ड्रॉइंग संख्या/DRAWING NO. 11604570024

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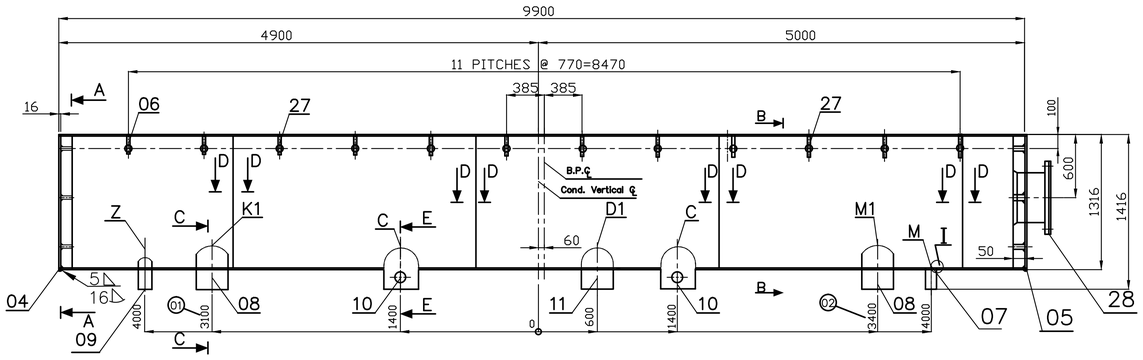
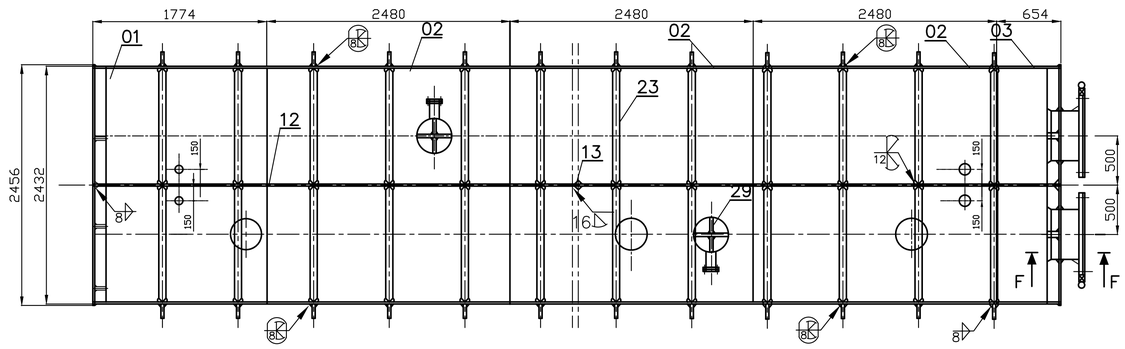
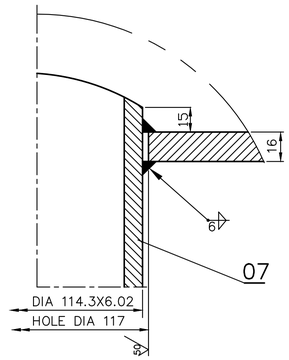
THE REST.

