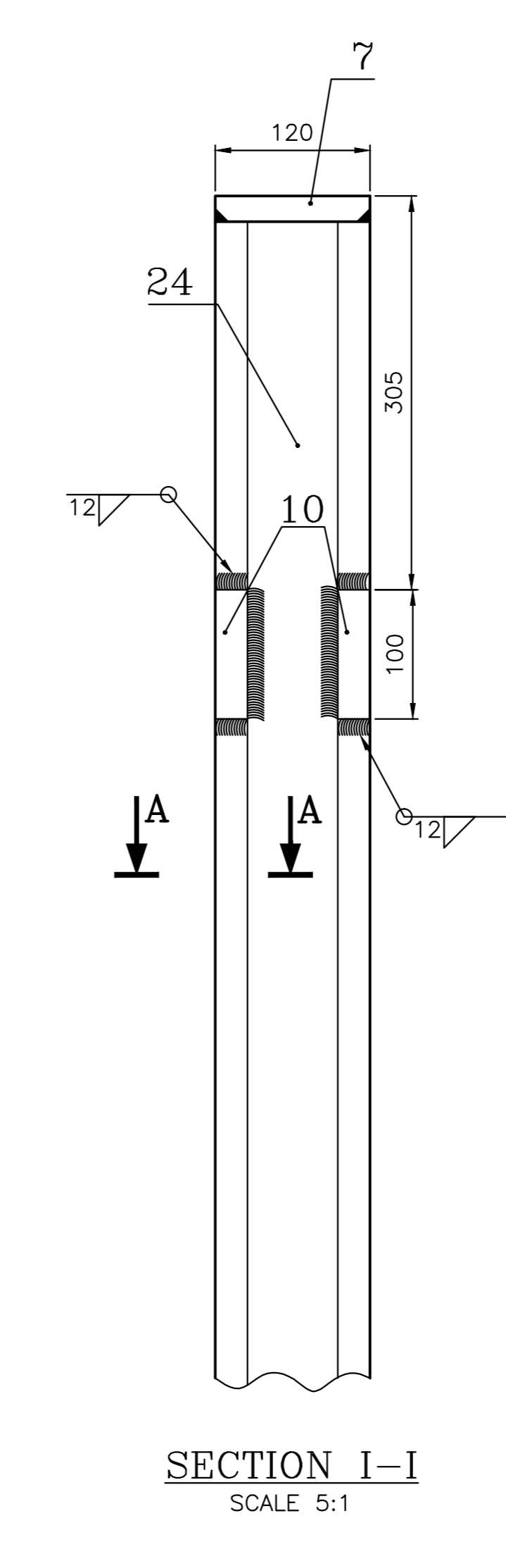
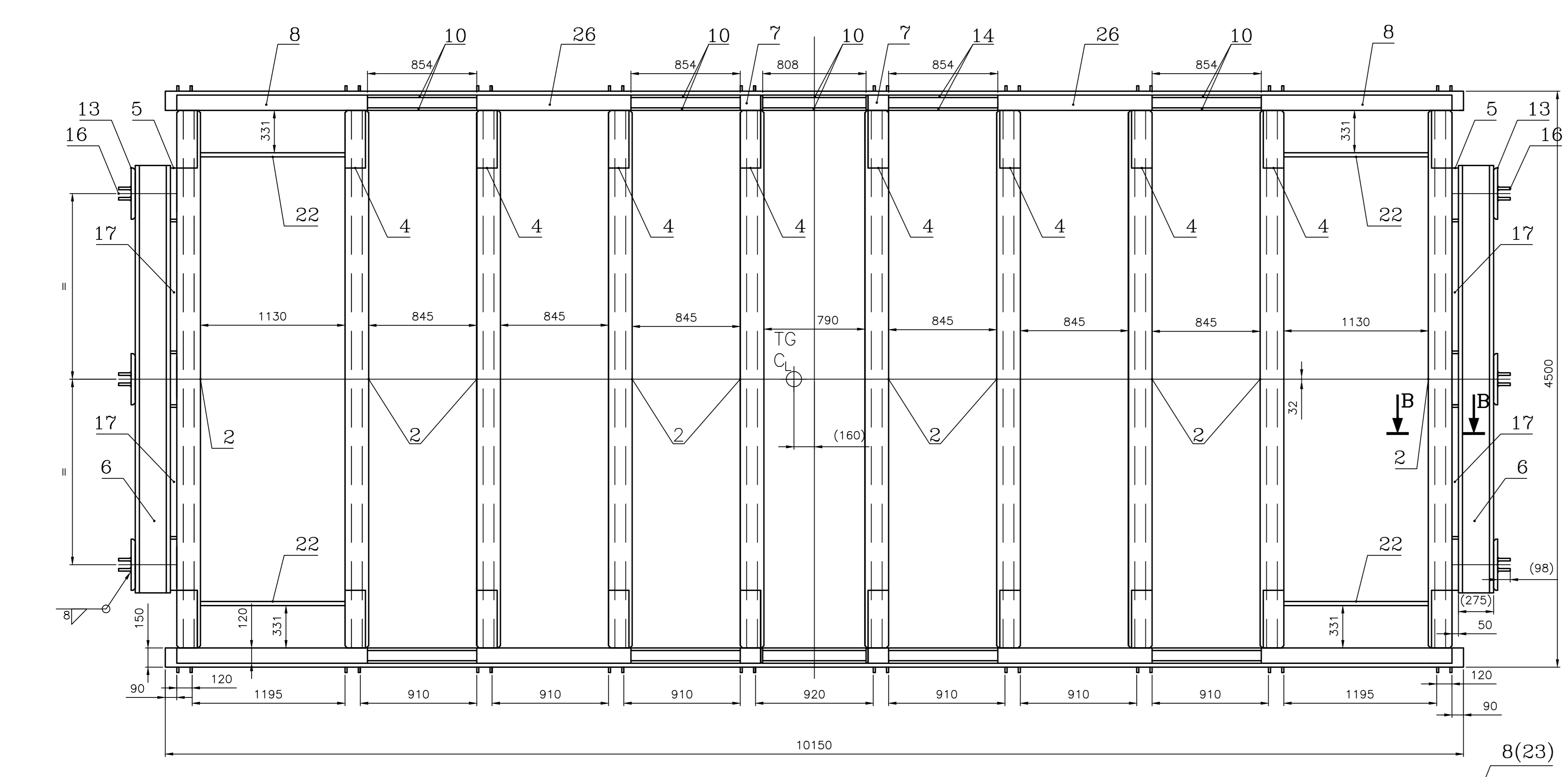
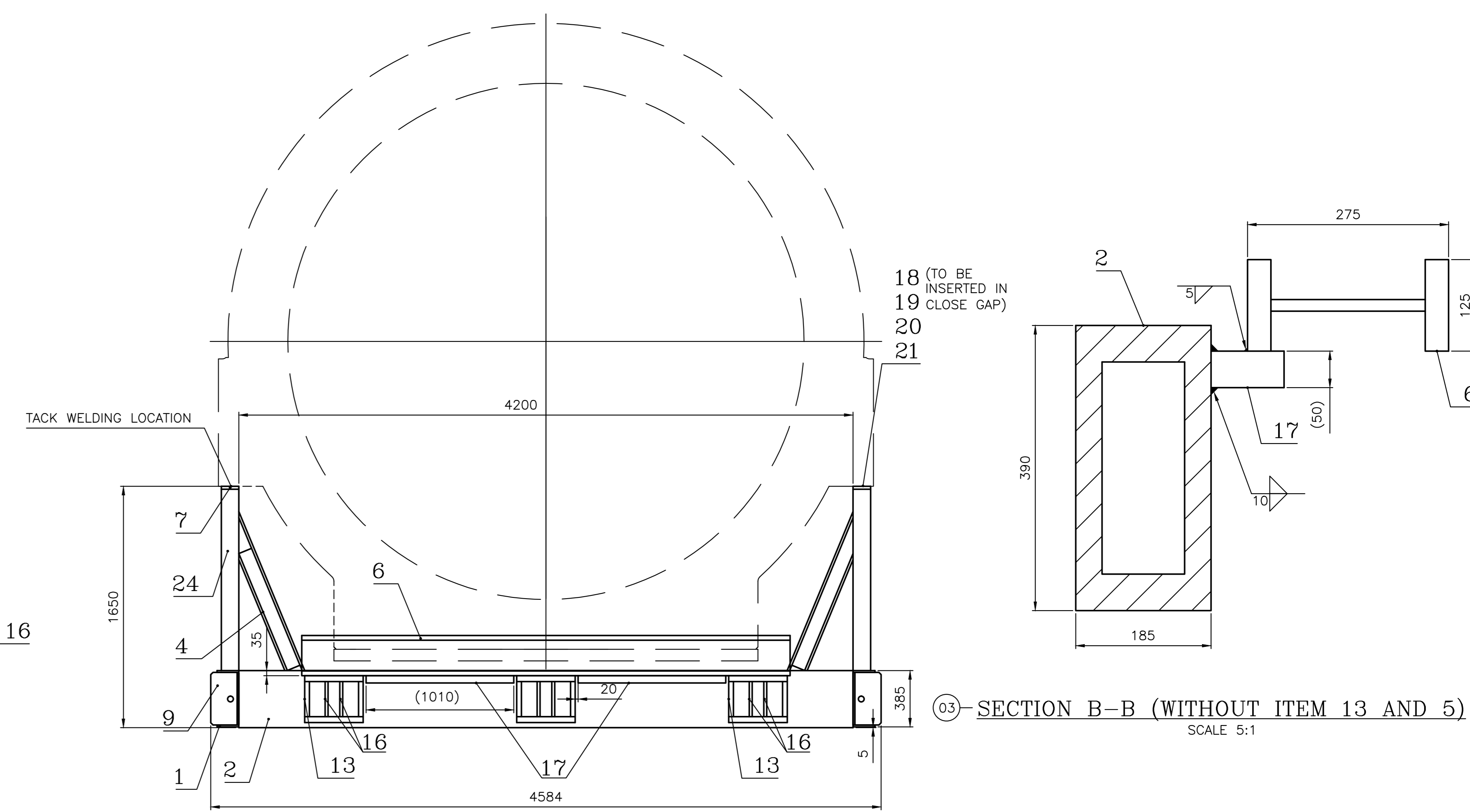
