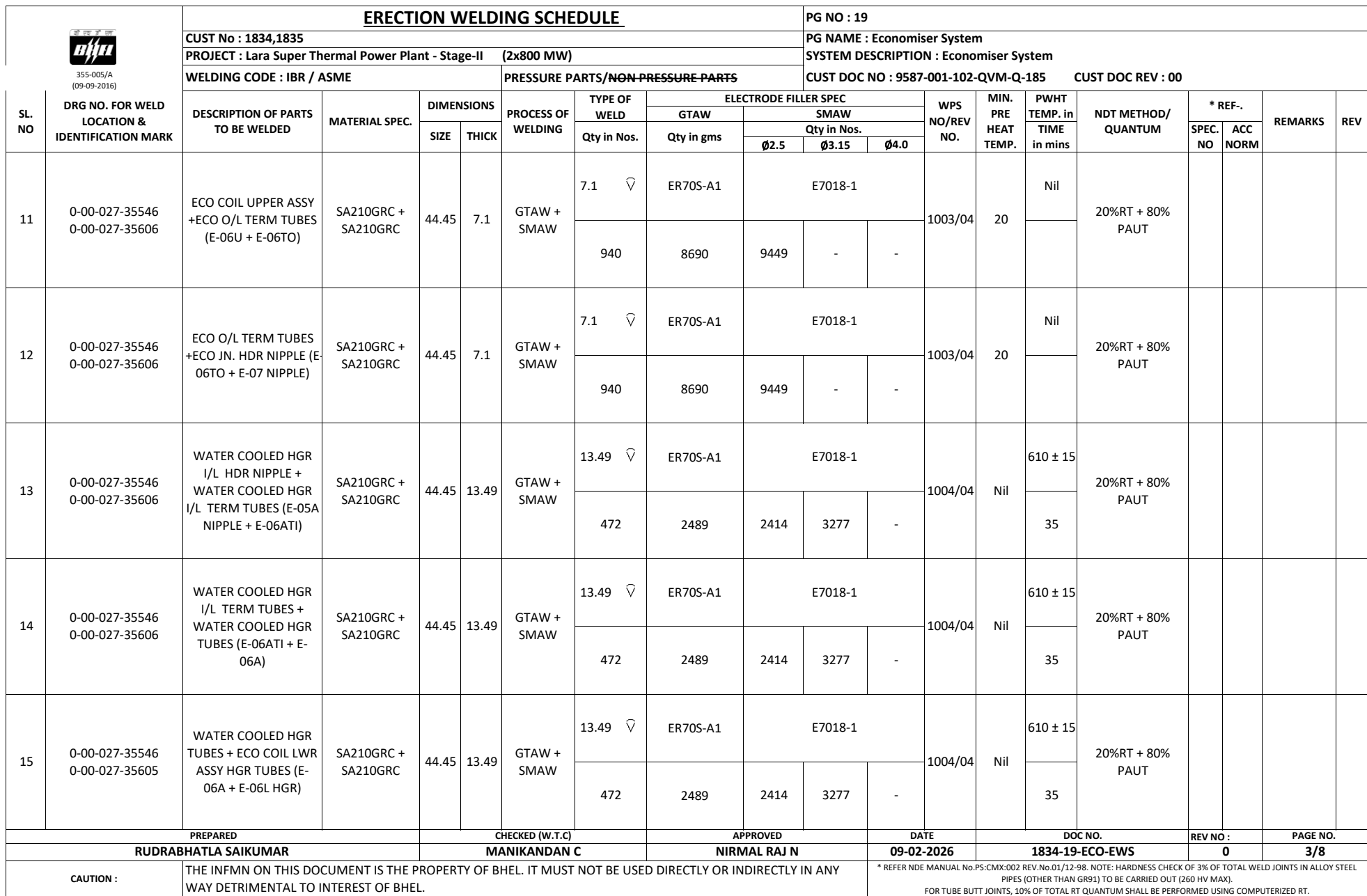




 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 19						
CUST No : 1834,1835													PG NAME : Economiser System						
PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)													SYSTEM DESCRIPTION : Economiser System						
WELDING CODE : IBR / ASME						PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00								
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
									Ø2.5	Ø3.15					Ø4.0				
6	2-19-850-05101 0-00-027-35571	WATER COOLED HGR I/L HDR LINK + WATER COOLED HGR I/L HDR (E-04.01 + E.05A)	SA106GRC + SA106GRC	219.1	36	GTAW + SMAW	31.50 ∇∇	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% RT 100% MPI/LPI				
						1	71	16	26	55		90							
7	0-00-027-35546	ECO I/L HDR NIPP+ECO I/L TERM TUBE (E-05 NIPPLE + E-06TI)	SA210GRC + SA210GRC	44.45	7.1	GTAW + SMAW	7.1 ∇	ER70S-A1	E7018-1			1003/04	20	Nil	20%RT + 80% PAUT				
						940	8690	9449	-	-									
8	0-00-027-35546	ECO I/L TERM TUBE +ECO COIL LWR ASSY (E-06TI + E-06L)	SA210GRC + SA210GRC	44.45	7.1	GTAW + SMAW	7.1 ∇	ER70S-A1	E7018-1			1003/04	20	Nil	20%RT + 80% PAUT				
						940	8690	9449	-	-									
9	0-00-027-35546	ECO COIL LWR ASSY +ECO COIL INTER ASSY (E-06L + E-06I)	SA210GRC + SA210GRC	44.45	7.1	GTAW + SMAW	7.1 ∇	ER70S-A1	E7018-1			1003/04	20	Nil	20%RT + 80% PAUT				
						940	8690	9449	-	-									
10	0-00-027-35546	ECO COIL INTER ASSY +ECO COIL UPPER ASSY (E-06I + E-6U)	SA210GRC + SA210GRC	44.45	7.1	GTAW + SMAW	7.1 ∇	ER70S-A1	E7018-1			1003/04	20	Nil	20%RT + 80% PAUT				
						940	8690	9449	-	-									
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
RUDRABHATLA SAIKUMAR				MANIKANDAN C				NIRMAL RAJ N			09-02-2026		1834-19-ECO-EWS		0		2/8		
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.										* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.							





 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 19						
CUST No : 1834,1835													PG NAME : Economiser System						
PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)													SYSTEM DESCRIPTION : Economiser System						
WELDING CODE : IBR / ASME						PRESSURE PARTS/ NON-PRESSURE PARTS						CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00							
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
							Qty in Nos.		Qty in gms	Qty in Nos.									
										Ø2.5					Ø3.15	Ø4.0			
16	0-00-027-35546	ECO COIL LWR ASSY HGR TUBES + ECO COIL INTER ASSY HGR TUBES (E-06L HGR + E-06I-HGR)	SA210GRC + SA210GRC	44.45	13.49	GTAW + SMAW	13.49 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
						472	2489	2414	3277	-		35							
17	0-00-027-35546	ECO COIL INTER ASSY HGR TUBES + ECO COIL UPR ASSY HGR TUBES (E-06I HGR + E-06U-HGR)	SA210GRC + SA210GRC	44.45	13.49	GTAW + SMAW	13.49 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
						472	2489	2414	3277	-		35							
18	0-00-027-35546	ECO COIL UPR ASSY HGR TUBES + WATER COOLED HGR O/L TERM TUBES (E-06U HGR + E-06ATO)	SA210GRC + SA210GRC	44.45	13.49	GTAW + SMAW	13.49 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
						472	2489	2414	3277	-		35							
19	0-00-027-35546	WATER COOLED HGR O/L TERM TUBES + ECO JN. HDR NIPPLES (E-06ATO + E-07 NIPPLE)	SA210GRC + SA210GRC	44.45	13.49	GTAW + SMAW	13.49 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
						472	2489	2414	3277	-		35							
20	0-00-027-35544 0-00-027-35606	ECO JN. HDR NIPPLE +ECO LWR HGR TUBE (E-07 NIPPLE + E-08L)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
						476	6087	4792	5498	-		40							
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
RUDRABHATLA SAIKUMAR				MANIKANDAN C				NIRMAL RAJ N			09-02-2026		1834-19-ECO-EWS		0		4/8		
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.										* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.							



