FIRST ANGLE PROJECTION (ALL DIMENSIONS ARE IN mm)

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INVENTORY No. | SIGN & DATE | REF.DRAWING No. STE-TD-118-L

TECHNICAL REQUIREMENTS :

1. ALL CORNER JOINT WELDS ARE WELDED FULL.
2. ALL UNSPECIFIED FILLET WELDS SEAMS ARE OF 8 ▷.
3. WELD CLASSIFICATION GROUPS CS, CK (WITHOUT OPEN ROOT DEFECT). BS, BK SHALL BE ACC. TO HW 0620099, 100% DPT OF WELD FOR ITEM NOS.33 AND 34. (01)
4. TEST SCOPE SHALL CONFORM TO HW 0850199 WITH CSR 3(1).
5. LP INNER CASING SHALL BE STRESS RELIEVED ACCORDING TO HW 0641099.
6. [ ] REPRESENTS DIMENSIONS TO BE CONTROLLED BEFORE ASSEMBLY. TOLERANCES FOR SUCH DIMENSIONS SHALL BE ACCORDING TO HW 0610003.
7. DIMENSIONS WITHIN ( ) ARE CRITICAL TO QUALITY (CTQ).
8. TRANSVERSE CENTER LINE SHALL BE HARD PUNCHED AS PER DETAIL-IX.
9. THE SURFACE FINISH ON THE THREADS TO BE AS PER ST 38014 EXCEPT OTHERWISE MENTIONED ON THE DRAWING.
10. AFTER ALTERNATE BOLT TIGHTENING THE FEELER OF 0.03 SHOULD NOT GO THROUGH AND THROUGH.
11. INSERTION PIECE ITEM NO.38 TO BE WELDED TO RING FLANGES ITEM NO.31 AFTER CLEANING THE EXTRACTION CHAMBER DURING ASSEMBLY IN SHOP.
12. IDENTIFICATION SHOULD BE ACC. TO HW 0400397 AT THE PLACE INDICATED WITH IN.

WELDING TABLE

WELD SYMBOL & SIZE	140 K	32 K	25 K	25	25 ▷	32 V	40 ▷	32 ▷	25 ▷	15 ▷	10 ▷	25 ◺	15 ◺	12 ◺	6 ◺
WELD SEAM LENGTH IN M	0.6	2.8	30.5	18.46	27.5	3.0	1.2	5.0	23.6	2.3	2.0	9.7	2.4	3.6	1.0
WT OF DEPOSITED METAL IN KG	34.13	6.9	40.6	70.0	134.5	13.5	7.5	21.0	71.4	28.0	1.3	21.4	2.1	2.1	1.5

GRADE OF UNTOL. DIM
M/CG.– AA0230208 m
WELDING-CLASS 'B' OF AA0621104
GAS CUTTING-TABLE 3 OF AA0621101

GMS No./ C.B.O.M 0 10742 46000			STATUS OF U DRG
AGREED DEPT	NAME	SIGN	DATE
WT	V.KUMAR	sd/-	14/01/04
STT	SATYA DEO	sd/-	12/01/04

REV	DATE	ALTERED	CHECKED
01	11/11/05	TSB sd/-	SB sd/-

IN VIEW-X,(Ø2620)WASØ2600. IN SEC-CC,(Ø220), (Ø120), (Ø116), (50), (35) WERE Ø250, Ø150, Ø146, 50, 35 RESP.&RELIEVING GROOVES SHOWN. VIEW-Z,DETAIL-IV,TR-3,SEC.-EE,FF&GG, VIEW OF JOINT PLANE(LH) MODIFIED. ASSLY.WT.WAS 17010.
C/A NO. STE-05-F0186

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: STEAM TURBINE

BHARAT HEAVY ELECTRICALS LTD.
RANIPUR, HARDWAR

	NAME	SIGN	DATE
DRN	SPS SENGAR	sd/-	22.09.2003
CHD	S BANSAL	sd/-	03.10.2003
APPD	AK JAIN	sd/-	14.01.2004

NO. OF VAR

DEPT STE | CODE 4011 | SCALE 1:10 | WEIGHT (KG) 16540 | REF. TO ASSY. DRG. --- | ITEM No. -- | NO. OF ITEMS --

TITLE : LP INNER INNER CASING
(N30-2X6.3 WITH ADVANCE BLADING)

CARD CODE

DRAWING NO. 0-10742-46000

SHEET No. 01 | No. OF SHEETS 01

A0 SIZE

FORM DG 46 (B)