.0MM.

| VARIANT NUMBER | ITEM NUMBER | DESCRIPTION | STD | DRAWING NUMBER | ITEM NO | MATERIAL CODE | UNIT | UNIT WEIGHT | GS | ZONE |
|----------------|-------------|--------------------------|-----|----------------|---------|----------------|------|-------------|----|------|
| | | | | | VAR NO | MATERIAL SPECN | DI | QUANTITY | | |
| | 08 | ALIGNMENT BAND | | 3-19-124-03692 | | WELDMNT | | 1.470 | | |
| | 07 | PL: 5x20x20 | | | | 150110290000 | | 0.016 | | |
| | | | | | | IS2062GrA | | 16 | | |
| | 06 | PL 8x32x1680.2 | | | | 150422780000 | C | 3.380 | | |
| | | | | | | SA387Gr12CL2 | | 4 | | |
| | 05 | PANTO PLATE 8 THK | | 4-19-124-U8507 | | 150422780000 | C | 11.000 | | |
| | | | | | | SA387Gr12CL2 | | 2 | | |
| | 04 | CIRCUIT-IV D38.1x4.0 | | 2-19-124-U8047 | | AA1049046099 | A | 251.700 | | |
| | | | | | | SA210GrA1 | | 1 | | |
| | 03 | CIRCUIT-III D38.1x4.0 | | 2-19-124-U8046 | | AA1049046099 | A | 251.870 | | |
| | | | | | | SA210GrA1 | | 1 | | |
| | 02 | CIRCUIT-II D38.1x4.0 | | 2-19-124-U8045 | | AA1049046099 | A | 253.660 | | |
| | | | | | | SA210GrA1 | | 1 | | |
| | 01 | CIRCUIT-I D38.1x4.0 | | 2-19-124-U8044 | | AA1049046099 | A | 253.850 | | |
| | | | | | | SA210GrA1 | | 1 | | |

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| DEPT HTE CODE 320 | | DRN RAJU CHD ANVK KISHORE APPD K TARAKESH | |
| ALL DIMENSIONS ARE IN MM PROJECTION SCALE N.T.S WEIGHT (Kg) 1048.326 | | DATE 02-01-2026 REF TO ASSY / OLD DWG 1-19-124-01945/01 | |
| TITLE ECO.LOWER COIL ASSY. (ECML-04) | | DRAWING NO : 1-19-124-U8134 | |
| REV DATE ALTERED : CHD & APPD : | | REV 00 | |