 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 19									
CUST No : 1834,1835										PG NAME : Economiser System												
PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Economiser System												
WELDING CODE : IBR / ASME						PRESSURE PARTS/ NON-PRESSURE PARTS						CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00										
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV				
				SIZE	THICK			GTAW	SMAW													
									Qty in Nos.													
									Ø2.5	Ø3.15					Ø4.0							
21	0-00-027-35544	ECO LWR HGR TUBE +ECO HGR TUBE (LTRH LWR ASSY) (E-08L + R-04L HANGER)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT							
476	6087	4792	5498	-	40																	
22	0-00-027-35544	ECO HGR TUBE (LTRH LWR ASSY)+ECO HGR TUBE (LTRH LWR INTER ASSY) (R-04L HGR + R-04LI HGR)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT							
476	6087	4792	5498	-	40																	
23	0-00-027-35544	ECO HGR TUBE (LTRH LWR INTER ASSY)+ECO HGR TUBE (LTRH INTER ASSY) (R-04LI HGR + R-04I HGR)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT							
476	6087	4792	5498	-	40																	
24	0-00-027-35544	ECO HGR TUBE (LTRH INTER ASSY)+ECO HGR TUBE (LTRH UPR INTER ASSY) (R-04I HANGER + R-04UI HANGER)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT							
476	6087	4792	5498	-	40																	
25	0-00-027-35544	ECO HGR TUBE (LTRH UPR INTER ASSY)+ECO HGR TUBE (LTRH UPR ASSY) (R-04UI HANGER + R-04U HANGER)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT							
476	6087	4792	5498	-	40																	
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.				
RUDRABHATLA SAIKUMAR				MANIKANDAN C				NIRMAL RAJ N				09-02-2026		1834-19-ECO-EWS		0		5/8				
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 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 19						
CUST No : 1834,1835										PG NAME : Economiser System									
PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Economiser System									
WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00									
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
									Ø2.5	Ø3.15					Ø4.0				
26	0-00-027-35544	ECO HGR TUBE (LTRH UPR ASSY)+ECO UPR HGR TUBE (R-04U HGR + E-08U)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
476	6087	4792	5498	-	40														
27	0-00-027-35544 0-00-027-35574	ECO UPR HGR TUBE +ECO HGR O/L TERM TUBE (E-08U + E-08TO)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
476	6087	4792	5498	-	40														
28	0-00-027-35544 0-00-027-35574	ECO HGR O/L TERM TUBE +ECO O/L HDR NIPPLE (E-08TO + E-09 NIPP)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
476	6087	4792	5498	-	40														
29	0-00-027-35580	ECO JN. HDR NIPPLE + ECO HGR TUBE (LTRH HDR SUPPT) (E-07 NIPP + E-08X)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
40	512	403	462	-	40														
30	0-00-027-35580	ECO HGR TUBE (LTRH HDR SUPPT)+ECO HGR TUBE (LTRH HDR SUPPT) (E-08X + E-08X)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ▽	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
160	2046	1611	1848	-	40														
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
RUDRABHATLA SAIKUMAR				MANIKANDAN C				NIRMAL RAJ N			09-02-2026		1834-19-ECO-EWS		0		6/8		
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 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 19						
CUST No : 1834,1835										PG NAME : Economiser System									
PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Economiser System									
WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00									
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
									Ø2.5	Ø3.15					Ø4.0				
31	0-00-027-35580	ECO HGR TUBE(LTRH HDR SUPPT)+ECO O/L HDR NIPPLE (E-08X + E-09 NIPPLE)	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ∇	ER70S-A1	E7018-1			1004/04	Nil	610 ± 15	20%RT + 80% PAUT				
						40	512	403	462	-		40							
32	0-19-851-02645 0-00-027-35571	ECO O/L HDR+ECO O/L LINK (E-09 + EF-01)	SA106GRC + SA106GRC	508	70	GTAW + SMAW	61.25 ∇∇	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							2	341	73	120	871		175						
33	0-19-851-02645 0-00-027-35571	ECO O/L LINK+ECO O/L LINK (EF-01 + EF-01)	SA106GRC + SA106GRC	508	70	GTAW + SMAW	61.25 ∇∇	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							18	3069	656	1075	7832		175						
34	0-19-851-02645 0-19-852-02665 0-00-027-35571	ECO O/L LINK+ECO MIXING LINE (EF-01 + EF-02)	SA106GRC + SA234WPC	508	70	GTAW + SMAW	61.25 ∇∇	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							2	341	73	120	871		175						
35	0-19-852-02665 0-19-853-02646 0-00-027-35571	ECO MIXING LINE+ECO WW I/L LINK (EF-02 + EF-03)	SA234WPC + SA106GRC	508	70	GTAW + SMAW	61.25 ∇∇	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							2	341	73	120	871		175						
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
RUDRABHATLA SAIKUMAR				MANIKANDAN C				NIRMAL RAJ N				09-02-2026		1834-19-ECO-EWS		0		7/8	
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.										* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.							

 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 19							
		CUST No : 1834,1835										PG NAME : Economiser System							
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Economiser System							
		WELDING CODE : IBR / ASME					PRESSURE PARTS/NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 00							
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
							Qty in Nos.		Qty in gms	Qty in Nos.					Ø2.5	Ø3.15			Ø4.0
36	0-19-853-02646 0-00-027-35571	ECO WW I/L LINK+ECO WW I/L LINK (EF-03 + EF-03)	SA106GRC + SA106GRC	508	70	GTAW + SMAW	61.25 ∇∇	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							4	682	146	239	1741			175					
37	0-19-853-02646 0-00-027-35571	ECO WW I/L LINK+FURN SIDE I/L HDRS (EF-03 + F-16 L&R)	SA106GRC + SA234WPC	508	70	GTAW + SMAW	61.25 ∇∇	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% (ISRT+UT) 100% MPI/LPI				
							2	341	73	120	871			175					
38	0-19-753-02639 0-19-763-02643 0-19-783-02666 0-19-793-02668	ECO INTER HDRS:INSP. NOZZLE + FLAT END COVER	SA105 + SA105	168.3	45.4	GTAW + SMAW	39.72 ∇∇	ER70S-A1	E7018-1			1004/04	100	610 ± 15	100% RT 100% MPI/LPI				
							8	328	97	159	451			115					
39		GAMMA PLUG	SA105 + SA106GRC			SMAW	7 ∇	-	E7018			1101/01	150	Nil	100% LPI or MPI			FOR T >75 MM	
							23	-	6	-	-								
40		GAMMA PLUG	SA105 + SA106GRC			SMAW	7 ∇	-	E7018			1101/01	100	Nil	100% LPI or MPI			FOR T- (25-75) MM	
							43	-	11	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
RUDRABHATLA SAIKUMAR				MANIKANDAN C				NIRMAL RAJ N			09-02-2026		1834-19-ECO-EWS		0		8/8		
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.										* REFER NDE MANUAL No.P5:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.							

