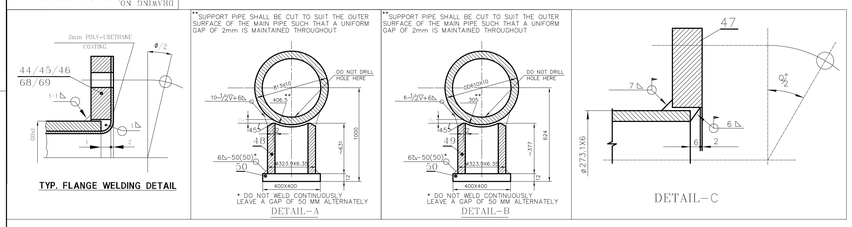
DRAWING NO. 0-80-468-06414



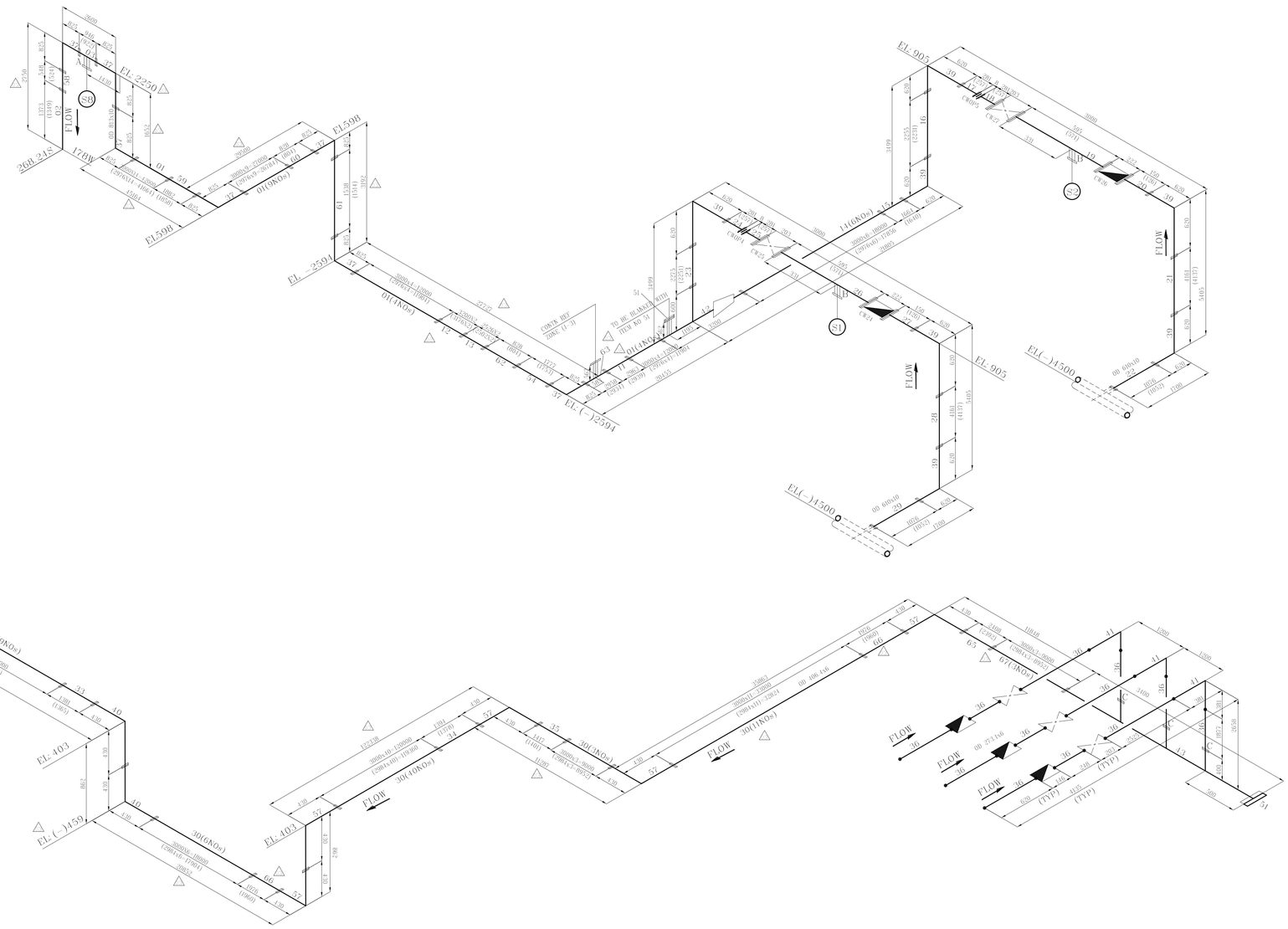
NOTES: –

ALL DIMENSIONS ARE IN MILIMETRES

01 DESIGN PRESSURE : 5.0 Kg/Cm 2 (g)
02 DESIGN TEMPERATURE : 50° C
03 WORKING MEDIUM : SEA WATER
04 HYDRAULIC TEST PRESSARE : 7.5Kg/Cm 2 (g)
05 FOR ERECTION WELDING SCHEDULE REFER DRG.No:4-80-468-75538
06 COMPONENTS FOR HANGERS & SUPPORTS ARE ISSUED IN PGMA 80-
07 FOLLOW QCP : 6947:QPC:02 REV.00
08 PIPE EDGE PREPARATION & ELECTRODE DATA

PIPE SIZE	MATERIAL SPECN. (C)	WT. Kg/M	END CONNECTION	RADIUS OF BEND	WELD SPECN.	ELECTRODE DATA (C) ROOT RUN	FURTHER RUN
OD 813 X 10	IS 3589	198.200	FLANGED	R=800	10$\bar{V}$	E 7018	E 7018
OD 610 X 10	IS 3589	150.400	FLANGED	R=600	10$\bar{V}$	E 7018	E 7018
OD 406.4 X 6	IS 3589	59.240	FLANGED	R=400	6 $\bar{V}$	E 7018	E 7018
OD 273 X 6	SA312TP316L	41.200	D	R=250	6 $\bar{V}$	RT 347	E 347

09. ALL FASTENERS ARE TO BE ZINC PLATED TO A THICKNESS OF 10-14 MICRONS
10. BOLTS AND NUTS ARE SUPPLIED SEPARATELY WITH 10% EXCESS AS SPARES VIDE DU No.
11. RUBBER GASKET SUPPLIED SEPARATELY WITH 10% EXCESS AS SPARES VIDE DU No.
12. DIMENSIONS WITH IN BRACKETS INDICATES ACTUAL LENGTH OF PIPE.
13. COATING OF PIPES:–
    A. FOLLOW QP 6947:QPC:12
