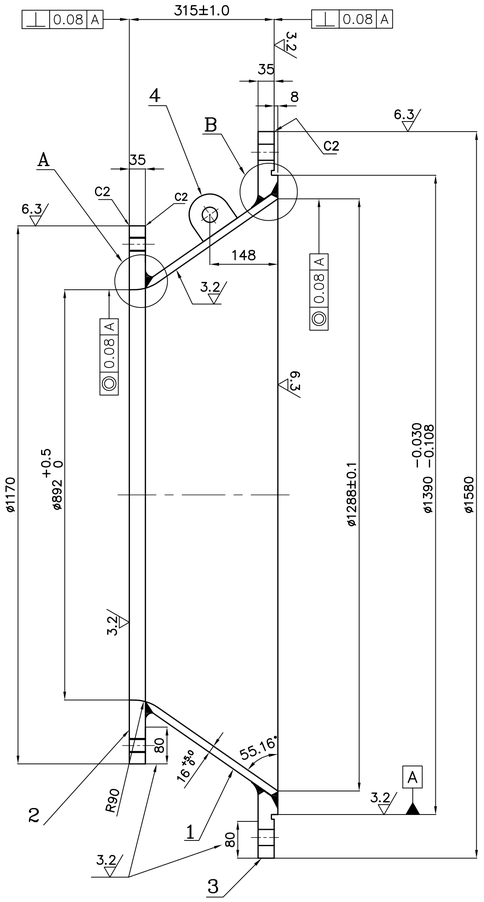
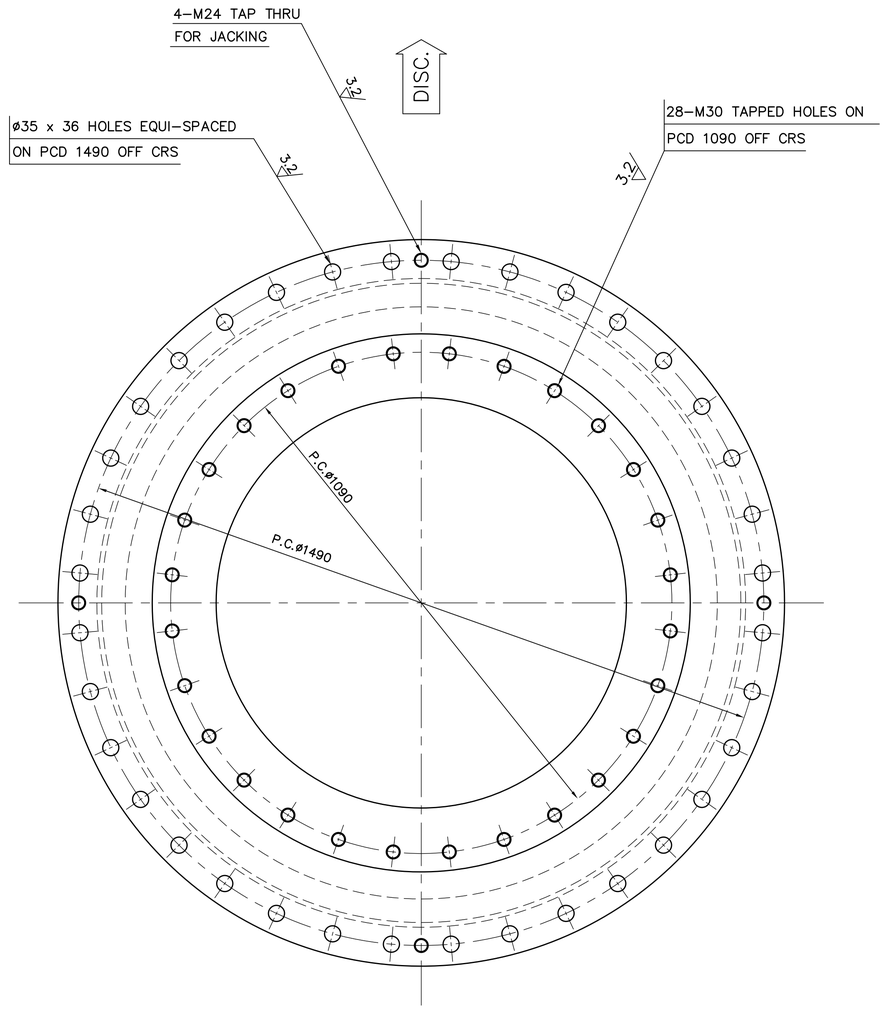
FIRST ANGLE PROJECTION

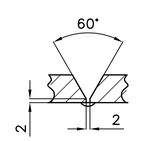
(ALL DIMENSIONS ARE IN mm)