 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 12							
		CUST No : 1834,1835										PG NAME : Superheater System							
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Superheater System							
		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01							
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT TEMP. in °C	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK		Qty in Nos.	GTAW	SMAW				TIME in mins		SPEC. NO	ACC NORM REF.			
									Qty in gms	Qty in Nos.									
									Ø2.5	Ø3.15	Ø4.0								
1	2-12-850-03559 TO 2-12-850-03566 0-00-027-35568	SEPARATOR+ SH CONNECTING PIPE (F-31 NOZZLE + S-01)	SA182F22CL3 + SA335P12	273	50	GTAW + SMAW	43.75 ∇∇	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI			NDT after SR	01
							8	666	157	257	1020			125					
2	2-12-850-03559 TO 2-12-850-03566	SH CONN. PIPE+ SH CONN. PIPE (S-01 + S-01)	SA335P12 + SA234WP12CL1	273	50	GTAW + SMAW	43.75 ∇∇	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							32	2661	627	1027	4079			125					
3	2-12-850-03559 TO 2-12-850-03566 0-00-027-35569	SH CONNECTING PIPE + SH FURNACE ROOF I/L HDR (S-01 + S-02 TEE)	SA335P12 + SA234WP12CL1	273	50	GTAW + SMAW	43.75 ∇∇	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							8	666	157	257	1020			125					
4	0-00-027-35549 0-00-027-35569	SH FURNACE ROOF I/L HEADER + SH FURN ROOF PANEL/LT (S-02 NIPPLE + S-03/S-03LT)	SA213T12 + SA213T12	54	8.13	GTAW + SMAW	8.13 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							208	2407	1928	300	-								
5	0-00-027-35549 0-00-027-35569	SH FURN ROOF I/L HDR /SH FURN ROOF PANEL + LOOSE TUBE (S-02 NIPP/S-03 + S-03LT)	SA213T12 + SA213T12	50.8	8.64	GTAW + SMAW	8.64 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							4	42	34	8	-								
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-12-SH-EWS		1		1/20		
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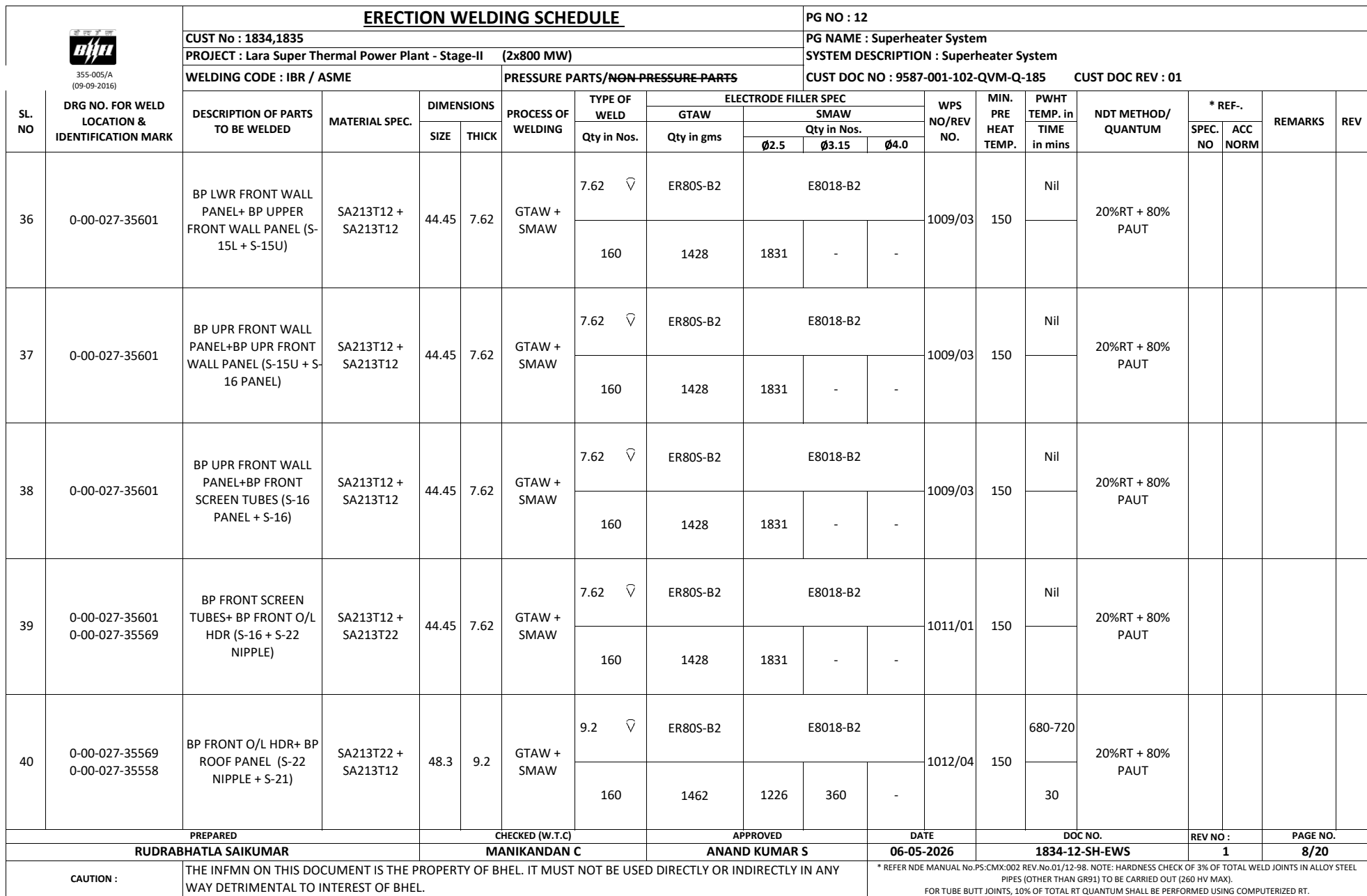
 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 12									
		CUST No : 1834,1835										PG NAME : Superheater System									
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Superheater System									
		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01									
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV			
				SIZE	THICK			GTAW	SMAW												
									Qty in gms	Qty in Nos.											
								Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM					
6	0-00-027-35549 0-00-027-35569	SH FURN ROOF PNL LOOSE TUBE +SH FURN ROOF PANEL (S-03LT + S-03)	SA213T12 + SA213T12	54	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT						
							32	371	297	47	-										
7	0-00-027-35549 0-00-027-35569	SH FURN ROOF PANEL +SH FURN ROOF TUBES (S-03 + S-04A)	SA213T12 + SA213T12	60.3	10.16	GTAW + SMAW	10.16 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT						
							210	2577	2043	796	-										
8	0-00-027-35549 0-00-027-35569	SH FURN ROOF TUBE +SH FURN ROOF TUBES (S-04A + S-04B)	SA213T12 + SA213T12	60.3	10.16	GTAW + SMAW	10.16 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT						
							210	2577	2043	796	-										
9	0-00-027-35549 0-00-027-35569	SH FURN ROOF TUBES+SH FURN ROOF O/L HDR (S-04B + S-05 NIPPLE)	SA213T12 + SA213T22	60.3	10.16	GTAW + SMAW	10.16 ▽	ER80S-B2	E8018-B2			1012/04	150	680-720	20%RT + 80% PAUT						
							210	2577	2043	796	-			30							
10	0-00-027-35569 0-00-027-35579	SH FURN ROOF O/L HDR ELBOW+BP EXT SIDE I/L HDR (S-05 ELBOW + S-06 TEE)	SA234WP22CL1 + SA234WP12CL1	406.4	80	GTAW + SMAW	70.00 ▽▽	ER80S-B2	E8018-B2			1012/04	150	680-720	100% (ISRT+UT) 100% MPI/LPI			NDT after SR	01		
							2	237	59	96	818			200							
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.				
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-12-SH-EWS		1		2/20				
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 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 12						
CUST No : 1834,1835										PG NAME : Superheater System									
PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Superheater System									
WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01									
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW Qty in gms	SMAW Qty in Nos.										
									Ø2.5	Ø3.15					Ø4.0				
11	0-00-027-35579	BP EXT SIDE I/L HDR+BP EXT SIDE WALL PANEL (S-06 NIPPLE + S-07 L&R)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							172	1535	1968	-	-								
12	0-00-027-35579	BP EXT SIDE WALL PANEL LOOSE TUBES + BP EXT SIDE WALL PANEL (S-07 L&R LT+ S-07 L&R)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							26	232	298	-	-								
13	0-00-027-35579	BP EXT SIDE WALL PANEL+BP EXT SIDE FLOOR PANEL (S-07 L&R + S-08 L&R)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							172	1535	1968	-	-								
14	0-00-027-35579	BP EXT SIDE FLOOR PANEL + BP EXT SIDE FLOOR PANEL (S-08 L&R + S-08TOA/B)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							172	1535	1968	-	-								
15	0-00-027-35579 0-00-027-36584	BP EXT SIDE FLOOR PANEL + BP EXT SIDE FLOOR PANEL LOOSE TUBES (S-08TOA/B + S-08 LT)	SA213T12 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							172	1535	1968	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-12-SH-EWS		1		3/20		
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 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 12							
		CUST No : 1834,1835										PG NAME : Superheater System							
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Superheater System							
		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON -PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01							
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW						SPEC. NO	ACC NORM			
									Qty in Nos.										
									Ø2.5	Ø3.15									Ø4.0
26	0-00-027-35601	BP UPR SIDE I/L HDR +BP UPR SIDE WALL PANEL (S-11 NIPPLE + S-12U L&R)	SA213T12 + SA213T12	50.8	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							278	2941	2394	384	-								
27	0-00-027-35601	BP UPR SIDE WALL PANEL+ BP INTER SIDE WALL PANEL (S-12U L&R + S-12I L&R)	SA213T12 + SA213T12	50.8	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							278	2941	2394	384	-								
28	0-00-027-35601	BP INTER SIDE WALL PANEL+ BP LWR SIDE WALL PANEL (S-12I L&R + S-12L L&R)	SA213T12 + SA213T12	50.8	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							278	2941	2394	384	-								
29	0-00-027-35601	LTRH OPENING LOOSE TUBES L&R	SA213T12 + SA213T12	50.8	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							40	424	345	56	-								
30	0-00-027-35601	BP LWR SIDE WALL PANEL + BP LWR SIDE WALL PANEL LOOSE TUBES (S-12L L&R + S-13 LT)	SA213T12 + SA213T22	50.8	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1012/04	150	680-720	20%RT + 80% PAUT				
							16	170	138	23	-			30					
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S				06-05-2026		1834-12-SH-EWS		1		6/20	
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 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 12						
			CUST No : 1834,1835										PG NAME : Superheater System						
			PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Superheater System						
			WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01						
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
								Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM			
31	0-00-027-35601	BP LWR SIDE WALL PANEL+ BP LOWER SIDE HDR NIPPLES (S-12L L&R + S-13 L&R NIPPLE)	SA213T12 + SA213T22	50.8	8.13	GTAW + SMAW	8.13 ∇	ER80S-B2	E8018-B2			1012/04	150	680-720	20%RT + 80% PAUT				
							262	2772	2256	362	-		30						
32	0-00-027-35601	BP LWR SIDE WALL PANEL LOOSE TUBES + BP LOWER SIDE HDR NIPPLES (S-13 LT + S-13 L&R NIPPLE)	SA213T22 + SA213T22	50.8	8.13	GTAW + SMAW	8.13 ∇	ER90S-B3	E9018-B3			1014/03	150	680-720	20%RT + 80% PAUT				
							16	170	138	23	-		30						
33	0-00-027-35601 0-00-027-35572	BP LWR FRONT WALL + BP LWR FRONT WALL PANEL LOOSE TUBES (S-15L + S-14LT/S-13 LT)	SA213T12 + SA213T22	44.45	7.62	GTAW + SMAW	7.62 ∇	ER80S-B2	E8018-B2			1011/01	150	Nil	20%RT + 80% PAUT				
							12	108	138	-	-								
34	0-00-027-35601	BP LWR FRONT HDR+ BP LOWER FRONT WALL PANEL (S-14 NIPPLE + S-15L)	SA213T22 + SA213T12	44.45	7.62	GTAW + SMAW	7.62 ∇	ER80S-B2	E8018-B2			1011/01	150	Nil	20%RT + 80% PAUT				
							148	1321	1694	-	-								
35	0-00-027-35601 0-00-027-35572	BP LWR FRONT WALL PANEL LOOSE TUBES+ BP LWR FRONT/SIDE HDR(S-14LT/S-13LT + S-14/S-13)	SA213T22 + SA213T22	44.45	7.62	GTAW + SMAW	7.62 ∇	ER90S-B3	E9018-B3			1013/02	150	Nil	20%RT + 80% PAUT				
							12	108	138	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-12-SH-EWS		1		7/20		
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 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 12							
		CUST No : 1834,1835										PG NAME : Superheater System							
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Superheater System							
		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01							
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
								Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM			
41	0-00-027-35601	BP ROOF PANEL+ BP UPPER REAR WALL PANEL (S-21 + S-20U)	SA213T12 + SA213T12	48.3	9.2	GTAW + SMAW	9.2 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							160	1462	1226	360	-								
42	0-00-027-35601	BP UPR REAR WALL PANEL+ BP INTER REAR WALL PANEL (S-20U + S-20I)	SA213T12 + SA213T12	48.3	9.2	GTAW + SMAW	9.2 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							160	1462	1226	360	-								
43	0-00-027-35601	BP INTER REAR WALL PANEL+ BP LOWER REAR WALL PANEL (S-20I + S-20L)	SA213T12 + SA213T12	48.3	9.2	GTAW + SMAW	9.2 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT				
							160	1462	1226	360	-								
44	0-00-027-35601 0-00-027-35572	BP LOWER REAR WALL PANEL + BP LOWER REAR WALL PANEL LOOSE TUBES (S-20L + S-13LT/S-17LT)	SA213T12 + SA213T22	48.3	9.2	GTAW + SMAW	9.2 ▽	ER80S-B2	E8018-B2			1012/04	150	680-720	20%RT + 80% PAUT				
							8	74	62	18	-			30					
45	0-00-027-35601 0-00-027-35572	BP LWR REAR WALL + BP LWR REAR HDR (S-20L+S-17 NIPP)	SA213T12 + SA213T22	48.3	9.2	GTAW + SMAW	9.2 ▽	ER80S-B2	E8018-B2			1012/04	150	680-720	20%RT + 80% PAUT				
							152	1389	1165	342	-			30					
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S				06-05-2026		1834-12-SH-EWS		1		9/20	
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 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 12						
CUST No : 1834,1835										PG NAME : Superheater System									
PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Superheater System									
WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01									
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW Qty in gms	SMAW Qty in Nos.										
									Ø2.5	Ø3.15					Ø4.0				
51	1-12-852-02195 0-00-027-35548	LINK FROM BP FRNT O/L HDR+LINK FROM BP FRNT O/L HDR (S-25A + S-25A)	SA335P12 + SA234WP12CL1	457	75	GTAW + SMAW	65.62 ∩∩	ER80S-B2	E8018-B2		1010/06	150	650-670	100% (ISRT+UT) 100% MPI/LPI			NDT after SR	01	
							4	578	132	215	1709		190						
52	1-12-852-02195 0-00-027-35548	LINK FROM BP FRNT O/L HDR+ LINK TO PLATEN SH (S-25A + S25B)	SA335P12 + SA335P12	457	75	GTAW + SMAW	65.62 ∩∩	ER80S-B2	E8018-B2		1010/06	150	650-670	100% (ISRT+UT) 100% MPI/LPI			NDT after SR	01	
							2	289	66	108	855		190						
53	1-12-852-02196 0-00-027-35547	LINK TO PLATEN SH+ LINK TO PLATEN SH (S-25B + S-25B)	SA335P12 + SA234WP12CL1	457	75	GTAW + SMAW	65.62 ∩∩	ER80S-B2	E8018-B2		1010/06	150	650-670	100% (ISRT+UT) 100% MPI/LPI			NDT after SR	01	
							4	578	132	215	1709		190						
54	1-12-852-02196 0-00-027-35547	LINK TO PLATEN SH+ SH PLATEN FRONT I/L HDR (S-25B + S-26 TEE)	SA335P12 + SA234WP12CL1	457	75	GTAW + SMAW	65.62 ∩∩	ER80S-B2	E8018-B2		1010/06	150	650-670	100% (ISRT+UT) 100% MPI/LPI			NDT after SR	01	
							2	289	66	108	855		190						
55	0-12-187-03715 0-00-027-35547	BP BYPASS PIPE+ LINK TO SH PLATEN (S-24 + S-25B)	SA335P12 + SA182F12CL2	273	45	GTAW + SMAW	39.38 ∩∩	ER80S-B2	E8018-B2		1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01	
							2	174	40	65	206		115						
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-12-SH-EWS		1		11/20		
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 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 12							
		CUST No : 1834,1835										PG NAME : Superheater System							
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Superheater System							
		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185			CUST DOC REV : 01				
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW						ACC	NORM			
									Qty in gms	Qty in Nos.									
										Ø2.5									Ø3.15
56	0-12-187-03715 0-00-027-35547	BP BYPASS PIPE + LINK FROM SH CONNECTING PIPE (S-24 + S-01 TEE)	SA335P12 + SA234WP12CL1	273	45	GTAW + SMAW	39.38 ∇∇	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							8	696	157	257	821			115					
57	0-12-187-03715 0-00-027-35547	BP BYPASS PIPE+ BP BYPASS PIPE (S-24 + S-24)	SA335P12 + SA335P12	273	45	GTAW + SMAW	39.38 ∇∇	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							20	1740	392	642	2051			115					
58	0-00-027-35561 0-00-027-35562	SH PLATEN FRONT I/L HDR+SH PLATEN FRONT I/L TERM TUBE (S-26 NIPPLE + S-27TI(1))	SA213T22 + SA213T22	50.8	8.64	GTAW + SMAW	8.64 ∇	ER90S-B3	E9018-B3			1014/03	150	680-720	20%RT + 80% PAUT				
							34	349	286	62	-			30					
59	0-00-027-35561 0-00-027-35562	SH PLATEN FRONT I/L HDR+SH PLATEN FRONT I/L TERM TUBE (S-26 NIPPLE + S-27TI (2-3))	SA213T22 + SA213T22	44.5	7.1	GTAW + SMAW	7.1 ∇	ER90S-B3	E9018-B3			1013/02	150	Nil	20%RT + 80% PAUT				
							68	630	685	-	-								
60	0-00-027-35561 0-00-027-35562	SH PLATEN FRONT I/L HDR+SH PLATEN FRONT I/L TERM TUBE (S-26 NIPPLE + S-27TI (4-18))	SA213T22 + SA213T22	33.4	6.6	GTAW + SMAW	6.6 ∇	ER90S-B3	E9018-B3			1013/02	150	Nil	20%RT + 80% PAUT				
							510	3122	3375	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S				06-05-2026		1834-12-SH-EWS		1		12/20	
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 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 12						
CUST No : 1834,1835										PG NAME : Superheater System									
PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Superheater System									
WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185			CUST DOC REV : 01						
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
									Ø2.5	Ø3.15					Ø4.0				
76	0-00-027-35563 0-00-027-35564	SH PLATEN REAR I/L TERM TUBE+ SH PLATEN REAR ASSY (S-33TI (1) + S-33 (1))	SA213 UNS S30432 + SA213 UNS S30432	50.8	8.64	GTAW	8.64 ∇ Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT					
						34	4683	-	-	-									
77	0-00-027-35563 0-00-027-35564	SH PLATEN REAR I/L TERM TUBE+ SH PLATEN REAR ASSY (S-33TI (2-18) + S-33 (2-18))	SA213 UNS S30432 + SA213 UNS S30432	44.45	7.11	GTAW	7.11 ∇ Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT					
						578	48606	-	-	-									
78	0-00-027-35563 0-00-027-35564	SH PLATEN REAR ASSY+ SH PLATEN REAR O/L TERM TUBE (S-33(1)+S-33TO (1))	SA213 UNS S30432 + SA213 UNS S30432	50.8	8.64	GTAW	8.64 ∇ Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT					
						34	4683	-	-	-									
79	0-00-027-35563 0-00-027-35564	SH PLATEN REAR ASSY+ SH PLATEN REAR O/L TERM TUBE (S-33 (2-18) + S-33TO (2-18))	SA213 UNS S30432 + SA213 UNS S30432	44.45	7.11	GTAW	7.11 ∇ Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT					
						578	48606	-	-	-									
80	0-00-027-35563 0-00-027-35564	SH PLATEN REAR O/L TERM TUBE+ SH PLATEN REAR O/L HDR (S-33TO (1) + S-34 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	50.8	8.64	GTAW	8.64 ∇ Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT					
						34	4683	-	-	-									
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-12-SH-EWS		1		16/20		
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 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 12							
		CUST No : 1834,1835										PG NAME : Superheater System							
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Superheater System							
		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01							
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW						SPEC. NO	ACC NORM			
									Qty in Nos.										
									Ø2.5	Ø3.15									Ø4.0
81	0-00-027-35563 0-00-027-35564	SH PLATEN REAR O/L TERM TUBE+ SH PLATEN REAR O/L HDR (S-33TO(2-3) + S-34 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	44.45	7.6	GTAW	7.6 ∇ Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT					
							68	6461	-	-	-								
82	0-00-027-35563 0-00-027-35564	SH PLATEN REAR O/L TERM TUBE+ SH PLATEN REAR O/L HDR (S-33TO (4-18) + S-34 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	44.45	8.1	GTAW	8.1 ∇ Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT					
							510	54502	-	-	-								
83	0-12-179-03684	SH PLATEN REAR O/L HDR+ LINK FROM SH DESUPERHEATER-2 (S-34 TEE + S-35)	SA234WP92 + SA335P92	559	85	GTAW + SMAW	74.38 ∇∇ ER90S-B92	E9015-B92		1056/04	220	755 ± 15	100% UT 100% MPI			NDT after SR; 100% HC, 186 HB TO 300HB			
						2	363	134	179			1822	215						
84	0-12-179-03684	LINK FROM SH DESH-2 +LINK FROM SH DESH-2 (S-35 + S-35)	SA234WP92 + SA335P92	559	85	GTAW + SMAW	74.38 ∇∇ ER90S-B92	E9015-B92		1056/04	220	755 ± 15	100% UT 100% MPI			NDT after SR; 100% HC, 186 HB TO 300HB			
						4	726	268	357			3644	215						
85	0-12-179-03684	LINK FROM SH DESH-2+ SH DESUPERHEATER-2 (S-35 + S-36)	SA335P92 + SA335P92	559	85	GTAW + SMAW	74.38 ∇∇ ER90S-B92	E9015-B92		1056/04	220	755 ± 15	100% UT 100% MPI			NDT after SR; 100% HC, 186 HB TO 300HB			
						2	363	134	179			1822	215						
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S				06-05-2026		1834-12-SH-EWS		1		17/20	
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 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 12						
CUST No : 1834,1835										PG NAME : Superheater System									
PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Superheater System									
WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185			CUST DOC REV : 01						
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
									Ø2.5	Ø3.15					Ø4.0				
91	0-00-027-35565 0-00-027-35566	FINISH SH FRONT ASSY+ FINISH SH REAR ASSY (S-39 (1) + S-40 (1))	SA213 UNS S30432 + SA213 UNS S30432	44.45	8.1	GTAW	8.1 ∇ Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT					
						104	11115	-	-	-									
92	0-00-027-35565 0-00-027-35566	FINISH SH FRONT ASSY+ FINISH SH REAR ASSY (S-39 (2-11) + S-40 (2-11))	SA213 UNS S30432 + SA213 UNS S30432	44.45	7.6	GTAW	7.6 ∇ Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT					
						1040	98807	-	-	-									
93	0-00-027-35565 0-00-027-35566	FINISH SH REAR ASSY+ FINISH SH O/L TERM TUBE (S-40 (1-11) + S-40TI (1-11))	SA213 UNS S30432 + SA213 UNS S30432	38.1	9.14	GTAW	9.14 ∇ Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT					
						1144	131277	-	-	-									
94	0-00-027-35565 0-00-027-35566	FINISH SH REAR ASSY+ FINISH SH O/L HDR (S-40 (1-11) + S-41 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	38.1	9.14	GTAW	9.14 ∇ Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	20%RT + 80% PAUT					
						1144	131277	-	-	-									
95	0-00-027-35552 0-00-027-35553 0-00-027-35554	SC FURN ARCH SUPPT I/L HDR+ STEAM COOLED SPACER TUBE (S-09A + S-44), (S-44+S-44)	SA213T12 + SA213T12	50.8	9.14	GTAW + SMAW	9.14 ∇ ER80S-B2	E8018-B2			1009/03	150	Nil	20%RT + 80% PAUT					
						6	60	50	14	-									
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S				06-05-2026		1834-12-SH-EWS		1		19/20	
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 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 17						
CUST No : 1834,1835										PG NAME : Reheater System									
PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Reheater System									
WELDING CODE : IBR / ASME						PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01								
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
									Ø2.5	Ø3.15					Ø4.0				
6	0-00-027-35557 0-00-027-35544	LTRH INTER ASSY +LTRH UPR INTER ASSY (R-04I + R-04UI)	SA213T22 + SA213T22	69.85	5.08	GTAW + SMAW	5.08 ▽	ER90S-B3	E9018-B3			1013/02	150	Nil	100% RT				
							952	17510	8317	-	-								
7	0-00-027-35557 0-00-027-35544	LTRH UPR INTER ASSY+LTRH UPR ASSY (R-04UI + R-04U)	SA213T22 + SA213T22	69.85	5.08	GTAW + SMAW	5.08 ▽	ER90S-B3	E9018-B3			1013/02	150	Nil	100% RT				
							952	17510	8317	-	-								
8	0-00-027-35573 0-00-027-35544	LTRH UPR ASSY + LTRH PENDANT LOOSE TUBE (R-04U + R-07B-LT)	SA213 UNS S30432 + SA213 UNS S30432	63.5	4	GTAW	4 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							952	71350	-	-	-								
9	0-00-027-35573 0-00-027-35544	LTRH PENDANT LOOSE TUBE+ LTRH PENDANT ASSY (R-07B-LT + R-07)	SA213 UNS S30432 + SA213 UNS S30432	63.5	4	GTAW	4 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							952	71350	-	-	-								
10	0-00-027-35573 0-00-027-35544	LTRH PENDANT ASSY +LTRH O/L TERM TUBE (R-07 + R-07TO)	SA213 UNS S30432 + SA213 UNS S30432	63.5	4	GTAW	4 ▽	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							952	71350	-	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-17-RH-EWS		1		2/6		
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 355-005/A (09-09-2016)		<u>ERECTION WELDING SCHEDULE</u>										PG NO : 17							
		CUST No : 1834,1835										PG NAME : Reheater System							
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Reheater System							
		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON -PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01							
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW						ACC	NORM			
									Qty in Nos.										
									Ø2.5	Ø3.15									Ø4.0
11	0-00-027-35573 0-00-027-35544	LTRH O/L TERM TUBE +LTRH O/L HDR NIPPLE (R-07TO (1, 8) + R-08 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	50.8	4	GTAW	4 ∇	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							238	14270	-	-	-								
12	0-00-027-35573 0-00-027-35544	LTRH O/L TERM TUBE +LTRH O/L HDR NIPPLE (R-07TO (2-7) + R-08 NIPPLE)	SA213 UNS S30432 + SA213 UNS S30432	44.45	4.2	GTAW	4.2 ∇	Nittetsu YT304H / Super TIG 304H	-			1054/03	10	Nil	100% RT				
							714	40491	-	-	-								
13	0-00-027-35548 1-17-174-00671	LTRH O/L HDR+ LINK TO RH DESH (R-08 + R-09)	SA335P91 + SA234WP91	813	40	GTAW + SMAW	35.00 ∇∇	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	654	195	260	791			100					
14	0-00-027-35548 1-17-174-00671	LINK TO RH DESH+ LINK TO RH DESH (R-09 + R-09)	SA335P91 + SA234WP91	813	40	GTAW + SMAW	35.00 ∇∇	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	654	195	260	791			100					
15	0-00-027-35548 0-17-900-00729	LINK TO RH DESH+ RH DESH (R-09 + R-10)	SA335P91 + SA335P91	813	40	GTAW + SMAW	35.00 ∇∇	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	654	195	260	791			100					
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S				06-05-2026		1834-17-RH-EWS		1		3/6	
CAUTION :		THE INFMM ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.										* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.							