TURBINE SIDE VIEW

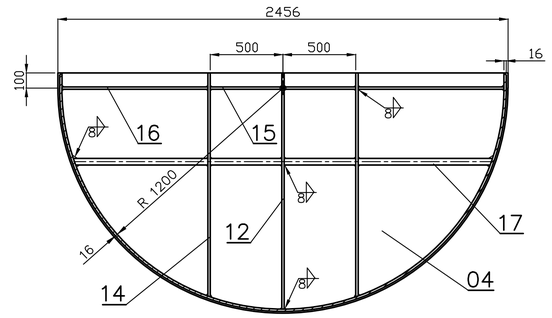




DETAIL–I



A–A



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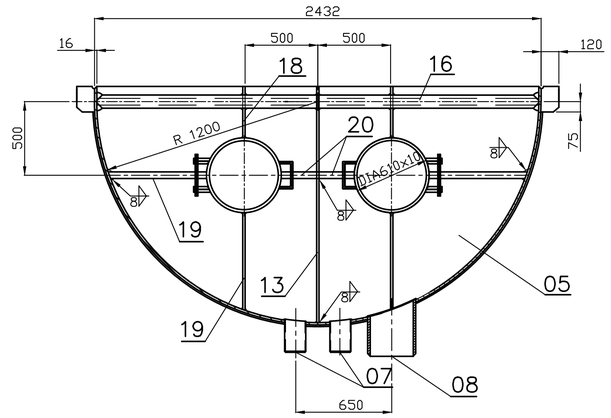

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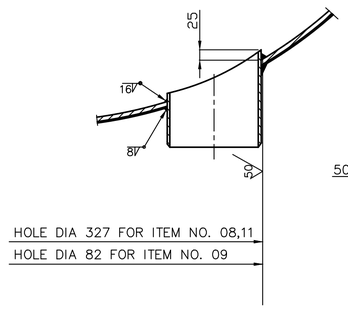
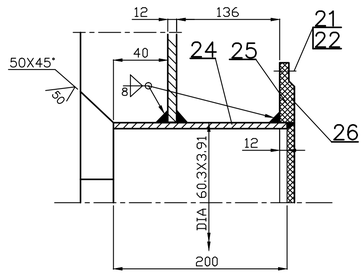
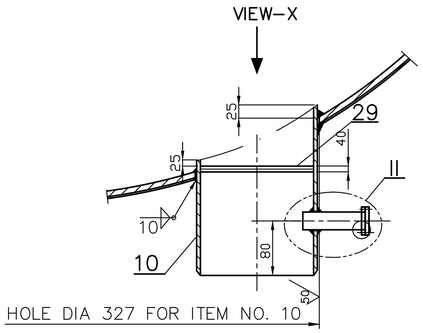
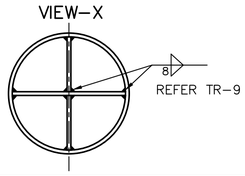


DETAIL–II

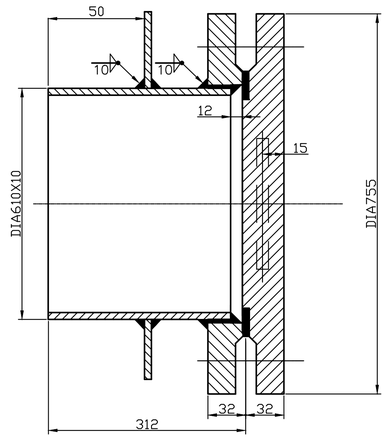


SECTION E–E
DETAIL OF NOZZLE WELD

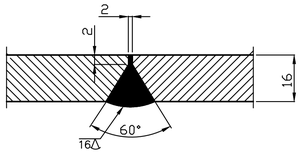




SECTION F–F



D–D



TECHNICAL REQUIREMENTS: –

1. THE EGDE OF THE STIFFENERS TO BE WELDED WITH THE CURVED PORTION OF HOTWELL/MANHOLE NOZZLE SHOULD BE GROUND SMOOTH, IF REQUIRED, FOR PROPER MATCHING.
2. QUALITY NOTE: –
   (i) VISUAL INSPECTION OF WELD SEAM AS PER PS HW 0620099,CLASSIFICATION GROUP CS/BK FOR ITEM NO. 01 TO 05.
   CS/CK FOR THE REST.
   (ii) NON DESTRUCTIVE EXAMINATION OF WELD SEAM AS PER HW 0850199 (PART 10).
3. PAINTING: – PAINTING IS TO BE DONE AS PER HXE PRODUCT STD. NO HE 77001.
4. GENERAL TOLERANCES ON STRAIGHTNESS, FLATNESS AND PARALLELISM SHALL BE MAINTAINED AS PER AA0621105 GRADE – F.
5. HOLE DIA 30 MAY BE MADE ON ITEM NO. 27 FOR LIFTING/HANDLING OF HOTWELL.
6. LIFTING TO BE DONE USING ITEM NO. 27 AT FOUR LOCATIONS SIMULTANEOUSLY.
7. ⬭ THIS INDICATES CRITICAL TO QUALITY (CTQ).
8. EXCESS PROJECTION OF NOZZLES (ITEM NO 07 TO 11) SHOULD BE CUT AS SHOWN IN DETAIL OF NOZZLE WELD.
9. ONE PIECE OF ITEM NO. 29 TO BE CUT TO SUITABLE FOR MAKING CROSS STIFFENING.