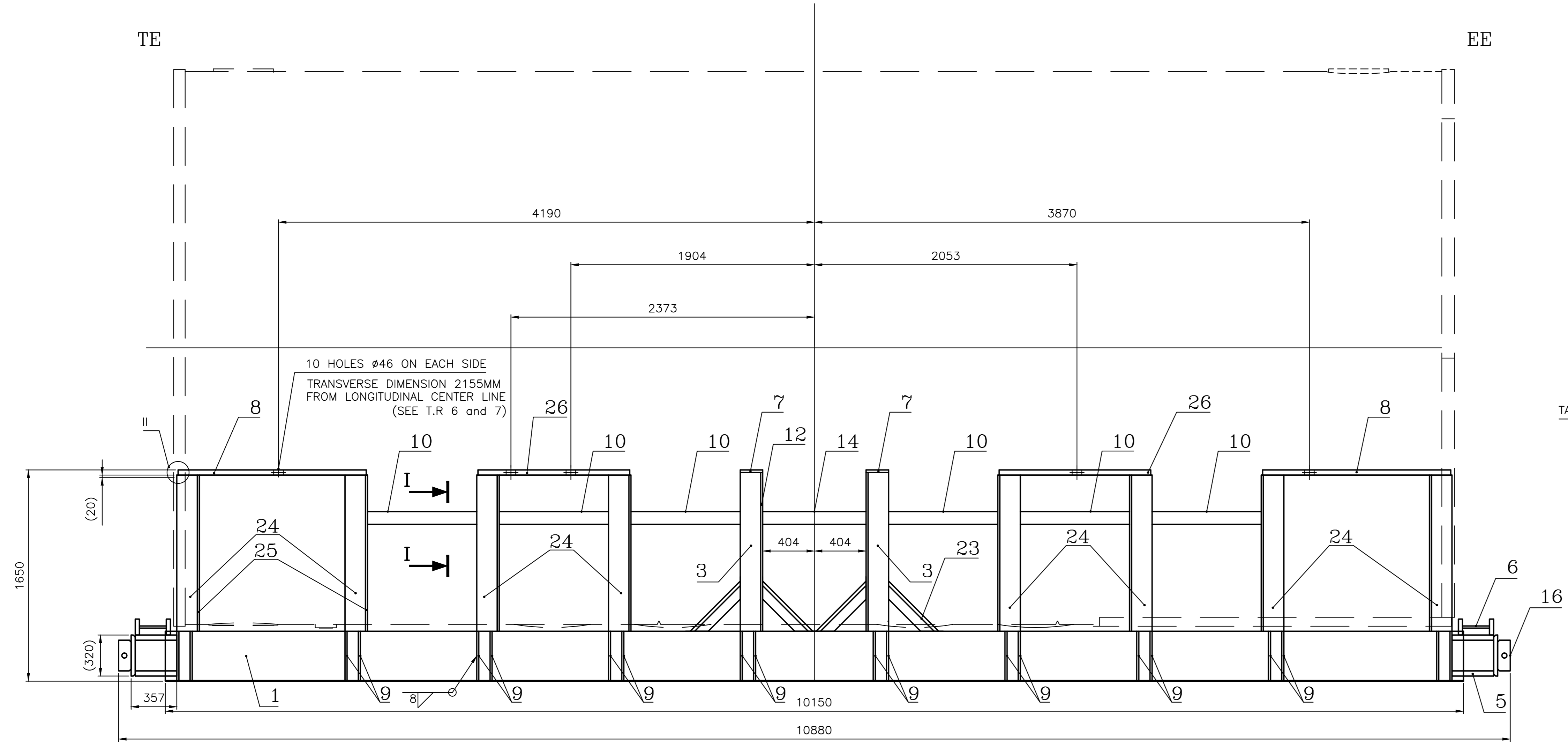
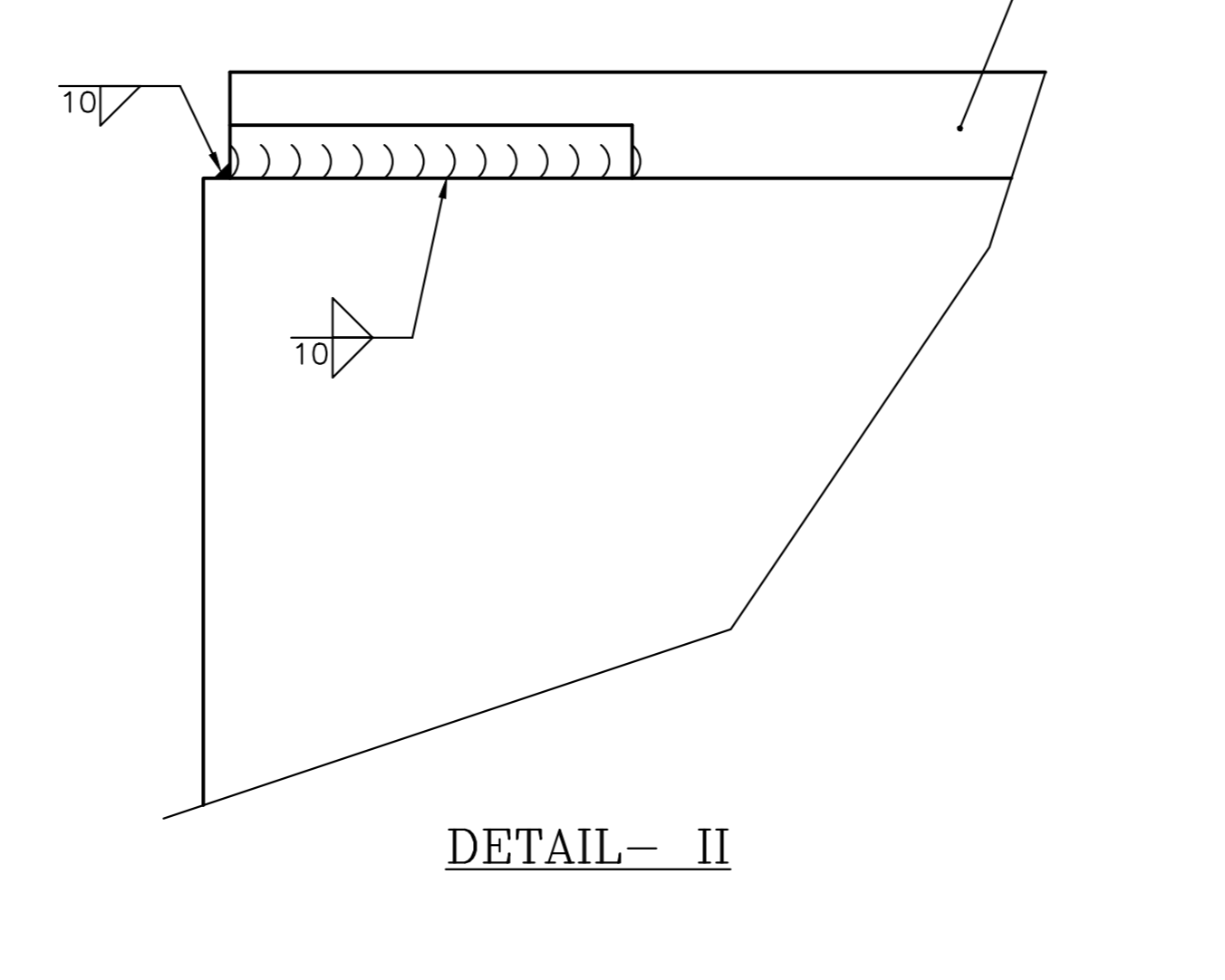
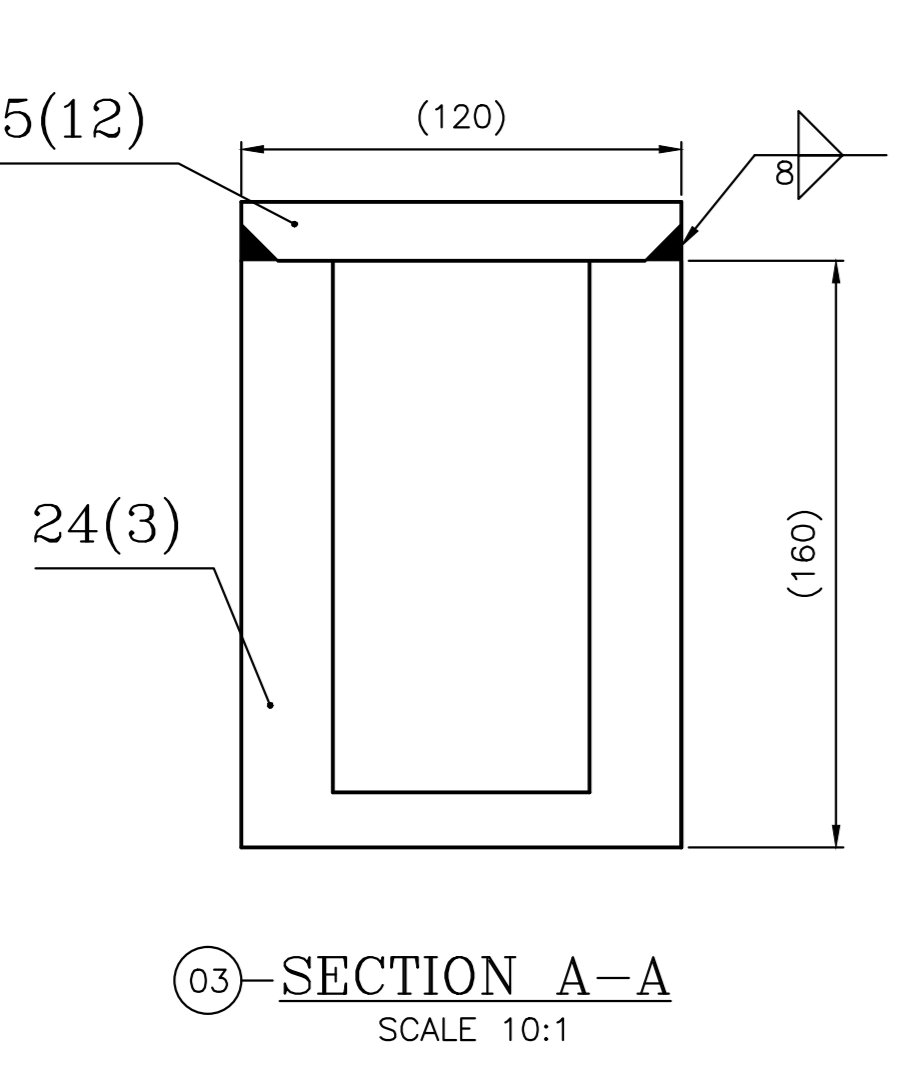