 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 17						
			CUST No : 1834,1835										PG NAME : Reheater System						
			PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Reheater System						
			WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01						
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV	
				SIZE	THICK			GTAW Qty in gms	SMAW Qty in Nos.										
									Ø2.5	Ø3.15					Ø4.0				
16	0-00-027-35548 0-17-900-00729 0-17-174-00801	RH DESH+ LINK TO FINISH RH (R-10 + R-11)	SA335P91 + SA335P91	813	40	GTAW + SMAW	35.00 ∇∇	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	654	195	260	791		100						
17	0-00-027-35548 0-17-174-00801	LINK TO FINISH RH+ LINK TO FINISH RH (R-11 + R-11)	SA335P91 + SA234WP91	813	40	GTAW + SMAW	35.00 ∇∇	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							7	2286	680	908	2767		100						
18	0-00-027-35547 0-17-174-00801	LINK TO FINISH RH+ FINISH RH I/L HDR (R-11 + R-12)	SA234WP91 + SA335P91	609.6	40	GTAW + SMAW	35.00 ∇∇	ER90S-B9	E9015-B91			1050/06	220	740-770	100% UT 100% MPI			NDT after SR; 100% HC, 180 HB TO 300HB	
							2	476	146	195	583		100						
19	0-00-027-35559 0-00-027-35560	FINISH RH I/L HDR NIPP+ FINISH RH I/L TERM TUBES (R-12 NIPPLE + R-13TI (1))	SA213T22 + SA213T22	76.2	6.6	GTAW + SMAW	6.6 ∇	ER90S-B3	E9018-B3			1013/02	150	Nil	20%RT + 80% PAUT				
							51	991	770	-	-								
20	0-00-027-35559 0-00-027-35560	FINISH RH I/L HDR NIPP+ FINISH RH I/L TERM TUBES (R-12 NIPPLE + R-13TI (2-3))	SA213T22 + SA213T22	63.5	5.59	GTAW + SMAW	5.59 ∇	ER90S-B3	E9018-B3			1013/02	150	Nil	100% RT				
							102	1643	956	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
RUDRABHATLA SAIKUMAR				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-17-RH-EWS		1		4/6		
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.										* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.							