DRG. NO. 1 182 36 1 7174

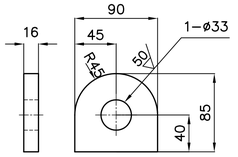
50/ 6.3/ 3.2/







WELD DETAIL–R

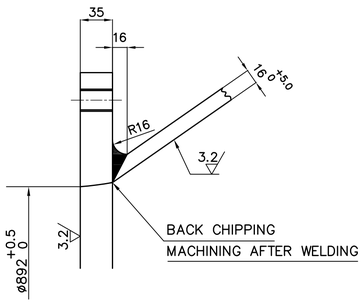


ITEM–4 DETAILS

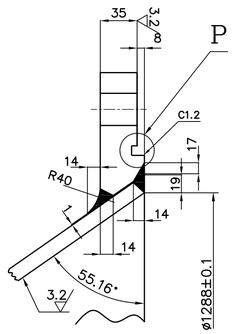
NOTE–1

1) MECHANICAL AND CHEMICAL PROPERTIES REPORT SHALL BE SUBMITTED
2) FOR FLANGES POS.NOs 2&3; SEGMENTAL WELDING IS PERMITTED (MAXIMUM 4 SEGMENTS). SEGMENTS SHALL BE WELDED WITH DOUBLE "U" TYPE WELDING AS SHOWN IN DETAIL "D".
3) FOR SHELL POS.No 1; MAXIMUM 1 NO VERTICAL WELD JOINT AS PER DETAIL–'R' IS PERMITTED.
4) DIMENSIONS SHOWN IN THE FINISH MACHINED DRAWING ARE FINISH MACHINED DIMENSIONS.
5) WELDING AS PER BHEL WELD PROCEDURE SPECN NO. WE–042
6) D.P.T SHALL BE DONE ON 100 % OF WELDS AS PER AA0850131 ACCEPTANCE AS PER AA0850129 LEVEL–IV.
7) R.T TO BE CARRIED OUT ON ALL WELD JOINTS 100 % AS PER THE QUALIFICATION PROCEDURE–ASME SECTION VIII DIV I, UW 51, WPS, PQR AND WELDER QUALIFICATION SHALL BE AS PER ASME SECTION –IX.
8) WHEREVER NOT SPECIFIED, ALL SHARP EDGES TO BE CHAMFERED TO 2x45°.
9) WHEREVER NOT SPECIFIED TOLERANCE ON MACHINED DIMENSIONS AS PER AA0230208 MEDIUM CLASS.
10) COMPONENT SHALL BE PRESSURE TESTED AT 5.5 Kg/Sq. Cm. FOR 30 MINUTES DURATION.
11) DIMENSIONAL INSPECTION REPORT.
12) MACHINED SURFACES SHALL NOT BE PAINTED.
13) MACHINED SURFACES SHALL BE COATED WITH SUITABLE RUST PREVENTIVE COAT AS PER HY0490563, CATEGORY 'B'
14) TO BE PROPERLY PACKED AND DESPATCHED SUCH THAT NO DAMAGE IS CAUSED DURING HANDLING AND TRANSIT.

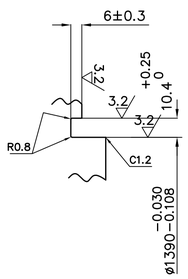
MATERIAL: DUPLEX SS TO UNS 32750
PREN (%CR+3.3%Mo+16%N) > 38



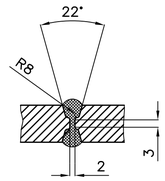
DETAIL–'A'



DETAIL–'B'



DETAIL–'P'



DETAIL–'D'

ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.
01	SUCTION LINER	1 182 36 1 7174	00		FP9714071127	480	480
					DUPLEX SS 2205 TO UNS 32750	1	
					MATERIAL SPECN.	QUANTITY	

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED.

1. REF.TO HY0230261 FOR UNTOLERANCES.
2. CHAMFER M/CD SHARP EDGES 1.2 TO 1.0 AT 45°.
3. INTERNAL M/CD CORNER RADII 1 TO 0.7.
4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: CW10M OUTFALL PUMP

भारत हेवी इलेक्ट्रिकल्स लिमिटेड
हैदराबाद
BHARAT HEAVY ELECTRICALS LTD.
HYDERABAD

	NAME	SIGN.	DATE
DRN.	SRINIVAS	SRINIVAS	01.11.21
CHD.	SATISH	SATISH	01.11.21
APPD.	K.H.R.K	K.H.R.K	01.11.21

NO.OF VAR.

DEPT.	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO.OF ITEMS
PUMPS	N.T.S	480	–NA–	–NA–	–NA–
CODE 410					

TITLE: SUCTION LINER

DRAWING NO. 1 182 36 1 7174 REV. 00

SHEET NO. NO OF SHEETS

REV.	DATE	ALTERED	CHECKED	APPD.	ZONE

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COMPUTER FILE NAME : | REF. DRG. NO. | SIGN. AND DATE | INVENTORY NO

Nov Tue 2 09:59 2021

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