DRAWING NO. 01393801097



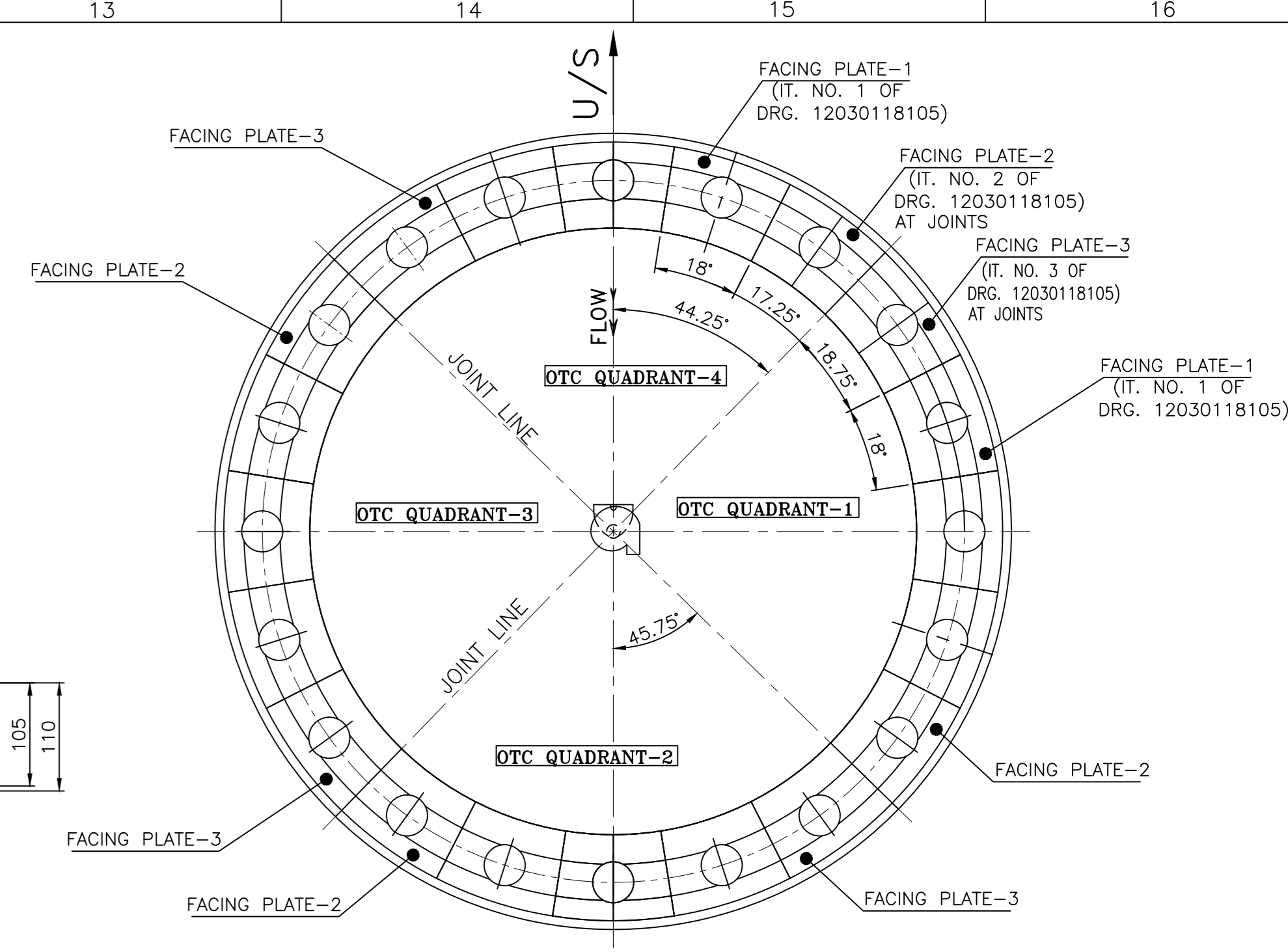
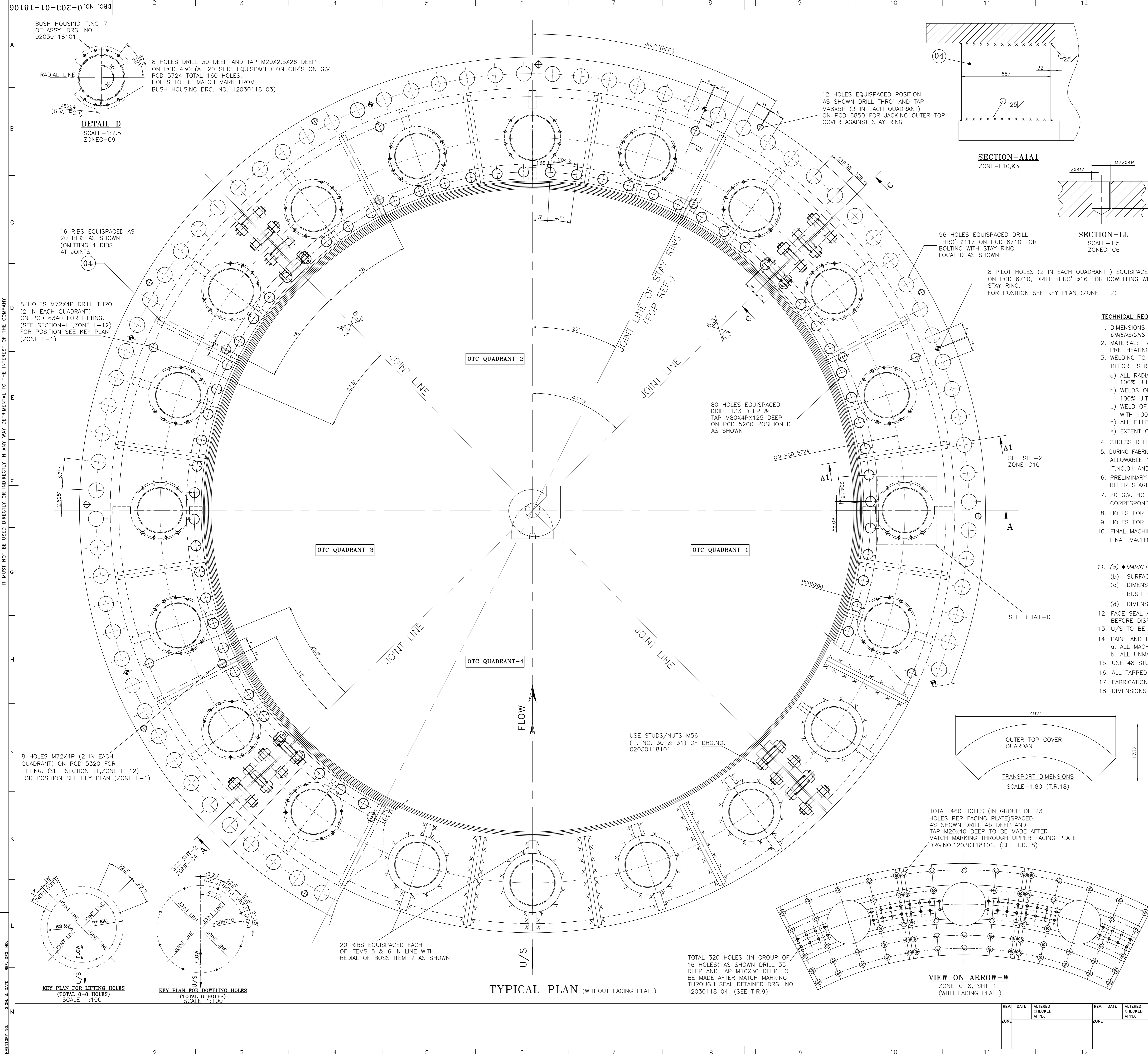
SL.NO.	LOCATION	TYPE & SIZE	SEAM LENGTH(M)	WT. OF DEPOSIT(KG)	TYPE OF ELECTRODE
1	BETWEEN ITEM 1 AND 2	16\	15.6	15.67	E-7018
2	BETWEEN ITEM 1 AND 3	10\	3.2	1.25	
3	BETWEEN ITEM 1 AND 12	10\	0.5	0.19	
4	BETWEEN ITEM 3 AND 4	10\	3.6	1.40	
5	BETWEEN ITEM 2 AND 4	10\	11.2	4.38	
6	BETWEEN ITEM 1 AND 9	8\	57.6	14.47	
7	BETWEEN ITEM 16 AND 13	8\	6.24	1.57	
8	BETWEEN ITEM 5 AND 6	16\	4.8	4.82	
9	BETWEEN ITEM 5 AND 13	16\	8.64	8.68	
10	BETWEEN ITEM 5 AND 2	16\	8.64	8.68	
11	BETWEEN ITEM 3 AND 12	8\	9.92	2.49	
12	BETWEEN ITEM 3 AND 7	10\	2.37	0.93	
13	BETWEEN ITEM 3 AND 10	12\	1.12	0.63	
14	BETWEEN ITEM 12 AND 23	10\	1.82	0.71	
15	BETWEEN ITEM 1 AND 23	10\	3.63	1.43	
16	BETWEEN ITEM 3 AND 23	10\	1.82	0.71	
17	BETWEEN ITEM 10 AND 25	12\	3.36	1.90	
18	BETWEEN ITEM 10 AND 24	12\	2.24	1.27	
19	BETWEEN ITEM 8 AND 24	10\	3.62	1.42	
20	BETWEEN ITEM 24 AND 25	10\	39.68	15.57	
21	BETWEEN ITEM 24 AND 26	10\	3.62	1.42	
22	BETWEEN ITEM 12 AND 14	12\	1.12	0.63	
23	BETWEEN ITEM 2 AND 22	16\	6.24	6.27	
24	BETWEEN ITEM 17 AND 2	10\	8.08	3.17	
25	BETWEEN ITEM 17 AND 6	5\	4.04	0.40	