 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE CUST No : 1834,1835 PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW) WELDING CODE : IBR / ASME										PG NO : 07 PG NAME : Circulation System SYSTEM DESCRIPTION : Circulation System CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01									
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV				
				SIZE	THICK			GTAW Qty in gms	SMAW Qty in Nos.													
									Ø2.5	Ø3.15					Ø4.0							
6	0-00-027-35556 0-00-027-35591	F-08TI (FURN REAR SPIRAL INLET TERM TUBES) + F-08L (FURN LOWER REAR SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT							
							258	2021	2863	-	-											
7	0-00-027-35556 0-00-027-35591	F-02TI (FURN LOWER FRONT SPIRAL INLET TERM TUBES) + F-08L (FURN LOWER REAR SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT							
							3	24	34	-	-											
8	0-00-027-35556 0-00-027-35591	F-08TI (FURN REAR SPIRAL INLET TERM TUBES) + F-02L (FURN LOWER FRONT SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT							
							3	24	34	-	-											
9	0-00-027-35556 0-00-027-35599 0-00-027-35600	F-02TI (FURN LOWER FRONT SPIRAL INLET TERM TUBES) + F-17L (L&R) (FURN LOWER SIDE SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT							
							10	79	111	-	-											
10	0-00-027-35556 0-00-027-35599 0-00-027-35600	F-08TI (FURN LOWER REAR SPIRAL INLET TERM TUBES) + F-17L (L&R) (FURN LOWER SIDE SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT							
							10	79	111	-	-											
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.					
SAJI P J				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-07-CIR-EWS		1		2/18					
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.										* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.										



