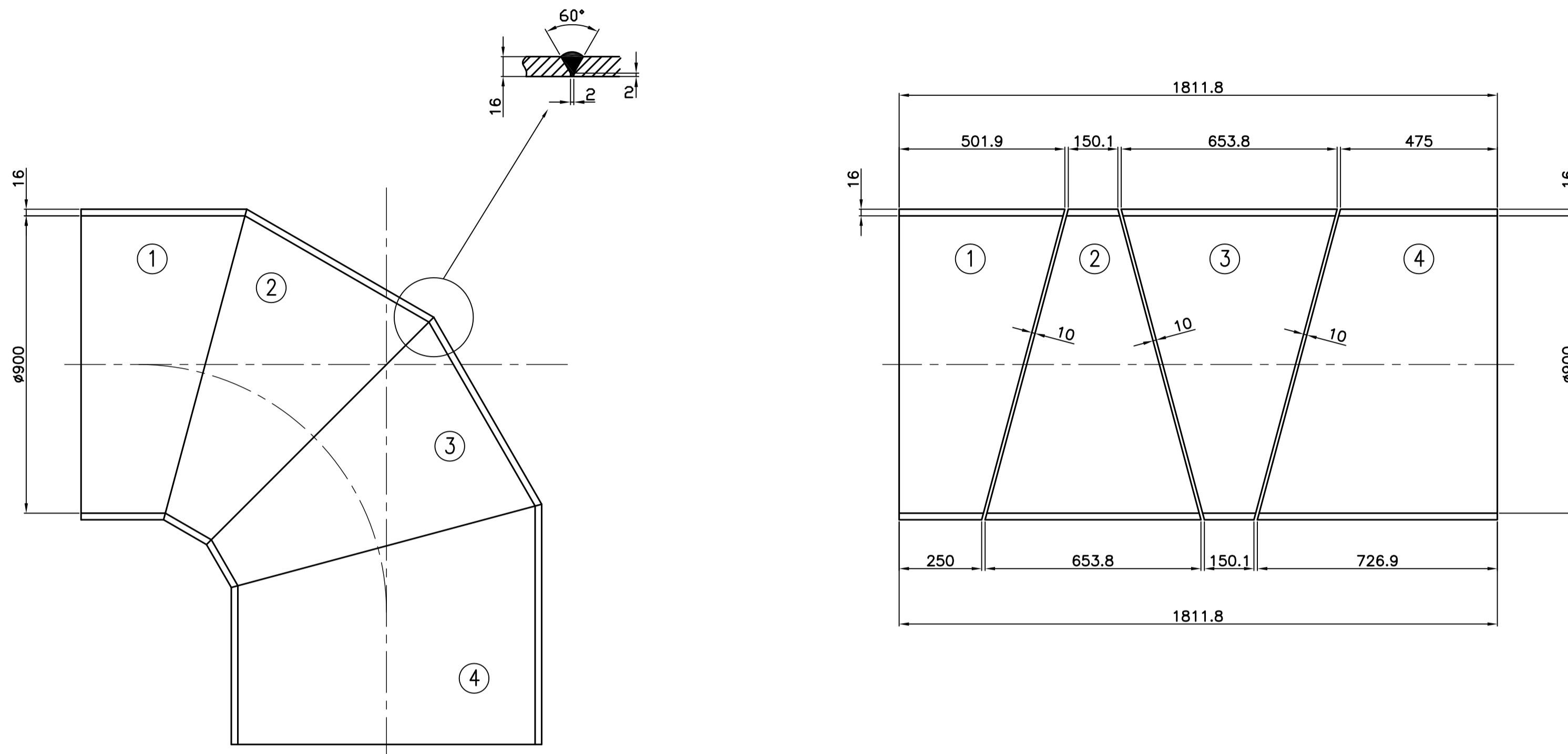


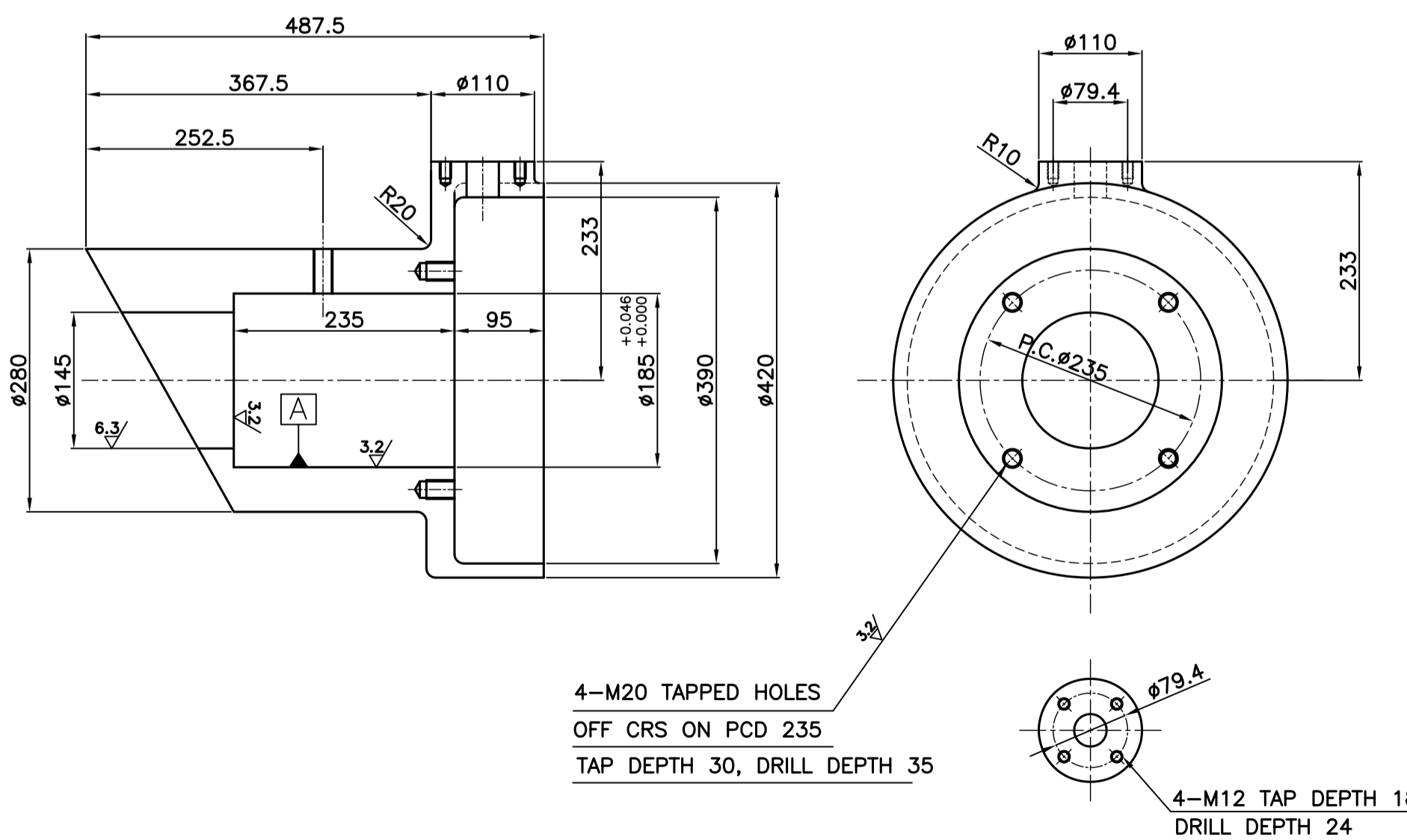
WELDING AS PER WPS , WE-042



NOTE-1

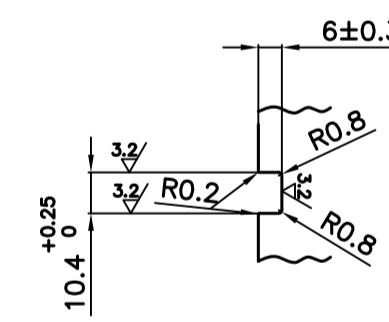
- 1) MECHANICAL AND CHEMICAL PROPERTIES REPORT SHALL BE SUBMITTED
- 2) FOR FLANGES POS.NOS 2&3; SEGMENTAL WELDING IS PERMITTED (MAXIMUM 4 SEGMENTS). SEGMENTS SHALL BE WELDED WITH DOUBLE 'U' TYPE WELDING AS SHOWN IN DETAIL 'D'.
- 3) FOR SHELL POS.No 1; MAXIMUM 1 NO VERTICAL WELD JOINT AS PER DETAIL-'R' 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) WHEREVER WELD SYMBOLS NOT SHOWN, ALL RIBS ARE TO BE WELDED ALL ROUND THE CONTACT AREA TO 12 MM FILLET
- 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 5.0 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. 02

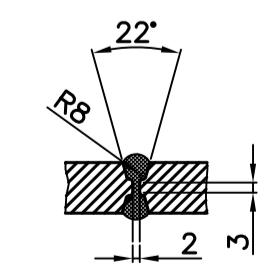


PART NO. 1.5  
20 THK; 1 NO.  
SCALE: 2:1

SCALE: 2:1



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.
07	SORF FLANGE 1" CLASS 150			SORF FLANGE 1", CLASS 150		2	0.78
06	PIPE 1" SCHEDULE 40			PIPE 1" X L185; SCH40		2	0.73
05	STUFFING HOUSING					1	
04	PLATE					1	
03	PLATE					1	
02	DISCHARGE BEND					1	
01	DISCHARGE ELBOW				FP9715941044	1040	1040

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 CW MAKEUP PUMP	
BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		BHARAT HEAVY ELECTRICALS LTD. HYDERABAD	
DEPT. PUMPS	SCALE N.T.S	WEIGHT (KG) 1040	REF. TO ASSY DRG. -NA-
CODE 410			ITEM NO. -NA-
TITLE DISCHARGE ELBOW (2/2)		DRAWING NO. 1 182 47 1 7017	
SHEET NO. 02		NO OF SHEETS 02	

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

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