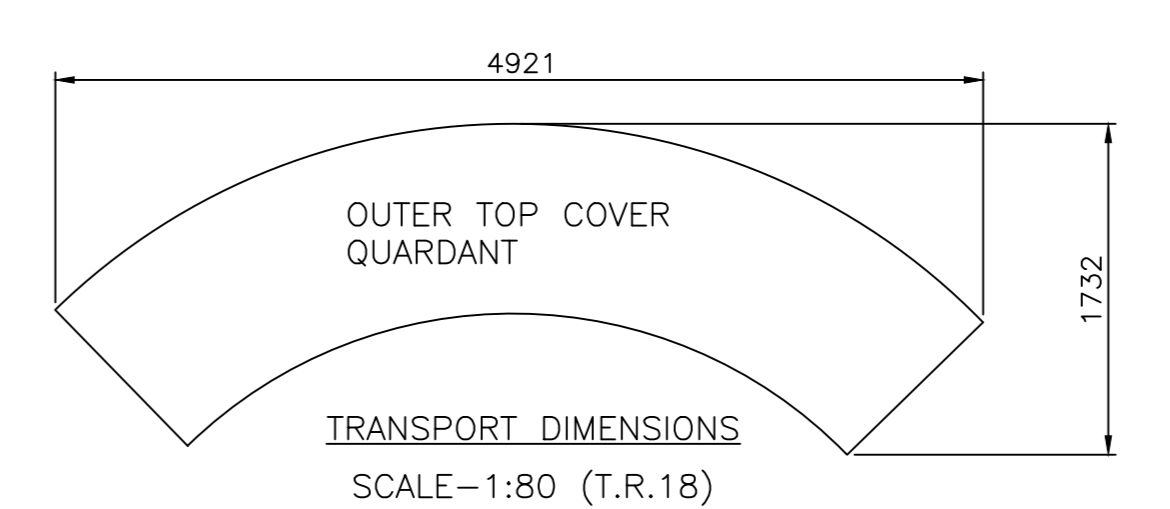
- TECHNICAL REQUIREMENTS**
- IDENTIFICATION ACCORDING TO HW 0400.397.
 - QUALITY GRADE OF WELD SEAMS AS PER HW 0620.009 CS,CK-AND BS,BK .
 - TEST SCOPE AS PER HW 0850.199 CATEGORY OF SERVICE REQUIREMENT-1.
 - SURFACE TREATMENT AS PER TECHNICAL INSTRUCTIONS 0912.015
 - STATOR FRAME TO BE TACK WELDED WITH CRADLE ITEM NO. 3(24) & 12(25) AS SHOWN IN SIDE VIEW.
 - THE HOLES ARE TO BE MADE ON PLATES AFTER THEIR FINAL ASSEMBLY.
 - ITEM NOS 27,28,29,30 AND 31 TO BE USED FOR BOLTING OF STATOR ON FIXTURE.

OBOM NO. 01393801097	STATUS OF DRG. REVISED	TYPE OF PRODUCT THDF 125/67
PREPARED BY WIX	NAME AMITKISHOR	NAME OF CUSTOMER/ PROJECT
GRADE OF UNTOL. DIM.:-- M/CG-1/8/M/1 AA 023020B	DATE 21/10/2023	DRN STGEPNM 21/10/2023
WELDING-1/8/1/1-AA621104	DATE 21/10/2023	CHD STGCKN 21/10/2023
GAS CUTTING-T3AA0621101	DATE 21/10/2023	APD ATGCKRG 21/10/2023
REV DATE ALTERED CHECKED	REV DATE ALTERED AMISHRA 24/10/23 CHECKED	DEPT. TGE CODE 4133
THE DRAWING SUPERSEDES THE OLD DRAWING UNDER THE SAME DRAWING NUMBER WITH CHANGES AS PER THE CHANGE ADVISE NO:TGE-15-F0370		SCALE 1:20
TITLE CRADLE FOR TRANSPORT		WEIGHT(Kg.) 21281.0
DRAWING NO. 01393801097		REF. TO ASSY. DRG. NO. OF SHEETS
SHEET NO. 1		NO. OF SHEETS

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- TECHNICAL REQUIREMENTS:-**
- DIMENSIONS GIVEN IN DRAWING DO NOT INCLUDE ANY TECHNOLOGICAL ALLOWANCE FOR FABRICATION. DIMENSIONS IN () ARE FOR WELDED ASSEMBLY BEFORE MACHINING.
 - MATERIAL:- AA10119, IS2062, GRADE-E250 GR.BR FOR IT.NO. 01 AND 02. THEREFORE NECESSARY PRECAUTION FOR PRE-HEATING AND WELDING ELECTRODES ARE TO BE TAKEN BY FBM.
 - WELDING TO CORPORATE STD. AA0622101 TO GRADES AS SPECIFIED BELOW AND NOT TO BE CARRIED OUT BEFORE STRESS RELIEVING.
 - ALL RADIAL JOINTS BETWEEN PARTS OF IT.NO.01 & 02 SHALL BE GRADE-II WITH 100% U.T., MCD AND D.P. TESTING.
 - WELDS OF JOINT FLANGES (IT.NO.03) WITH OTHER ITEMS TO BE GRADE-II WITH 100% U.T., MCD AND D.P. TESTING.
 - WELD OF JOINTS BETWEEN IT.NO.01 AND IT.NO.02 AND 07 TO BE GRADE-II WITH 100% U.T., MCD AND D.P. TESTING.
 - ALL FILLET WELDS TO GRADE-III WITH 100% D.P. TESTING.
 - EXTENT OF EXAMINATION BY U.T. FOR PARTIAL PENETRATION WELD SHALL BE WELD SIZE-5mm.
 - STRESS RELIEVING TO BE CARRIED OUT AS PER PROCESS SPCN. BP640299 AND SUBSEQUENT SHOT BLASTING TO BE DONE.
 - DURING FABRICATION BORES #320 IN IT.NO. 01 AND #310 IN IT. NO. 02 & #315 IN ITEM-7 ON G.V PCD 5724 TO BE KEPT ALIGNED. ALLOWABLE NONALIGNMENT 3mm. VARIATION IN PITCH OF EACH PAIR OF ADJACENT HOLES IN PLATES IT.NO.01 AND 02 NOT TO BE MORE THAN ± 3mm DURING FABRICATION.
 - PRELIMINARY MACHINING OF OUTER TOP COVER TO BE CARRIED OUT FOR WELDING OF S.S. LINER IT.NO. 09. REFER STAGE-I, STAGE-II & STAGE-III.
 - 20 G.V. HOLES SHALL BE MACHINED IN SUCH A WAY THAT THESE ARE CONCENTRIC W.R.T. CORRESPONDING HOLES IN PIVOT RING M/Cg (DRG.NO. 0 20301 18104) WITHIN 0.05mm.
 - HOLES FOR FIXING OF UPPER FACING PLATE TO BE MADE AT LOCATIONS MATCH MARKED FROM UPPER FACING PLATE.
 - HOLES FOR FIXING OF SEAL RETAINER TO BE MADE AT LOCATIONS MATCH MARKED FROM SEAL RETAINER.
 - FINAL MACHINING OF UPPER FACING PLATES ARE TO BE CARRIED OUT AFTER ASSEMBLY WITH OUTER TOP COVER. ENSURE FINAL MACHINING OF FACE SEAL GROOVE IN FACING PLATE TO BE CARRIED OUT ON ASSEMBLY.
 - (a) *MARKED DIAMETERS ARE TO BE CONCENTRIC WITHIN 0.03.
 (b) SURFACES A, X, Y AND Z SHALL BE PERPENDICULAR TO AXIS OF * MARKED DIAMETERS WITHIN 0.05.
 (c) DIMENSIONS MARKED ϕ ARE TO BE MAINTAINED AS PER DRAWING FOR INTERCHANGEABILITY OF BUSH HOUSING, GUIDE VANE FACE SEAL AND FACE SEAL RETAINERS.
 (d) DIMENSIONS MARKED ϕ 70 ARE CRITICAL FOR INSPECTION REEVALUATION DURING MEASUREMENT IN SHOP.
 - FACE SEAL AND SEAL RETAINERS ARE TO BE PROOF ASSEMBLED WITH OUTER TOP COVER AT BHEL WORKS BEFORE DISPATCH.
 - ALL MACHINED SURFACES TO CAT-G.
 - ALL UNMACHINED SURFACES TO CAT-C.
 - USE 48 STUDS AND 96 NUTS (IT.NO.30 AND IT.NO.31) OF DRG.NO. 02030118101 FOR JOINING QUADRANTS.
 - ALL TAPPED HOLES ARE TO BE CHECKED BY USING RELEVANT R.H. PLUG GAUGES.
 - FABRICATION WEIGHT OF OUTER TOP COVER QUADRANT=10830 KG
 - DIMENSIONS OF OUTER TOP COVER QUADRANT = 4921 x 1732 x 900



VAR. NO.	REMARKS	DATE	DESCRIPTION	DRAWING NO.	MATL. CODE	UNIT WT.	NO. OF
010	DOWEL #40x45 LG.		42030118402			0.35	012
009	S.S. LINER		SEE DETAIL		UNS 41500	6.5	024
008	STRIP 25TKX50WX20mtr				ASTM A240	196.0	001
007	BOSS CASTING		32030118116		AA1010312405	85.0	020
006	RIB-3		SEE DETAIL		AA10119	26.0	020
005	RIB-2		SEE DETAIL		AA1011819228	36.0	020
004	RIB-1 687X600X56TK		SEE DETAIL		AA10119	181.0	16
003	JOINT FLANGE		SEE DETAIL		AA1011819260	259.0	08
002	BOTTOM RING (IN QUADRANT)		SEE DETAIL		AA10119	3736	04
001	TOP RING (IN QUADRANT)		SEE DETAIL		IS2062.Gr.BR	5020	04