10▷	16◺	16△	12◺	8⟨	8▷	6▷	SIZE & SYMBOL OF SEAM
2.26	4.24	25.48	3.77	4.2	8.7	0.72	WELD LENGTH (M).
1.22	5.89	35.42	3.21	4.12	5.86	0.16	WT. OF WELD METAL (Kg).
E–309Cb	E–7018						TYPE OF ELECTRODE

असत्य विमाओं का वर्ग
GRADE OF UNTOLERANCED DIMENSION
मशीनिंग - एए0230208 एम
MACHINING – AA0230208 m
वेल्डिंग - एए0621104 की श्रेणी बी
WELDING–CLASS 'B' OF AA0621104
गैस कटिंग - एए0621101 की सारणी 3
GAS CUTTING–TABLE 3 OF AA0621101

संशोधन REV. 02	दिनांक DATE 19.06.18	संशोधनकर्ता ALTERED BY ANIL	सत्यापनकर्ता CHD MUKESH
HXE–18–F0078			
CHANGE AS MARKED (02)			

सी.बी.ओ.एम./C.B.O.M. 11604570024			
संशोधन REV. 01	दिनांक DATE 29.05.18	संशोधनकर्ता ALTERED BY ANIL	सत्यापनकर्ता CHD MUKESH
HXE–18–F0060			
CHANGE AS MARKED (01)			

अभिकल्प का स्तर STATUS OF DRG.	U		
AGRED. DEPTT.	नाम/NAME	हस्ताक्षर/SIGN	दिनांक/DATE
वेल्डिंग टेक्नो.	MANISH	ह.	–

उत्पाद का प्रकार या ग्राहक/परियोजना का नाम
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

660 MW MAITREE

भारत हेवी इलेक्ट्रिकल्स लिमिटेड, रानीपुर, हरिद्वार
BHARAT HEAVY ELECTRICALS LIMITED, RANIPUR, HARDWAR

	नाम/NAME	हस्ताक्षर/SIGN	दिनांक/DATE	संशोधन संख्या No. of Ver.
डिज़ाइनकर्ता DSN.	ANIL	sd/–	23.11.17	–
जांचकर्ता CHD	MUKESH	sd/–	23.11.17	
स्वीकृतकर्ता APPD	R.BANSAL	sd/–	23.11.17	

विभाग DEPTT.	हेड एक्सचेंजर अभि. HXE	अनुपात/SCALE 1:30	भार कि.ग्रा. WEIGHT (KG) 7947.3	असेम्बली अभिकल्प का संदर्भ REFER TO ASSLY. DRG. –
कोड/CODE 4222				

नग क्रमांक ITEM NO.	नगों की संख्या NO. OF ITEMS		
–	–		

शीर्षक/TITLE
HOT WELL–II

कार्ड कोड CARD CODE

अभिकल्प संख्या/DRAWING NO. 7 11604570024 22 23 24 02

कुल पन्ना/Sheets No. 01 कुल की संख्या/No. of Sheets 01

A1 साइज/A1 SIZE

अस्वीकृति एवं चेतावनी
इस प्रलेख में दर्शाई सामग्री भारत हेवी इलेक्ट्रिकल्स लिमिटेड के स्वामित्व में है, इसका पूरा या आंशिक रूप से बिना लिखित रूप से इसकी अनुमति लिए नहीं किया जाना चाहिए।

मास्टर सूची संख्या/INVENTORY NO.
डिज़ाइन अभिकल्प संदर्भ/REFERENCE DRG.NO.
हस्ताक्षर और दिनांक/SIGN & DATE