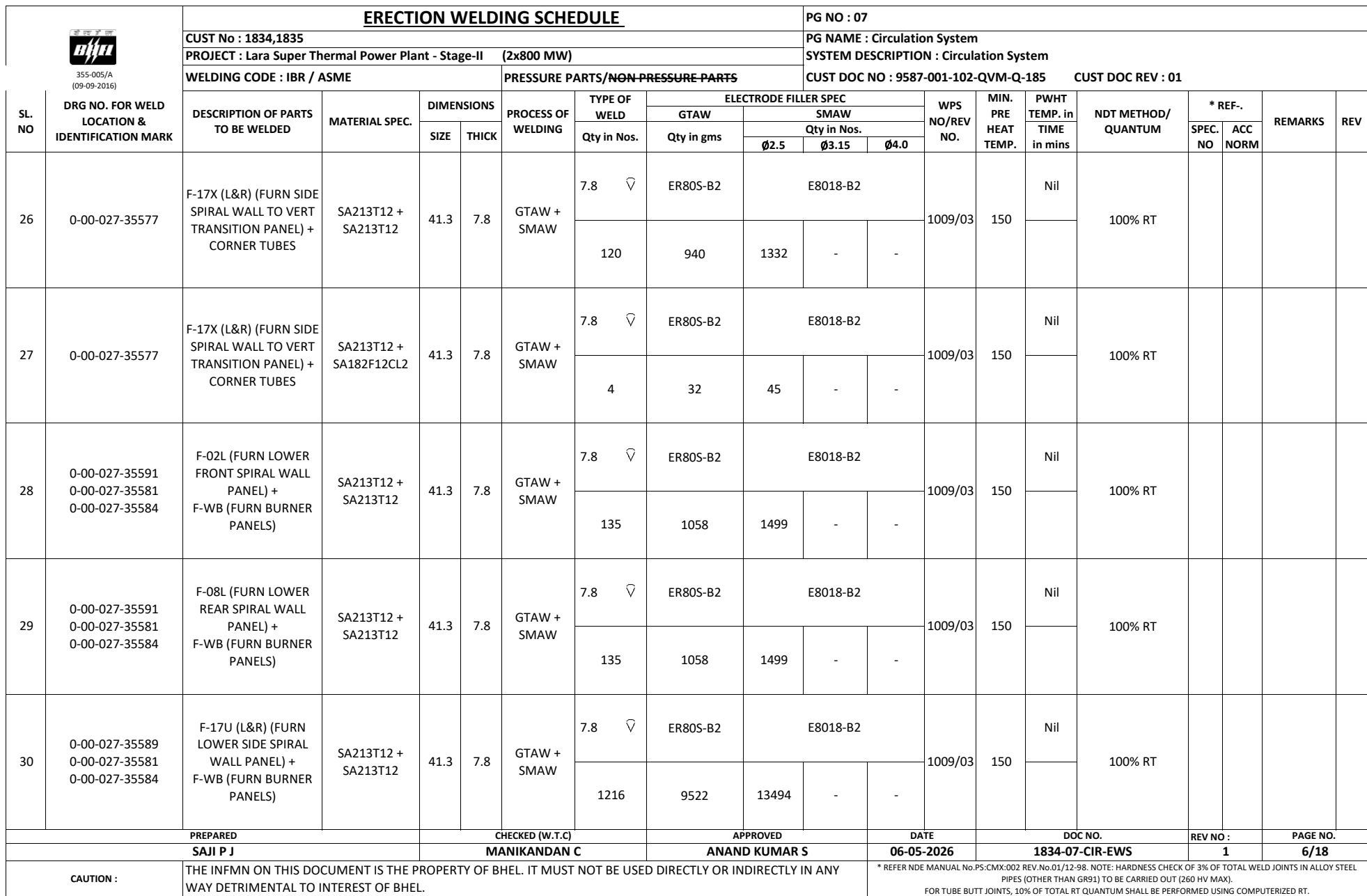
 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 07							
		CUST No : 1834,1835										PG NAME : Circulation System							
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Circulation System							
		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01							
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
									Ø2.5	Ø3.15					Ø4.0				
11	0-00-027-35591	F-02L (FURN LOWER FRONT SPIRAL WALL PANEL) + F-02L (FURN LOWER FRONT SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							319	2498	3540	-	-								
12	0-00-027-35591	F-08L (FURN LOWER REAR SPIRAL WALL PANEL) + F-08L (FURN LOWER REAR SPIRAL WALL PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							319	2498	3540	-	-								
13	0-00-027-35591	F-02L (FURN LOWER FRONT SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	38.1	8	GTAW + SMAW	8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							128	860	1374	-	-								
14	0-00-027-35591	F-02L (FURN LOWER FRONT SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							258	2021	2863	-	-								
15	0-00-027-35591	F-08L (FURN LOWER REAR SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	38.1	8	GTAW + SMAW	8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							128	860	1374	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
SAJI P J				MANIKANDAN C				ANAND KUMAR S				06-05-2026		1834-07-CIR-EWS		1		3/18	
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.										* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.							



 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 07						
CUST No : 1834,1835										PG NAME : Circulation System									
PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Circulation System									
WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01									
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
									Ø2.5	Ø3.15					Ø4.0				
16	0-00-027-35591	F-08L (FURN LOWER REAR SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							258	2021	2863	-	-								
17	0-00-027-35587	F-02U (FURN UPPER FRONT SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							133	1042	1476	-	-								
18	0-00-027-35588	F-08U (FURN UPPER REAR SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							133	1042	1476	-	-								
19	0-00-027-35599 0-00-027-35600	F-17L (L&R) (FURN LOWER SIDE SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	38.1	8	GTAW + SMAW	8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							516	3464	5536	-	-								
20	0-00-027-35599 0-00-027-35600	F-17L (L&R) (FURN LOWER SIDE SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							256	2005	2841	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
SAJI P J				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-07-CIR-EWS		1		4/18		
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.										* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.							



 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 07							
		CUST No : 1834,1835										PG NAME : Circulation System							
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Circulation System							
		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185			CUST DOC REV : 01				
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in gms	Qty in Nos.									
								Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM			
21	0-00-027-35589 0-00-027-35590	F-17U (L&R) (FURN UPPER SIDE SPIRAL WALL PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							286	2240	3174	-	-								
22	0-00-027-35578	F-02X (FURN FRONT SPIRAL WALL TO VERT TRANSITION PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							68	533	755	-	-								
23	0-00-027-35578	F-02X (FURN FRONT SPIRAL WALL TO VERT TRANSITION PANEL) + CORNER TUBES	SA213T12 + SA182F12CL2	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							2	16	23	-	-								
24	0-00-027-35578	F-08X (FURN REAR SPIRAL WALL TO VERT TRANSITION PANEL) + CORNER TUBES	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							68	533	755	-	-								
25	0-00-027-35578	F-08X (FURN REAR SPIRAL WALL TO VERT TRANSITION PANEL) + CORNER TUBES	SA213T12 + SA182F12CL2	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							2	16	23	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
SAJI P J				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-07-CIR-EWS		1		5/18		
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.										* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.							