    B. INSIDE SURFACE OF ENTIRE PIPING HAS TO BE COATED WITH 2mm THICK POLY-URETHANE INCLUDING FACE OF THE FLANGE
    C. PAINTING SHALL BE AS PER QP 6947:QPC:12
    D. ALL THE DUs INDICATED IN THE DRAWING ARE APPLICABLE FOR OVER GROUND PIPING
    E. INSIDE COATING TO BE DONE AT SITE
    WHEREVER MATING FLANGE FOR BF VALVES, SCF AND PUMPS SUPPLIED ALONGWITH THE EQUIPMENT SHALL BE WELDED AT SITE BEFORE COATING. FOR THIS PURPOSE, 100mm LENGTH IS LEFT UNCOATED.
14. FOR ALL FLANGED CONNECTION 3mmTHK GASKET TO BE USED. AFTER TIGHTENING THE THICKNESS BECOME 2mm TO BE MAINTAINED.
15. * INDICATES 2mm GASKET THICKNESS (BETWEEN FLANGES) ALSO TAKEN IN ACCOUNT WHILE CUMULATING LENGTH.
16. ITEM NO.36 SUPPLIED IN RUNNING METRE SHALL BE CUT AND WELD AT SITE AS PER THE DRAWING.
△ 17. ITEM NO.52 TO BE TAKEN FROM THE DU NO. 120 AND USE AS PER DRAWING.
△ 18. ITEM NO.S 53,54,55 & 56 ARE RELEASED IN THE PGMA 6947-80468 DU NO.S 07,08,09 OF NS-2 WO.
△ 18. ITEM NO.S 57-69 ARE RELEASED IN THE PGMA 6947-80468, OF NS-2 WO.


EL-2250
EL59B
268.2LS
176W
FLOW
EL-2594
EL-905
EL(-)1500
EL(-)2030
CONTR REF ZONE (C-9)
KB 800
EL-403
EL(-)459
EL-403
FLOW
30(4NOs)
30(3NOs)
30(1NOs)
30(6NOs)
30(9NOs)
67(4NOs)
OD 273x6
OD 406x6
OD 406x10
OD 406.4x6
OD 406.4x6
OD 406.4x6