

ANNEXURE – I

JOB PROVE OUT DETAILS FOR CNC GANTRY DRILLING M/C

REFER THE INDENT NO: CG7A0111 (Matl.Code.No.CG2015294015)

TYPE OF CASING	:	Steam Turbine 120MW KN inner casing
MATERIAL SPECIFICATION	:	HY 19573 (Gs17CrMoV511)
MECHANICAL PROPERTIES	:	Ts : 590~780 Ys : 440 E : 15
WEIGHT OF JOB BOTH UPPER & LOWER PARTS	:	36300Kgs (Gross) 34300 Kgs (Net)
VOLUMETRIC DIMNSOF CASING IN COMBINED CONDITION (L X B X H):	:	3675x 2240x2120 mm.
CHEMICAL COMPOSITION	:	C = 0.15~0.2; Si = 0.3~0.6; Mn = 0.5~0.8; S = 0.03; P = 0.03; Cr = 1.2~1.5; Mo = 0.9~1.1; V = 0.2~0.3.
SCOPE OF M/CING	:	PP Milling,Drilling, Spot facing ,Threading, Pheripheral milling & drilling including tapping ,as per relevant drawings. Excluding internal diameters and faces which are highlighted in the drgs.
DRAWING.NO	:	CG6A1107-001 REV02 SHEET 1 & 2
DESCRIPTION	:	INNER CASING (WZ)