REV.	DATE	ALTERED	SLG	DEPT.	UNTO.	DIMS.	GR.	SCALE	WEIGHTS	REF. TO	NO. OF
01	30.04.16	CHECKED	RPS	AS PER	DRG.	32000049014		1:10	36128	02030118101	001

PRANAHITA - VIII LIS

NAME: RABI, SIGN: [Signature], DATE: 31.03.16, NO. OF VAR.: 01

NAME: R.P.S., SIGN: [Signature], DATE: 31.03.16, NO. OF VAR.: 01

NAME: R.RAWAL, SIGN: [Signature], DATE: 31.03.16, NO. OF VAR.: 01

TITLE: OUTER TOP COVER (FAB & M/CING) (IN QUADRANTS)

DRAWING NO. 0 203-01-18106

SHT. NO. 02, NO. OF SHT. 02

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A B C D E F G H J K L M

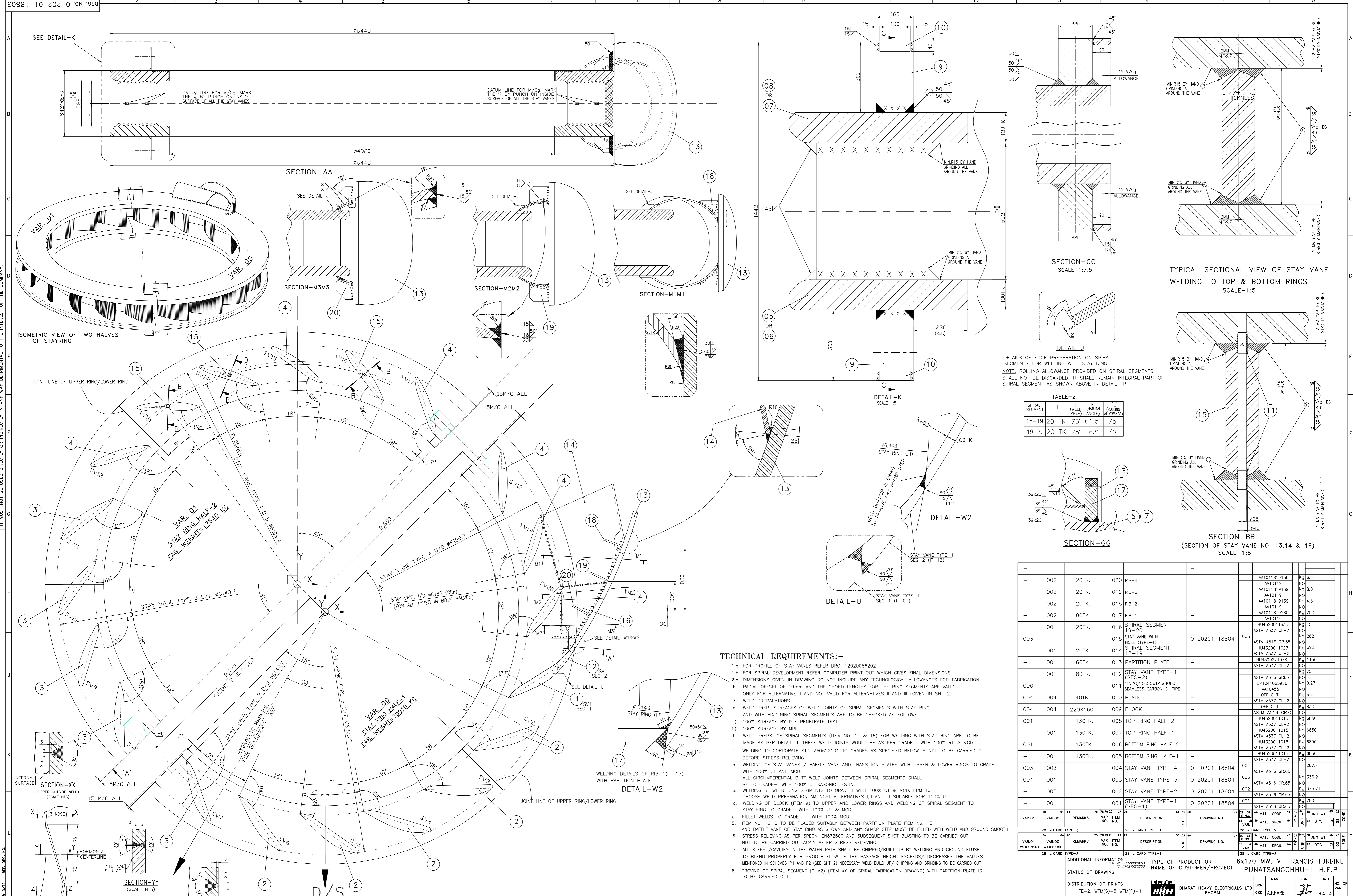


TABLE-2

SPIRAL SEGMENT	T (WELD PREP)	F (NATURAL ANGLE)	L' (ROLLING ALLOWANCE)
18-19	20 TK	75°	61.5'
19-20	20 TK	75°	6.3'

TECHNICAL REQUIREMENTS:-

- FOR PROFILE OF STAY VANES REFER DRG. 12020086202
- FOR SPIRAL DEVELOPMENT REFER COMPUTER PRINT OUT WHICH GIVES FINAL DIMENSIONS.
- DIMENSIONS GIVEN IN DRAWING DO NOT INCLUDE ANY TECHNOLOGICAL ALLOWANCES FOR FABRICATION
- RADIAL OFFSET OF 19mm AND THE CHORD LENGTHS FOR THE RING SEGMENTS ARE VALID ONLY FOR ALTERNATIVE-I AND NOT VALID FOR ALTERNATIVES II AND III (GIVEN IN SHT-2)
- WELD PREPARATIONS
 - WELD PREP. SURFACES OF WELD JOINTS OF SPIRAL SEGMENTS WITH STAY RING AND WITH ADJOINING SPIRAL SEGMENTS ARE TO BE CHECKED AS FOLLOWS:
 - 100% SURFACE BY DYE PENETRATE TEST
 - 100% SURFACE BY MPI
 - WELD PREPS. OF SPIRAL SEGMENTS (ITEM NO. 14 & 16) FOR WELDING WITH STAY RING ARE TO BE MADE AS PER DETAIL-J. THESE WELD JOINTS WOULD BE AS PER GRADE-I WITH 100% RT & MCD
 - WELDING TO CORPORATE STD. A40622101 TO GRADES AS SPECIFIED BELOW & NOT TO BE CARRIED OUT BEFORE STRESS RELIEVING.
 - WELDING OF STAY VANES / BAFFLE VANE AND TRANSITION PLATES WITH UPPER & LOWER RINGS TO GRADE I WITH 100% UT AND MCD. ALL CIRCUMFERENTIAL BUTT WELD JOINTS BETWEEN SPIRAL SEGMENTS SHALL BE TO GRADE-I WITH 100% ULTRASONIC TESTING.
- WELDING BETWEEN RING SEGMENTS TO GRADE I WITH 100% UT & MCD. FBM TO CHOOSE WELD PREPARATION AMONGST ALTERNATIVES I, II AND III SUITABLE FOR 100% UT
- WELDING OF BLOCK (ITEM 9) TO UPPER AND LOWER RINGS AND WELDING OF SPIRAL SEGMENT TO STAY RING TO GRADE I WITH 100% UT & MCD.
- FILLET WELDS TO GRADE -III WITH 100% MCD.
- ITEM NO. 12 IS TO BE PLACED SUITABLY BETWEEN PARTITION PLATE ITEM NO. 13 AND BAFFLE VANE OF STAY RING AS SHOWN AND ANY SHARP STEP MUST BE FILLED WITH WELD AND GROUND SMOOTH.
- STRESS RELIEVING AS PER SPEC. EN872600 AND SUBSEQUENT SHOT BLASTING TO BE CARRIED OUT NOT TO BE CARRIED OUT AGAIN AFTER STRESS RELIEVING.
- ALL STEPS / CAVITIES IN THE WATER PATH SHALL BE CHIPPED/BUILT UP BY WELDING AND GROUND FLUSH TO BLEND PROPERLY FOR SMOOTH FLOW. IF THE PASSAGE HEIGHT EXCEEDS/ DECREASES THE VALUES MENTIONED IN SCHEMS-P1 AND P2 (SEE SHT-2) NECESSARY WELD BUILD UP/ CHIPPING AND GRINDING TO BE CARRIED OUT
- PROVING OF SPIRAL SEGMENT (0-02) (ITEM XX OF SPIRAL FABRICATION DRAWING) WITH PARTITION PLATE IS TO BE CARRIED OUT.