 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 07						
CUST No : 1834,1835										PG NAME : Circulation System									
PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Circulation System									
WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01									
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW Qty in gms	SMAW Qty in Nos.										
									Ø2.5	Ø3.15					Ø4.0				
31	0-00-027-35587 0-00-027-35581 0-00-027-35584	F-02U (FURN UPPER FRONT SPIRAL WALL PANEL) + F-WB (FURN BURNER PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							598	4683	6636	-	-								
32	0-00-027-35588 0-00-027-35581 0-00-027-35584	F-08U (FURN UPPER REAR SPIRAL WALL PANEL) + F-WB (FURN BURNER PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							598	4683	6636	-	-								
33	0-00-027-35599 0-00-027-35581 0-00-027-35584	F-17L (L&R) (FURN LOWER SIDE SPIRAL WALL PANEL) + F-WB (FURN BURNER PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							250	1958	2775	-	-								
34	0-00-027-35578	F-02U (FURN UPPER FRONT SPIRAL WALL PANEL) + F-02X (FURN FRONT SPIRAL WALL TO VERT TRANSITION PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							124	971	1376	-	-								
35	0-00-027-35578	F-08U (FURN UPPER REAR SPIRAL WALL PANEL) + F-08X (FURN REAR SPIRAL TO VERT TRANSITION PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							124	971	1376	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
SAJI P J				MANIKANDAN C				ANAND KUMAR S				06-05-2026		1834-07-CIR-EWS		1		7/18	
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.										* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.							



 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 07						
CUST No : 1834,1835													PG NAME : Circulation System						
PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)													SYSTEM DESCRIPTION : Circulation System						
WELDING CODE : IBR / ASME						PRESSURE PARTS/ NON-PRESSURE PARTS						CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01							
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
							Qty in Nos.		Qty in gms	Qty in Nos.									
										Ø2.5					Ø3.15	Ø4.0			
36	0-00-027-35577	F-17U (L&R) (FURN UPPER SIDE SPIRAL WALL PANEL) + F-17X (L&R) (FURN SIDE SPIRAL TO VERT TRANSITION PANEL)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							218	1708	2420	-	-								
37	0-00-027-35587	F-02U (FURN UPPER FRONT SPIRAL WALL PANEL) + F-OFA (FURN SOFA PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							485	3798	5382	-	-								
38	0-00-027-35588	F-08U (FURN UPPER REAR SPIRAL WALL PANEL) + F-OFA (FURN SOFA PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							485	3798	5382	-	-								
39	0-00-027-35577	F-17U (L&R) (FURN UPPER SIDE SPIRAL WALL PANEL) + F-OFA (FURN SOFA PANELS)	SA213T12 + SA213T12	41.3	7.8	GTAW + SMAW	7.8 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							932	7299	10343	-	-								
40	0-00-027-35577	F-17X (L&R) (FURN SIDE SPIRAL TO VERT TRANSITION PANEL) + F-17TO (L&R) (FURN SIDE SPIRAL OUTLET TERM TUBES)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							262	1904	2264	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
SAJI P J				MANIKANDAN C				ANAND KUMAR S				06-05-2026		1834-07-CIR-EWS		1		8/18	
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.										* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.							



 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 07						
			CUST No : 1834,1835										PG NAME : Circulation System						
			PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Circulation System						
			WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01						
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
								Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM			
41	0-00-027-35578	F-02X (FURN FRONT SPIRAL TO VERT TRANSITION PANEL) + F-02TO (FURN FRONT SPIRAL OUTLET TERM TUBES)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							140	1018	1210	-	-								
42	0-00-027-35578	F-08X (FURN REAR SPIRAL TO VERT TRANSITION PANEL) + F-08TO (FURN REAR SPIRAL OUTLET TERM TUBES)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							140	1018	1210	-	-								
43	0-00-027-35577	F-17TO (L&R) (FURN SIDE SPIRAL OUTLET TERM TUBES) + F-18 (L&R) (FURN INTERM SIDE HDRS)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							262	1904	2264	-	-								
44	0-00-027-35578	F-02TO (FURN FRONT SPIRAL OUTLET TERM TUBES) + F-03 (FURN INTERM FRONT HDR)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							140	1018	1210	-	-								
45	0-00-027-35578	F-08TO (FURN REAR SPIRAL OUTLET TERM TUBES) + F-09 (FURN INTERM REAR HDR)	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							140	1018	1210	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
SAJI P J				MANIKANDAN C				ANAND KUMAR S				06-05-2026		1834-07-CIR-EWS		1		9/18	
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 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 07						
			CUST No : 1834,1835										PG NAME : Circulation System						
			PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Circulation System						
			WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01						
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
								Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM			
46	0-00-027-35577	F-18 (L&R) (FURN INTERM SIDE HDRS) + F-19TI (L&R) (FURN SIDE VERT INLET TERM TUBES)	SA213T12 + SA213T12	33.4	5.59	GTAW + SMAW	5.59 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							786	5305	3873	-	-								
47	0-00-027-35578	F-03 (FURN INTERM FRONT HDR) + F-04TI (FURN FRONT VERTICAL INLET TERM TUBES)	SA213T12 + SA213T12	33.4	5.59	GTAW + SMAW	5.59 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							420	2835	2070	-	-								
48	0-00-027-35578	F-09 (FURN INTERM REAR HDR) + F-10TI (FURN REAR VERT INET TERM TUBES)	SA213T12 + SA213T12	33.4	5.59	GTAW + SMAW	5.59 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							420	2835	2070	-	-								
49	0-00-027-35578	F-03 (FURN FRONT INTERM HDR INSPECTION NOZZLE) + FLAT END COVER	SA182F12CL2 + SA182F12CL2	168.3	39.7	GTAW + SMAW	34.74 ∇∇	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							2	91	25	40	92			100					
50	0-00-027-35578	F-09 (FURN REAR INTERM HDR INSPECTION NOZZLE) + FLAT END COVER	SA182F12CL2 + SA182F12CL2	168.3	39.7	GTAW + SMAW	34.74 ∇∇	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							2	91	25	40	92			100					
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
SAJI P J				MANIKANDAN C				ANAND KUMAR S				06-05-2026		1834-07-CIR-EWS		1		10/18	
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 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 07							
		CUST No : 1834,1835										PG NAME : Circulation System							
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Circulation System							
		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01							
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
								Ø2.5	Ø3.15	Ø4.0									
51	0-00-027-35577	F-18 (FURN INTERM HDR INSPECTION NOZZLE) + FLAT END COVER	SA182F12CL2 + SA182F12CL2	168.3	39.7	GTAW + SMAW	34.74 ∇∇	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							4	182	49	80	184		100						
52	0-00-027-35577	F-19TI (L&R) (FURN SIDE VERT INLET TERM TUBES) + F-17X (L&R) (FURN SIDE SPIRAL TO VERT TRANSITION PANEL)	SA213T12 + SA213T12	33.4	5.59	GTAW + SMAW	5.59 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							786	5305	3873	-	-								
53	0-00-027-35578	F-04TI (FURN FRONT VERTICAL INLET TERM TUBES) + F-02X (FURN FRONT SPIRAL TO VERT TRANSITION PANEL)	SA213T12 + SA213T12	33.4	5.59	GTAW + SMAW	5.59 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							420	2835	2070	-	-								
54	0-00-027-35578	F-10TI (FURN REAR VERT INET TERM TUBES) + F-08X (FURN REAR SPIRAL TO VERT TRANSITION PANEL)	SA213T12 + SA213T12	33.4	5.59	GTAW + SMAW	5.59 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							420	2835	2070	-	-								
55	0-00-027-35586	F-02X (FURN FRONT SPIRAL TO VERT TRANSITION PANEL) + F-04L (FURN LOWER FRONT VERT WALL PANEL)	SA213T12 + SA213T12	38.1	8.13	GTAW + SMAW	8.13 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							420	2786	4642	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
SAJI P J				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-07-CIR-EWS		1		11/18		
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.										* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.							



