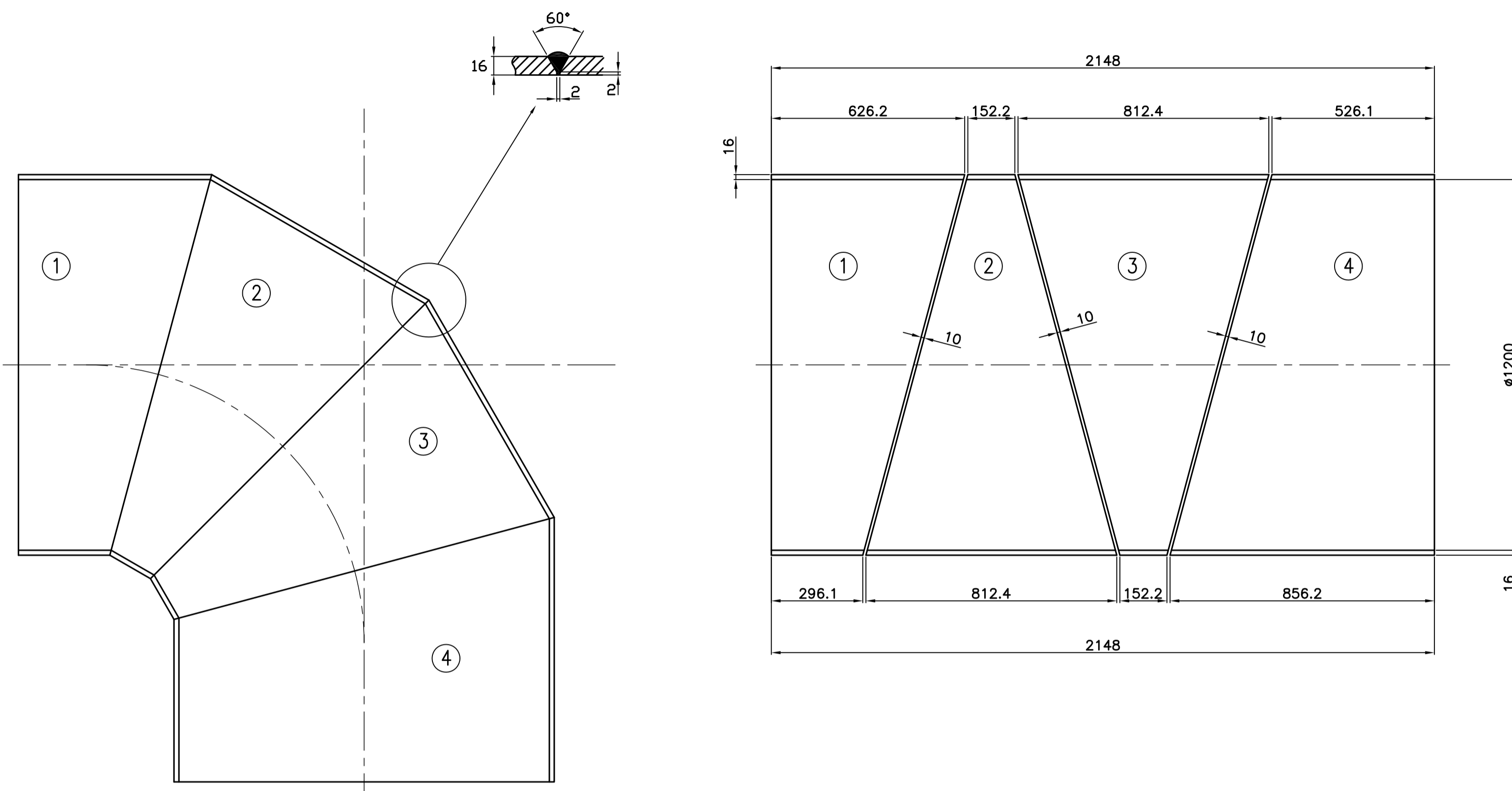


WELDING AS PER WPS , WE-042



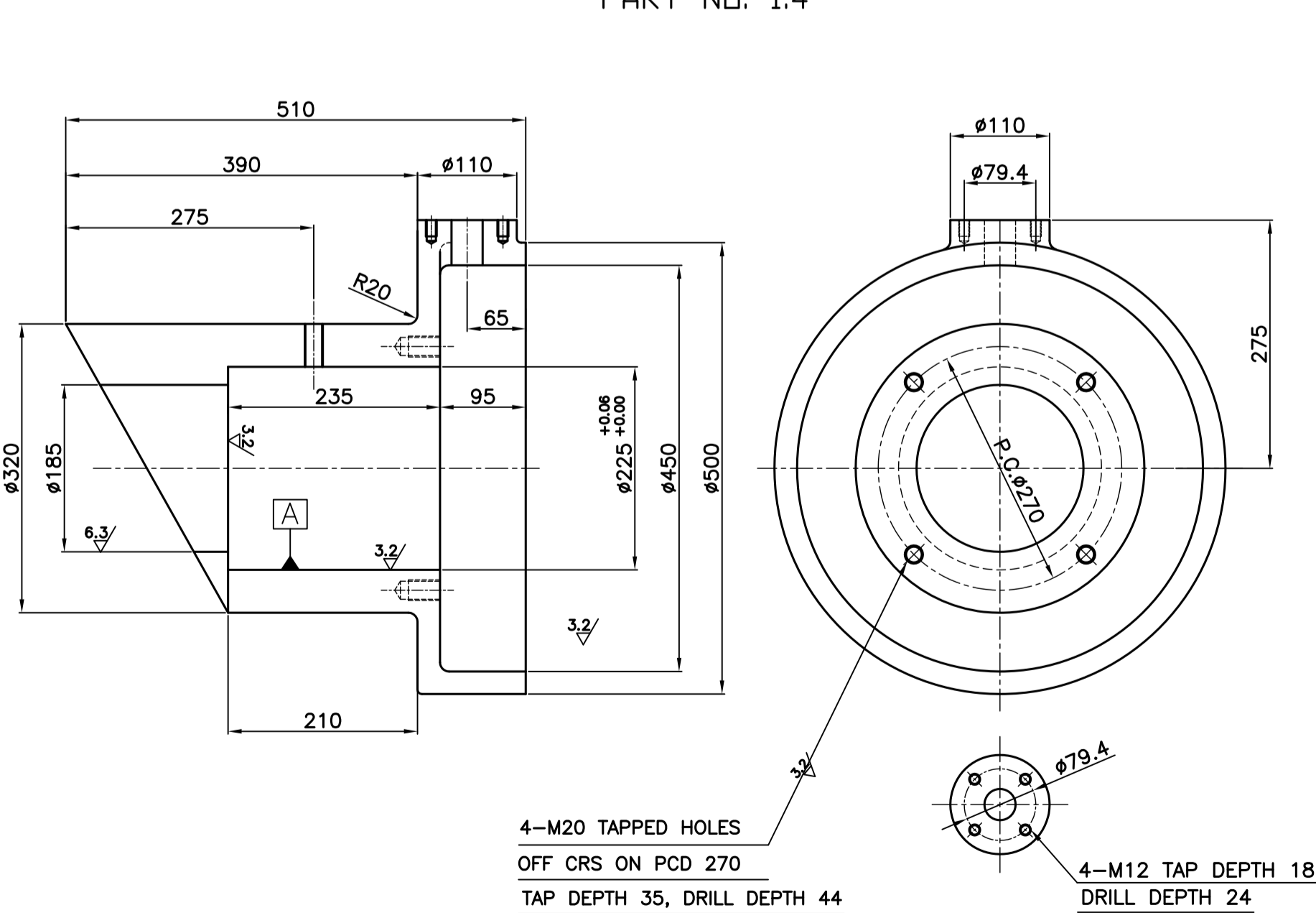
NOTE-1

- 1) MECHANICAL AND CHEMICAL PROPERTIES REPORT SHALL BE SUBMITTED
- 2) FOR FLANGES POS.NOs 1.2&1.3; 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 2 NO VERTICAL WELD JOINT IS PERMITTED.
- 4) FLANGES TO SHELL AND RIBS SHALL BE WELDED ALL ROUND THE CONTACT AREA TO 12 MM FILLET.
- 5) DIMENSIONS SHOWN IN THE FINISH MACHINED DRAWING ARE FINISH MACHINED DIMENSIONS.
- 6) WELDING AS PER BHEL WELD PROCEDURE SPECN NO. WE-042
- 7) D.P.T SHALL BE DONE ON 100 % OF WELDS AS PER AA0850131 ACCEPTANCE AS PER AA0850129 LEVEL-IV.
- 8) 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.
- 9) WHEREVER NOT SPECIFIED, ALL SHARP EDGES TO BE CHAMFERED TO 2x45'.
- 10) WHEREVER NOT SPECIFIED TOLERANCE ON MACHINED DIMENSIONS AS PER AA0230208 MEDIUM CLASS.
- 11) COMPONENT SHALL BE PRESSURE TESTED AT 5.5 Kg/Sq. Cm. FOR 30 MINUTES DURATION.
- 12) DIMENSIONAL INSPECTION REPORT.
- 13) MACHINED SURFACES SHALL NOT BE PAINTED.
- 14) MACHINED SURFACES SHALL BE COATED WITH SUITABLE RUST PREVENTIVE COAT AS PER HY0490563, CATEGORY 'B'
- 15) TO BE PROPERLY PACKED AND DESPATCHED SUCH THAT NO DAMAGE IS CAUSED DURING HANDLING AND TRANSIT.