VAR.01	VAR.00	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	QTY	DRAWING NO.	28 - CARD TYPE-2	28 - CARD TYPE-1	28 - CARD TYPE-2	28 - CARD TYPE-1	UNIT WT.	NO. OF
-	002	20TK.	020	RIB-4	-	-	-	AA1011819139	-	AA1011819139	-	Kg 6.9	-
-	002	20TK.	019	RIB-3	-	-	-	AA1011819139	-	AA1011819139	-	Kg 8.0	-
-	002	20TK.	018	RIB-2	-	-	-	AA1011819139	-	AA1011819139	-	Kg 4.5	-
-	002	80TK.	017	RIB-1	-	-	-	AA1011819260	-	AA1011819260	-	Kg 25.0	-
-	001	20TK.	016	SPIRAL SEGMENT 19-20	-	-	-	HU4320011635	-	ASTM A537 CL-2	-	Kg 45	-
003	-	015	015	STAY VANE WITH HOLE (TYPE-4)	0	20201 18804	005	ASTM A516 GR.65	-	ASTM A516 GR.65	-	Kg 282	-
-	001	20TK.	014	SPIRAL SEGMENT 18-19	-	-	-	HU4320011627	-	ASTM A537 CL-2	-	Kg 392	-
-	001	60TK.	013	PARTITION PLATE	-	-	-	HU4390221078	-	ASTM A537 CL-2	-	Kg 1150	-
-	001	80TK.	012	STAY VANE TYPE-1 (SEG-2)	-	-	-	BP1041059596	-	ASTM A516 GR.65	-	Kg 75	-
006	-	011	011	42.20/Dx3.56TK.x80LG SEAMLESS CARBON S. PIPE	-	-	-	AA10455	-	OFF CUT	-	Kg 0.27	-
004	004	40TK.	010	PLATE	-	-	-	OFF CUT	-	ASTM A537 CL-2	-	Kg 5.4	-
004	004	220X160	009	BLOCK	-	-	-	OFF CUT	-	ASTM A516 GR.70	-	Kg 83.0	-
001	-	130TK.	008	TOP RING HALF-2	-	-	-	HU4320011015	-	ASTM A537 CL-2	-	Kg 6850	-
-	001	130TK.	007	TOP RING HALF-1	-	-	-	HU4320011015	-	ASTM A537 CL-2	-	Kg 6850	-
001	-	130TK.	006	BOTTOM RING HALF-2	-	-	-	HU4320011015	-	ASTM A537 CL-2	-	Kg 6850	-
-	001	130TK.	005	BOTTOM RING HALF-1	-	-	-	HU4320011015	-	ASTM A537 CL-2	-	Kg 6850	-
003	003	004	004	STAY VANE TYPE-4	0	20201 18804	004	ASTM A516 GR.65	-	ASTM A516 GR.65	-	Kg 287.7	-
004	001	003	003	STAY VANE TYPE-3	0	20201 18804	003	ASTM A516 GR.65	-	ASTM A516 GR.65	-	Kg 336.9	-
-	005	002	002	STAY VANE TYPE-2	0	20201 18804	002	ASTM A516 GR.65	-	ASTM A516 GR.65	-	Kg 375.71	-
-	001	001	001	STAY VANE TYPE-1 (SEG-1)	0	20201 18804	001	ASTM A516 GR.65	-	ASTM A516 GR.65	-	Kg 290	-