 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 07							
		CUST No : 1834,1835										PG NAME : Circulation System							
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Circulation System							
		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185			CUST DOC REV : 01				
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in gms	Qty in Nos.									
								Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM			
61	0-00-027-35586 0-00-027-35551	F-12 (FURN SCREEN TUBES) + F-14 (FURN UPPER REAR OUTLET HDR)	SA213T12 + SA213T12	38.1	8.13	GTAW + SMAW	8.13 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							280	1857	3095	-	-								
62	0-00-027-35586 0-00-027-35551	F-13 (FURN HANGER TUBES) + F-14 (FURN UPPER REAR OUTLET HDR)	SA213T22 + SA213T22	63.5	12.7	GTAW + SMAW	12.7 ▽	ER90S-B3	E9018-B3			1084/01	200	740 ± 10	20% RT + 80% PAUT			100% HC, 260HV (MAX)	
							140	1636	1308	1152	-			60					
63	0-00-027-35586	F-17X (L&R) (FURN SIDE SPIRAL TO VERT TRANSITION PANEL) + F-19L (L&R) (FURN LOWER SIDE VERT WALL PANEL)	SA213T12 + SA213T12	38.1	9.1	GTAW + SMAW	9.1 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							786	4739	10720	-	-								
64	0-00-027-35586	F-19L (L&R) (FURN LOWER SIDE VERT WALL PANEL) + F-19U (L&R) (FURN UPPER SIDE VERT WALL PANEL)	SA213T12 + SA213T12	38.1	9.1	GTAW + SMAW	9.1 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	100% RT				
							786	4739	10720	-	-								
65	0-00-027-35586	F-19U (L&R) (FURN UPPER SIDE VERT WALL PANEL) + F-19U LT (LOOSE TUBES)	SA213T12 + SA213T12	38.1	9.1	GTAW + SMAW	9.1 ▽	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							10	61	137	-	-								
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.		
SAJI P J				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-07-CIR-EWS		1		13/18		
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 355-005/A (09-09-2016)			ERECTION WELDING SCHEDULE										PG NO : 07						
			CUST No : 1834,1835										PG NAME : Circulation System						
			PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Circulation System						
			WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01						
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in Nos.										
								Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM			
66	0-00-027-35586	F-19U (L&R) (FURN UPPER SIDE VERT WALL PANEL) + F-20 (L&R) (FURN UPPER SIDE OUTLET HDRS)	SA213T12 + SA213T12	38.1	9.1	GTAW + SMAW	9.1 ∇	ER80S-B2	E8018-B2			1009/03	150	Nil	20% RT + 80% PAUT				
							786	4739	10720	-	-								
67	1-07-318-01322 1-07-318-01323 0-00-027-35570	F-05 (FURN UPPER FRONT OUTLET HDR) + F-06 (FRONT RISER PIPES)	SA182F12CL2 + SA335P12	219.1	40	GTAW + SMAW	35.00 ∇∇	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							4	270	63	103	261			100					
68	1-07-318-01322 1-07-318-01323 0-00-027-35568	F-06 (FRONT RISER PIPES) + F-06 (FRONT RISER PIPES)	SA335P12 + SA335P12	219.1	40	GTAW + SMAW	35.00 ∇∇	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							16	1077	252	412	1042			100					
69	1-07-318-01322 1-07-318-01323 0-00-027-35568	F-06 (FRONT RISER PIPES) + F-31 (SEPARATOR)	SA335P12 + SA182F22CL3	219.1	40	GTAW + SMAW	35.00 ∇∇	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI			NDT after SR	01
							4	270	63	103	261			100					
70	0-07-316-02253 0-07-316-02254 0-00-027-35568	F-14 (FURN UPPER REAR OUTLET HDR) + F-15 (REAR RISER PIPES)	SA182F12CL2 + SA335P12	219.1	40	GTAW + SMAW	35.00 ∇∇	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							4	270	63	103	261			100					
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
SAJI P J				MANIKANDAN C				ANAND KUMAR S				06-05-2026		1834-07-CIR-EWS		1		14/18	
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 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 07							
		CUST No : 1834,1835										PG NAME : Circulation System							
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Circulation System							
		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON-PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01							
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF-.		REMARKS	REV	
				SIZE	THICK		Qty in Nos.	GTAW	SMAW										
								Qty in Nos.											
								Ø2.5	Ø3.15	Ø4.0									
71	0-07-316-02253 0-07-316-02254 0-00-027-35568	F-15 (REAR RISER PIPES) + F-15 (REAR RISER PIPES)	SA335P12 + SA335P12	219.1	40	GTAW + SMAW	35.00 ☑☑	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							20	1346	315	515	1302		100						
72	0-07-316-02253 0-07-316-02254 0-00-027-35568	F-15 (REAR RISER PIPES) + F-31 (SEPARATOR)	SA335P12 + SA182F22CL3	219.1	40	GTAW + SMAW	35.00 ☑☑	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI			NDT after SR	01
							4	270	63	103	261		100						
73	1-07-315-01314 TO 1-07-315-01321 0-00-027-35568	F-20 (FURN UPPER SIDE OUTLET HDRS) + F-21 (SIDE RISER PIPES)	SA182F12CL2 + SA335P12	219.1	40	GTAW + SMAW	35.00 ☑☑	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							8	539	126	206	521		100						
74	1-07-315-01314 TO 1-07-315-01321 0-00-027-35568	F-21 (SIDE RISER PIPES) + F-21 (SIDE RISER PIPES)	SA335P12 + SA335P12	219.1	40	GTAW + SMAW	35.00 ☑☑	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							36	2422	566	927	2343		100						
75	1-07-315-01314 TO 1-07-315-01321 0-00-027-35568	F-21 (SIDE RISER PIPES) + F-31 (SEPARATOR)	SA335P12 + SA182F22CL3	219.1	40	GTAW + SMAW	35.00 ☑☑	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI			NDT after SR	01
							8	539	126	206	521		100						
PREPARED				CHECKED (W.T.C)		APPROVED			DATE		DOC NO.		REV NO :		PAGE NO.				
SAJI P J				MANIKANDAN C		ANAND KUMAR S			06-05-2026		1834-07-CIR-EWS		1		15/18				
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.							* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98. NOTE: HARDNESS CHECK OF 3% OF TOTAL WELD JOINTS IN ALLOY STEEL PIPES (OTHER THAN GR91) TO BE CARRIED OUT (260 HV MAX). FOR TUBE BUTT JOINTS, 10% OF TOTAL RT QUANTUM SHALL BE PERFORMED USING COMPUTERIZED RT.										

 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 07							
		CUST No : 1834,1835										PG NAME : Circulation System							
		PROJECT : Lara Super Thermal Power Plant - Stage-II (2x800 MW)										SYSTEM DESCRIPTION : Circulation System							
		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01							
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD Qty in Nos.	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW										
									Qty in gms	Qty in Nos.									
								Ø2.5	Ø3.15	Ø4.0					SPEC. NO	ACC NORM			
76	0-07-102-02217 0-00-027-35568	F-31 (SEPARATOR) + F-32 (LINK TO SEPARATOR STORAGE TANK)	SA182F22CL3 + SA335P12	355.6	65	GTAW + SMAW	56.88 ∇∇	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI			NDT after SR	01
							4	432	102	168	1030			165					
77	0-07-102-02217 0-00-027-35568	F-32 (LINK TO SEPARATOR STORAGE TANK) + F-32 (LINK TO SEPARATOR STORAGE TANK)	SA335P12 + SA335P12	355.6	65	GTAW + SMAW	56.88 ∇∇	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							8	863	204	335	2059			165					
78	0-07-102-02217 0-00-027-35568	F-32 (LINK TO SEPARATOR STORAGE TANK) + F-33 (STORAGE TANK)	SA335P12 + SA182F22CL3	355.6	65	GTAW + SMAW	56.88 ∇∇	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI			NDT after SR	01
							4	432	102	168	1030			165					
79	0-07-110-02218 0-00-027-35568	F-33 (STORAGE TANK) + F-49 (FURN DOWNCOMER TO CONNECTING SPHERE)	SA182F22CL3 + SA335P12	406.4	65	GTAW + SMAW	56.88 ∇∇	ER80S-B2	E8018-B2			1012/04	150	680-720	100% RT 100% MPI/LPI			NDT after SR	01
							2	260	59	96	603			165					
80	0-07-110-02218 0-00-027-35568	F-49 (FURN DOWNCOMER TO CONNECTING SPHERE) + F-50 (FURN CONNECTING SPHERE)	SA335P12 + SA182F12CL2	406.4	65	GTAW + SMAW	56.88 ∇∇	ER80S-B2	E8018-B2			1010/06	150	650-670	100% RT 100% MPI/LPI			NDT after SR	01
							2	260	59	96	603			165					
PREPARED				CHECKED (W.T.C)				APPROVED			DATE		DOC NO.			REV NO :		PAGE NO.	
SAJI P J				MANIKANDAN C				ANAND KUMAR S			06-05-2026		1834-07-CIR-EWS			1		16/18	
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 355-005/A (09-09-2016)		ERECTION WELDING SCHEDULE										PG NO : 07							
		CUST No : 1834,1835										PG NAME : Circulation System							
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		WELDING CODE : IBR / ASME					PRESSURE PARTS/ NON PRESSURE PARTS					CUST DOC NO : 9587-001-102-QVM-Q-185 CUST DOC REV : 01							
		SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP.	PWHT TEMP. in TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS
SIZE	THICK					GTAW	SMAW			SPEC. NO	ACC NORM								
							Qty in Nos.					Qty in gms					Qty in Nos.		
								Ø2.5	Ø3.15	Ø4.0									
86		GAMMA PLUG IN F-49 LINKS	SA335P12 + SA182F22CL3			SMAW	7 	-	E8018-B2			1102/01	200	Nil	100% LPI or MPI				
							16	-	5	-	-								
PREPARED		CHECKED (W.T.C)		APPROVED		DATE		DOC NO.		REV NO :		PAGE NO.							
SAJI P J		MANIKANDAN C		ANAND KUMAR S		06-05-2026		1834-07-CIR-EWS		1		18/18							
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