PART NO. 1.1

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

PART NO. 1.4



PART NO. 1.5
16 THK; 1 NO.
SCALE: 2:1

DETAIL-P

DETAIL-D

1.7	SORF FLANGE 1" CLASS 150		SORF FLANGE 1", CLASS 150			0.78
1.6	PIPE 1" SCHEDULE 40		PIPE 1" X L185; SCH40			0.73
1.5	RIB					1
1.4	STUFFING HOUSING					1
1.3	PLATE					1
1.2	PLATE					1
1.1	DISCHARGE BEND					1
01	DISCHARGE ELBOW			FP9712011127	1590	1590
				DUPLEX SS 2205 TO UNS 32750		1
ITEM NO	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT. GROSS WT.
					MATERIAL SPECN.	QUANTITY

THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED

1. REF.TO HY0230261 FOR UN TOLERANCES.
2. CHAMFER M/CD SHARP ED 1.2 TO 1.0 AT 45'.
3. INTERNAL M/CD CORNER RADI 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	
BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD	
DRN. SRINIVAS	SIGN. SRINIVAS	DATE 16.02.21	NO.OF VAR.
CHD. SATISH	SIGN. SATISH	DATE 16.02.21	
APPD. MSRAM	SIGN. MSRAM	DATE 16.02.21	
DEPT. PUMPS	SCALE N.T.S	WEIGHT (KG) 1590	REF. TO ASSY DRG. -NA-
CODE 410			ITEM NO. -NA-
TITLE		DRAWING NO.	
DISCHARGE ELBOW (2/2)		1 182 47 1 7018	
SHEET NO. 02		NO OF SHEETS 02	

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

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