DRAWING No. 1-80-468-18705

ALL DIMENSIONS ARE IN MILLIMETRES

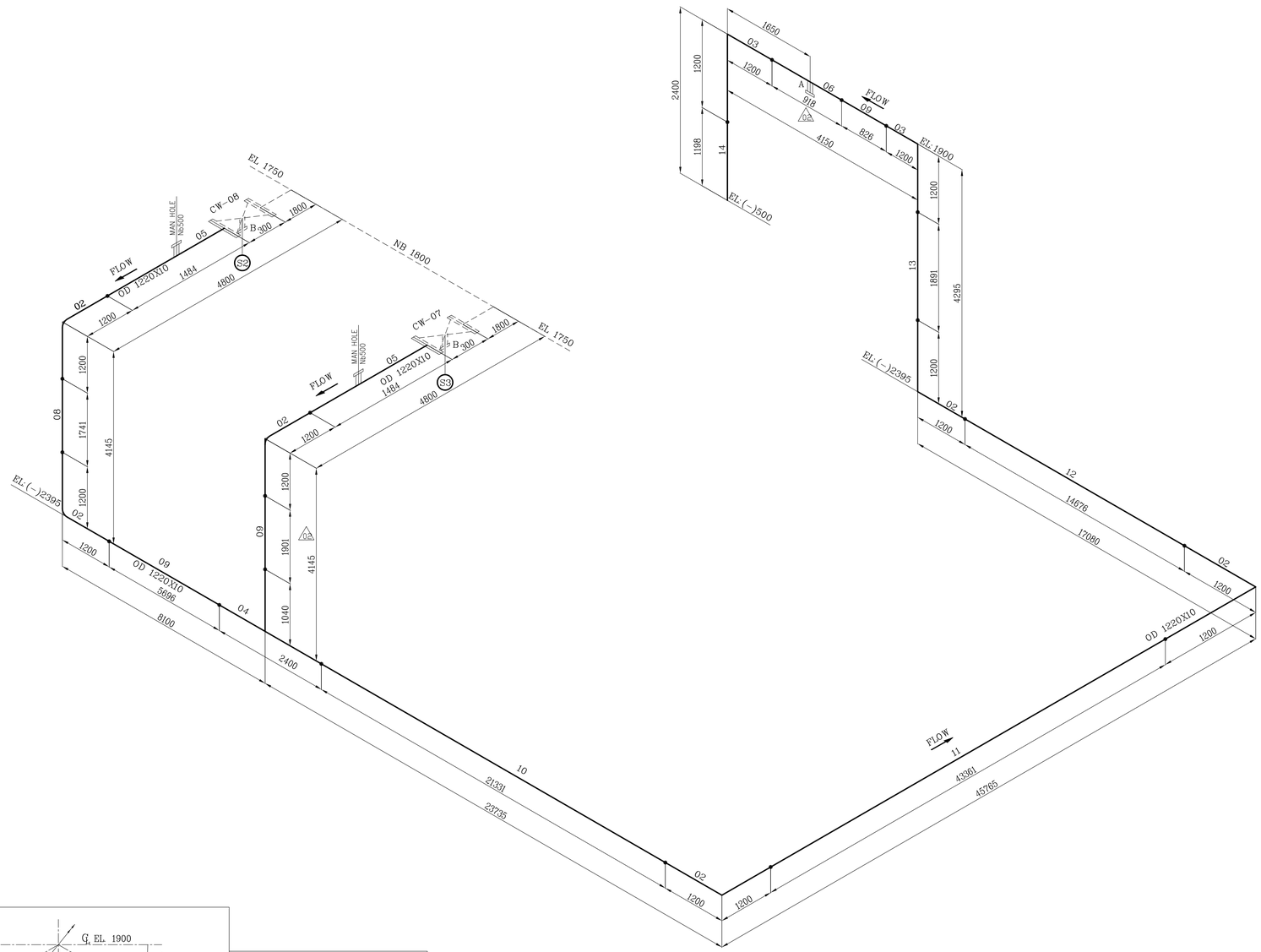
NOTES: –

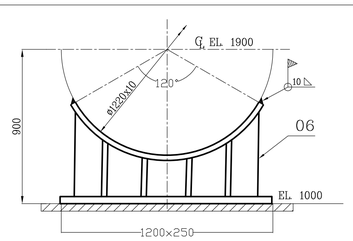
01 DESIGN PRESSURE : 5.0 Kg/Cm^2 (g)
02 DESIGN TEMPERATURE : 50° C
03 WORKING MEDIUM : SEA WATER
04 HYDRAULIC TEST PRESSARE : 7.5Kg/Cm^2 (g)
05 FOR ERECTION WELDING SCHEDULE REFER DRG.No: 4-80-468-75538

06 PIPE EDGE PREPARATION & ELECTRODE DATA

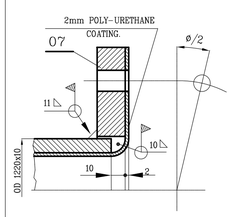
PIPE SIZE	MATERIAL SPECN. (C)	WT. Kg/M	END CONNECTION	RADIUS OF BEND	WELD SPECN	ELECTRODE DATA (C)	
						ROOT RUN	FURTHER RUN
OD 1220 X 10	IS 3589	298.4	WELD	R=1200	10$\widehat{V}$	E 7018	E 7018