ADDITIONAL INFORMATION

STATUS OF DRAWING

DISTRIBUTION OF PRINTS

TYPE OF PRODUCT OR PROJECT: 6x170 MW. V. FRANCIS TURBINE NAME OF CUSTOMER/PROJECT: PUNATSANGCHHU-II H.E.P

NAME: BHARAT HEAVY ELECTRICALS LTD BHOVAL

DRN: A.KHARE

CDK: A.MANDAL

APPD: A.MANDAL

DEPT: H.T.E

UNTL DWS. GR: 3200049014

SCALE: 1:15 & AS STATED

WEIGHT(K.G): 37550

REF TO ASSY.DRG: 0 202 01 18802

ITEM NO: 020

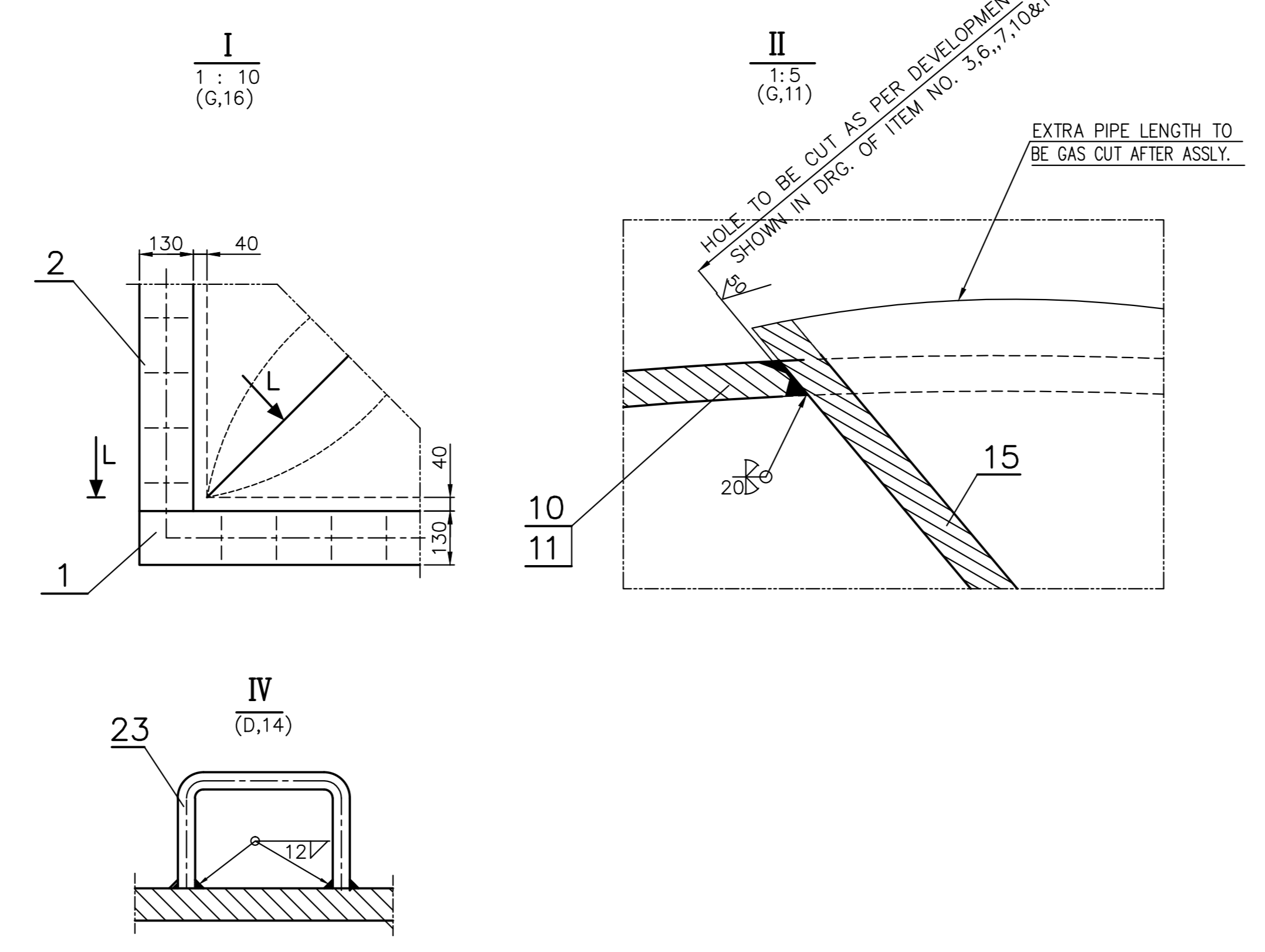
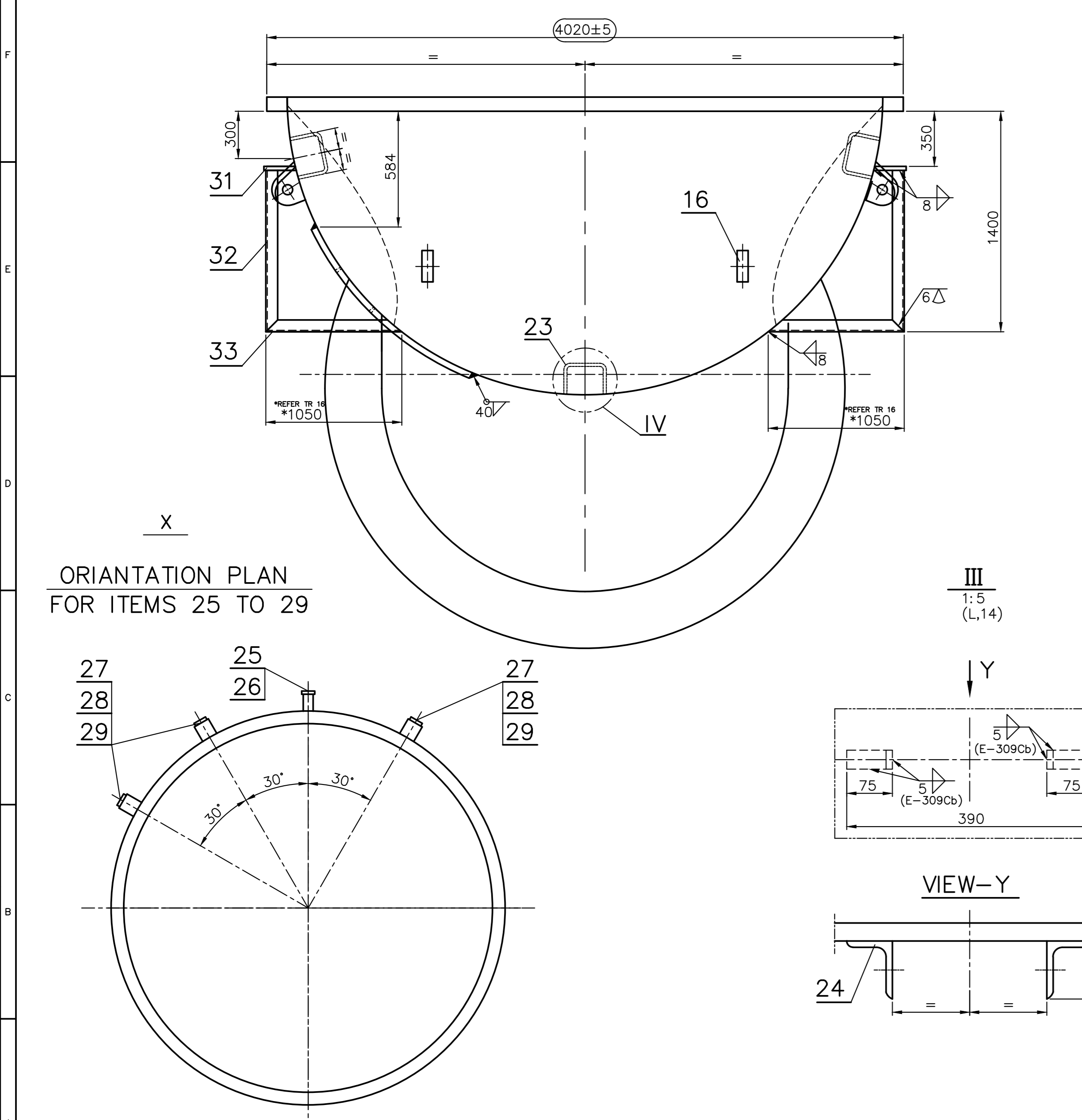
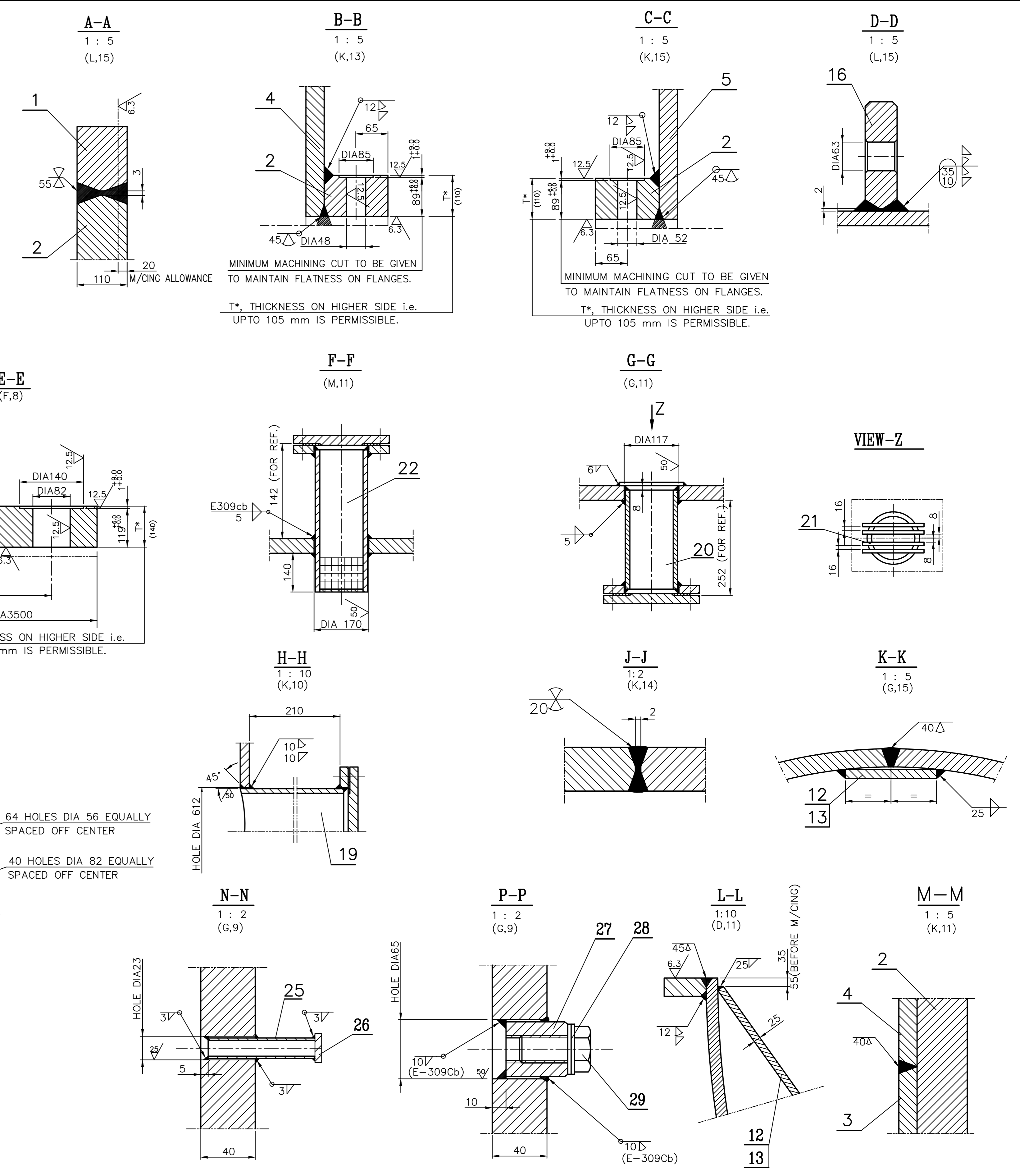
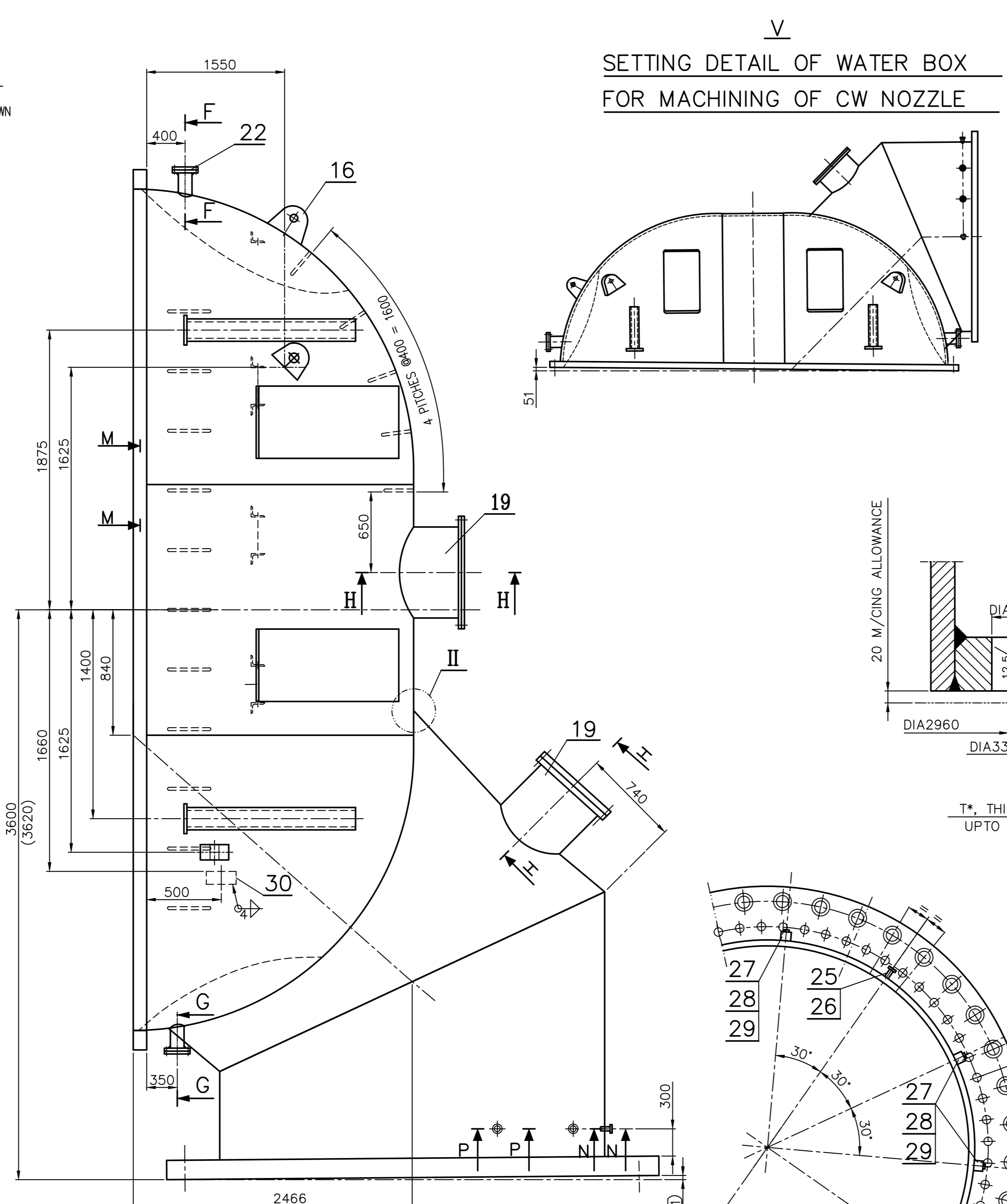
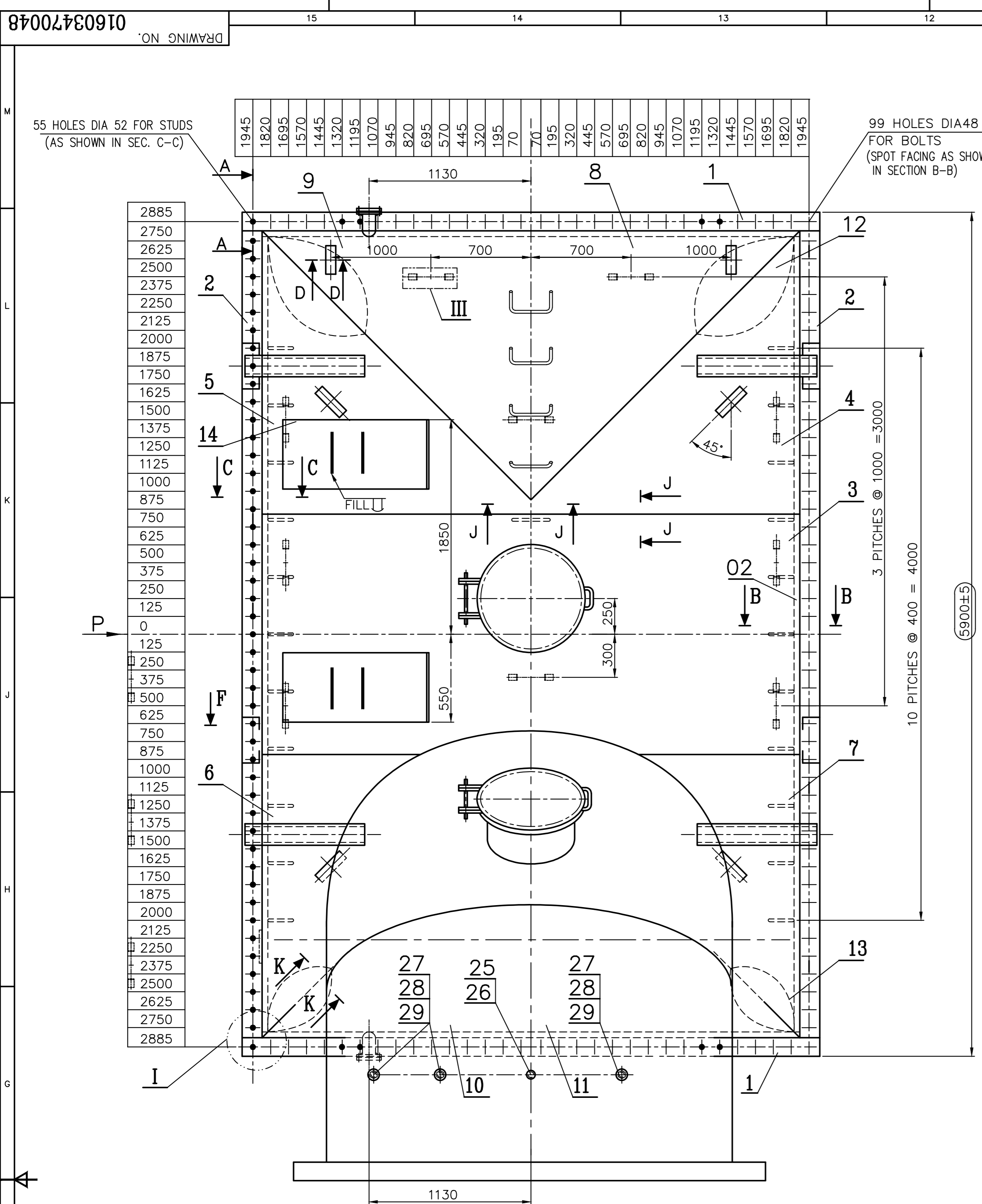
TITLE: STAY RING (FABRICATION IN HALVES)

DRAWING NO: 0 202 01 18803

SHT. NO. 01

NO. OF SHT. 02

REV.	DATE	ALTERED CHECKED APPD.	REV.	DATE	ALTERED CHECKED APPD.	REV.	DATE	ALTERED CHECKED APPD.	REV.	DATE	ALTERED CHECKED APPD.	REV.	DATE	ALTERED CHECKED APPD.



1. FABRICATED WEIGHT WITH WELD DEPOSIT	WT. (kg.)
	24837
2. FINISHED WEIGHT AFTER MACHINING	23148

- TECHNICAL REQUIREMENTS: -**
- VISUAL INSPECTION OF WELD SEAMS AS PER HW0620099. CLASSIFICATION GROUPS : -
 I) FOR ITEM NOS. 14 & 16 BS/BK.
 II) CS/BK FOR OTHER ITEMS.
 - NON DESTRUCTIVE EXAMINATION OF WELD SEAMS AS PER HW 0850199 PART 10.
 - WELD EDGE PREPARATION AS PER AA0620502.
 - THE GENERAL TOLERANCES OF STRAIGHTNESS, FLATNESS AND PARALLELISM SHALL BE MAINTAINED AS PER AA0621105 GRADE-F.
 - PAINING IS TO BE DONE AS PER HE77001.
 - ITEM NO. 31, 32 & 33 ARE TO BE REMOVED PRIOR TO FINAL DESPATCH.
 - LIFTING TO BE DONE USING ALL THE FOUR LIFTING LUGS.
 - DIMENSIONS GIVEN IN BRACKET ARE BEFORE MACHINING.
 - DIMENSIONS GIVEN FROM MACHINED FACE OF FLANGES ARE THEORETICAL. ACTUAL DIMENSION SHALL BE AS PER MACHINING CARRIED OUT ON FLANGE (SEC. B-B, C-C & E-E).
 - IDENTIFICATION PLATE ITEM NO. 30 MAY BE SUITABLE BENT MANUALLY BEFORE WELDING WITH WATER BOX.
 - THE WORD 'REAR WATER BOX (GEN. SIDE)' SHOULD BE PAINTED ATLEAST TWO PLACES ON OPPOSITE SIDES.
 - THIS INDICATES CRITICAL TO QUALITY (CTQ).
 - OUT OF FLATNESS OF MACHINED SURFACE OF RECTANGULAR FLANGE SHOULD BE WITHIN 1.5 mm IN FREE CONDITION.
 - WATER BOX IS TO BE MATCHED WITH WATER CHAMBER IN FREE STATE BEFORE DISPATCH. GAP BETWEEN WATERBOX AND WATER CHAMBER MACHINED FLANGE SURFACES DURING MATCHING SHOULD BE WITHIN 3 mm.
 - EXTRA LENGTH OF ITEM NO. 33 MAY BE CUT TO SUIT PROPER FITTING.

INVENTORY NO. / SIGN & DATE	REF. DRG. NO.	CSOM NO. 01603470048	STATUS OF DRG. APPROVED	DATE 29.5.15	TYPE OF PRODUCT OR NAME OF CUSTOMER/ PROJECT	800 MW WANAKBORI																																																																
		DRN T.BANSAL	SD.	06.05.15	DRN T.BANSAL	SD.	06.05.15	DRN T.BANSAL	SD.	06.05.15																																																												
		W.T. NAME SIGN DATE	BL. NAME SD/	29.5.15	BHARAT HEAVY ELECTRICALS LTD. HARDWAR		APP. S.KANT	SD.	30.05.15	ITEM NO. OF SHEETS 02																																																												
		REV. DATE ALTERED CHECKED	REV. DATE ALTERED CHECKED	REV. DATE ALTERED CHECKED	REV. DATE ALTERED CHECKED	DEPT. HXE	SCALE 1:20	WEIGHT(Kg.)	SEE TABLE	DRAWING NO. 01603470048																																																												
		<table border="1"> <tr> <th>SIZE & SYMBOL OF WELD SEAM LENGTH IN M.</th> <th>GRADE OF UNTOL. DIM:-</th> <th>GRADE OF UNTOL. DIM:-</th> </tr> <tr> <td>M/CC- X/B/N/F AA 0230208</td> <td>M/CC- X/B/N/F AA 0230208</td> <td>M/CC- X/B/N/F AA 0230208</td> </tr> <tr> <td>WT. OF DEPOSITED METAL</td> <td>WELDING-X/B/N/F-AA621104</td> <td>WELDING-X/B/N/F-AA621104</td> </tr> <tr> <td>TYPE OF ELECTRODE</td> <td>GAS CUTTING-T3-AA621101</td> <td>GAS CUTTING-T3-AA621101</td> </tr> </table>				SIZE & SYMBOL OF WELD SEAM LENGTH IN M.	GRADE OF UNTOL. DIM:-	GRADE OF UNTOL. DIM:-	M/CC- X/B/N/F AA 0230208	M/CC- X/B/N/F AA 0230208	M/CC- X/B/N/F AA 0230208	WT. OF DEPOSITED METAL	WELDING-X/B/N/F-AA621104	WELDING-X/B/N/F-AA621104	TYPE OF ELECTRODE	GAS CUTTING-T3-AA621101	GAS CUTTING-T3-AA621101	DEPT. HXE	SCALE 1:20	WEIGHT(Kg.)	SEE TABLE	DRAWING NO. 01603470048																																																
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M/CC- X/B/N/F AA 0230208	M/CC- X/B/N/F AA 0230208	M/CC- X/B/N/F AA 0230208																																																																				
WT. OF DEPOSITED METAL	WELDING-X/B/N/F-AA621104	WELDING-X/B/N/F-AA621104																																																																				
TYPE OF ELECTRODE	GAS CUTTING-T3-AA621101	GAS CUTTING-T3-AA621101																																																																				
		<table border="1"> <tr> <th>10 b</th><th>10P</th><th>5 P</th><th>4 P</th><th>40FILL</th><th>55A</th><th>45A</th><th>40A</th><th>20A</th><th>35 b</th><th>20 b</th><th>12 b</th><th>10 b</th><th>40P</th><th>25P</th><th>12P</th><th>10P</th><th>5 P</th><th>3 P</th> </tr> <tr> <td>0.79</td><td>0.79</td><td>8.72</td><td>0.67</td><td>1.88</td><td>1.04</td><td>19.6</td><td>16.20</td><td>21.64</td><td>1.88</td><td>15.16</td><td>17.14</td><td>2.76</td><td>7.84</td><td>16.25</td><td>20.03</td><td>7.04</td><td>0.05</td><td>0.72</td><td>0.14</td> </tr> <tr> <td>0.57</td><td>0.43</td><td>1.16</td><td>0.06</td><td>13.40</td><td>10.9</td><td>90.3</td><td>95.3</td><td>29.87</td><td>14.76</td><td>33.5</td><td>14.57</td><td>1.99</td><td>56.3</td><td>42.08</td><td>14.92</td><td>3.81</td><td>0.10</td><td>0.10</td><td>0.01</td> </tr> </table>				10 b	10P	5 P	4 P	40FILL	55A	45A	40A	20A	35 b	20 b	12 b	10 b	40P	25P	12P	10P	5 P	3 P	0.79	0.79	8.72	0.67	1.88	1.04	19.6	16.20	21.64	1.88	15.16	17.14	2.76	7.84	16.25	20.03	7.04	0.05	0.72	0.14	0.57	0.43	1.16	0.06	13.40	10.9	90.3	95.3	29.87	14.76	33.5	14.57	1.99	56.3	42.08	14.92	3.81	0.10	0.10	0.01	CODE 4222	SCALE 1:20	WEIGHT(Kg.)	SEE TABLE	SHEET NO. 01	NO. OF SHEETS 02
10 b	10P	5 P	4 P	40FILL	55A	45A	40A	20A	35 b	20 b	12 b	10 b	40P	25P	12P	10P	5 P	3 P																																																				
0.79	0.79	8.72	0.67	1.88	1.04	19.6	16.20	21.64	1.88	15.16	17.14	2.76	7.84	16.25	20.03	7.04	0.05	0.72	0.14																																																			
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REV.	DATE	ALTERED	CHECKED	REV.	DATE	ALTERED	CHECKED	REV.	DATE	ALTERED	CHECKED	REV.	DATE	ALTERED	CHECKED																																																							