07. ALL FASTENERS ARE TO BE ZINC PLATED TO A THICKNESS OF 10-14 MICRONS
08. BOLTS AND NUTS ARE SUPPLIED SEPARATELY WITH 10% EXCESS AS SPARES VIDE DU No.
09. RUBBER GASKET SUPPLIED SEPARATELY WITH 10% EXCESS AS SPARES VIDE DU No.
10. DIMENSIONS WITH IN BRACKETS INDICATES ACTUAL LENGTH OF PIPE.
11. 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 UNDER 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.
12. ITEM NO 01 & 02 ARE RELEASED IN PGMA 80-468 DU NO: 005 & 019 (CUST NO: 6947)
01 13. ITEM NO 01 HAS BEEN DELETED AND RELEASED AS ITEM NO 08-14 VIDE.DU.NO. 200-206
01 14. FOR PLATE FORMED PIPES, USE OF IS3589/ SA515GR70/ SA515GR.60/ IS2062 MATERIAL ACCEPTABLE AS THE CASE MAY BE APPLICABLE.
02 15. ITEM NO. 9 SUPPLIED WITH EXTRA LENGTH. SITE MAY SUITABLY CUT AND USE AS PER DRAWING.





SUPPORT WELDING DETAIL-A



FLANGE WELDING DETAIL

01	206	14	PIPE OD 1220 X 10 (UG) L=1198	1-80-468-18705		15 938 546 0000 / IS 3589			357 / 1	483	
01	205	13	PIPE OD 1220 X 10 (UG) L=1891	1-80-468-18705		15 938 546 0000 / IS 3589			564 / 1	274	
01	204	12	PIPE OD 1220 X 10 (UG) L=14676	1-80-468-18705		15 938 546 0000 / IS 3589			4379 / 1	318	
01	203	11	PIPE OD 1220 X 10 (UG) L=43361	1-80-468-18705		15 938 546 0000 / IS 3589			12938 / 1	922	
01	202	10	PIPE OD 1220 X 10 (UG) L=21331	1-80-468-18705		15 938 546 0000 / IS 3589			6365 / 1	170	
01	201	09	PIPE OD 1220 X 10 (UG) L=5696	1-80-468-18705		15 938 546 0000 / IS 3589			1699 / 3	686	
01	200	08	PIPE OD 1220 X 10 (UG) L=1741	1-80-468-18705		15 938 546 0000 / IS 3589			1519 / 2	514	
		07	FLAT FACED FLANGE NB1200 Cl. 150	4-80-463-68512		15 011 106 0000 / IS 2062 FE410B			215 / 1	000	
		06	PIPE WITH SADDLE SUPPORT NB1200	3-80-468-29826		WELDMENT			436 / 1	666	
		05	PIPE WITH MAN HOLE (NB500) ASSEMBLY	2-80-468-09454		WELDMENT			720 / 2	541	
		04	FAB EQUAL TEE OD 1220X10 L=2400	3-80-468-26206		WELDMENT			1254 / 1	247	
		03	90DEG MITRE BEND OD 1220X10 L=1200/1200	4-80-468-67849		WELDMENT			702 / 2	455	
	019	02	90DEG MITRE BEND OD 1220X10 L=1200/1200	4-80-468-67849		WELDMENT			702 / 6	455	
01	~~005~~	~~01~~	~~PIPE OD 1220 X 10 L=91635~~	~~1-80-468-18705~~		~~15 938 546 0000 / IS 3589~~			~~27343 / 1~~	~~884~~	
	DU NO.	ITEM NO.	DESCRIPTION	STD	DRAWING NO.	ITEM NO. / VAR NO.	MATL CODE / MATL SPECN	A C	UNIT / DI	UNIT WT. / QTY.	G.S. / ZONE

CUST NO. 6947 & 6948

CUSTOMER M/S GUJARAT STATE ELECTRICITY CORPORATION LTD.
DIST. JAMNAGAR

CONSULTANT M/S TCE CONSULTING ENGINEERS LIMITED

NAME OF PROJECT. 2 x 250MW SIKKA THERMAL POWER PROJECT (EXTENSION UNITS 3 & 4)

BHARAT HEAVY ELECTRICALS LIMITED
PIPING CENTRE
CHENNAI 600 017

	NAME	SIGN	DATE
DRN	P.VIMALRAJ		09-08-12
CHD	S.R.K.N		09-08-12
APPD	C.SARAVANAN		09-08-12

DEPT	GRADE OF UNTOL DIM	SCALE	WEIGHT (KG)	REF TO ASSY / OLD DRG.	ITEM No.
CODE	C/M/F	N.T.S		PE-DG-281-165-M003	

TITLE: CW RECIRCULATION

CARD CODE: U 01

PC DRAWING NO.: 1-80-468-18705

REV: 02

Size A1

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 / APPROVED	ZONE
03			
02	19/01/13	ALTERED P.SURESH / APPROVED S PANDA	ITEM NO. 9 PIPE LENGTH CHANGED; ALL REVISIONS MARKED AS 02
01	09/10/12	ALTERED P.SURESH / APPROVED C.V.N	AS INFORMED BY OP&C/PC VIDE E-MAIL DTD 09/10/12 DRG. GENERALLY REVISED REVISED DUs MARKED. 01