DRAWING NO. 2-V-0000-05573

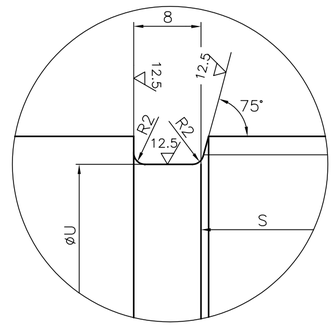
ALL DIMENSIONS ARE IN MILLIMETRES. FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER RELEVANT QCP / QP

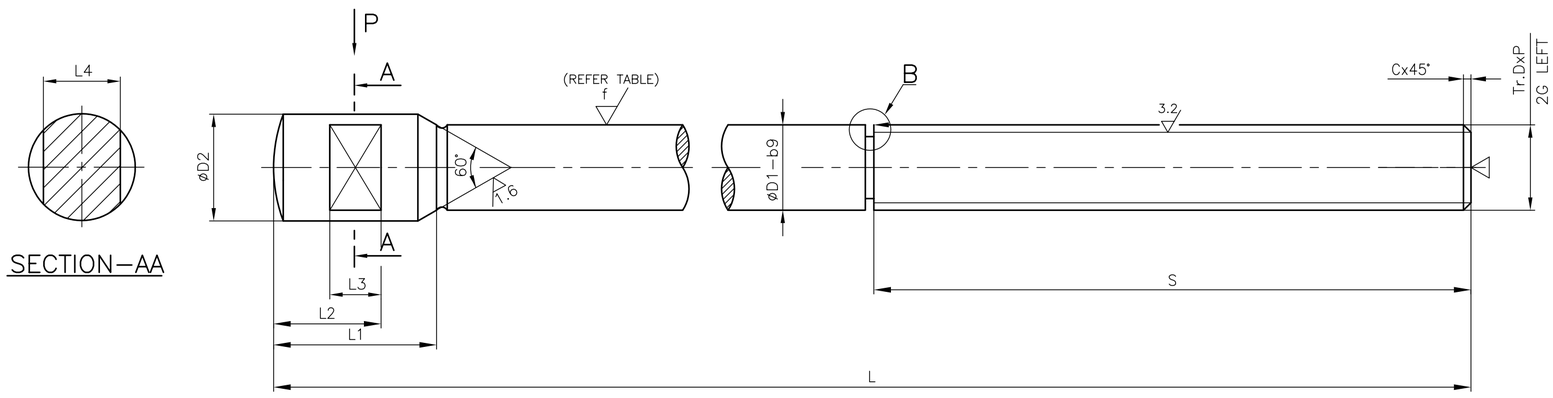
12.5 3.2 0.4

SL. No.	DRG. No.	COMP. CODE	MATL. SPECN	øD1 –b9	øD2	øU +0.5 0	S	L	L1	L2	L3	L4	C	L5	L6	W	W1	f	SCRAP SORT	Tr DxP 2G–LEFT	FINISHED Wt.(kg)	SIZE/ RATING
01	2-V-N001-05573/02	93 104 001 0000	ASTM A182-GR. F6a CL.3 HT (CERTIFY)	28.575	40	22.2	263	570	52	36	20	20	3					0.4	40	1.125"–5ACME	2.86	6"–150C HO
02	2-V-N002-05573/03	93 104 002 0000		28.575	40	22.2	275	625	52	36	20	20	3					0.4	40	1.125"–5ACME	3.51	6"–150C HO SG
03	2-V-N009-05573/02	93 104 003 0000		31.750	45	24.1	310	694	54	37	22	30	3					0.4	40	1.250"–4ACME	4.15	8"–150C
04	2-V-N017-05573/02	93 104 004 0000		31.750	40	24.1	290	630	52	36	20	20	3					0.4	40	1.250"–4ACME	4.10	6"–300C
05	2-V-N049-05573/04	93 104 005 0000		22.225	32	15.9	155	392	41	–	–	–	3	29	13	25.5	10	0.4	40	0.875"–5ACME	1.32	3"–300C
06	2-V-N025-05573/04	93 104 006 0000		22.225	32	15.9	155	383	41	–	–	–	3	29	13	25.5	10	0.4	40	0.875"–5ACME	1.29	3"–150C
07	2-V-N033-05573/03	93 104 007 0000		25.400	32	19.1	196	454	41	28	16	18	3					0.4	40	1.000"–5ACME	1.53	4"–150C
08	2-V-N041-05573/02	93 104 008 0000		38.100	50	30.4	437	960	69	47	28	30	3.5					0.4	40	1.500"–4ACME	8.35	12"–150C
09	2-V-N057-05573/02	93 104 009 0000		34.925	50	27.3	375	840	69	47	28	30	3.5					0.4	40	1.375"–4ACME	6.55	10"–150C
10	2-V-N065-05573/02	93 104 010 0000		41.275	50	33.6	388	860	69	47	28	30	3.5					0.4	40	1.625"–4ACME	9.36	10"–300C
11	2-V-N089-05573/02	93 104 011 0000		34.925	45	27.3	365	780	64	41	22	30	3.5					0.4	40	1.375"–4ACME	6.16	8"–300C
12	2-V-N097-05573/02	93 104 012 0000		25.400	32	19.1	204	460	41	28	16	18	3					0.4	40	1.000"–5ACME	1.54	4"–300C
13	2-V-N105-05573/02	93 104 052 0000		41.275	55	33.6	425	961	75	52	28	34	4.5					0.4	40	1.625"–4ACME	10.7	12"–300C MO & GO
14	2-V-M357-05573/01	93 105 306 0000	SA182–F304 SOLUTION HEAT TREATED CERTIFY	25.4	32	19.1	204	460	41	28	16	18	3					0.4	46	1.0"–5ACME	1.54	4"–300C
15	2-V-M358-05573/01	93 105 307 0000		31.75	40	24.1	290	630	52	36	20	20	3					0.4	46	1.25"–4ACME	4.10	6"–300C
16	2-V-M359-05573/01	93 105 308 0000		34.925	45	27.3	365	780	64	41	22	30	3.5					0.4	46	1.375"–4ACME	6.16	8"–300C
17	2-V-N227-05573/02	93 105 433 0000	ASTM A182 Gr. F6a CL.3 HT–CERTIFY	41.275	50	33.6	388	922	69	47	28	30	3.5					0.4	40	1.625"–4ACME	10.01	10"–300C
18	2-V-N588-05573/01	93 108 464 0000		41.275	50	33.6	417	912	69	47	28	30	3.5					0.4	40	1.625"–4ACME	10.00	10"–300C
19	2-V-K994-05573	93 109 645 0000		25.400	32	19.1	223	492	41	28	16	18	3					0.4	40	1.000"–5ACME	1.87	4"–300C(SPF)
20	2-V-J002-05573	93 109 646 0000		31.75	40	24.1	290	660	52	36	20	20	3					0.4	40	1.25"–4ACME	4.286	6"–300C(SPF)
21	2-V-K998-05573	93 109 647 0000		34.925	45	27.3	373	800	64	41	22	30	3.5					0.4	40	1.375"–4ACME	6.30	8"–300C(SPF)
22	2-V-K996-05573	93 109 648 0000		41.275	50	33.6	417	912	69	47	28	30	3.5					0.4	40	1.625"–4ACME	10.00	10"–300C(SPF)
23	2-V-N905-05573	93 201 369 0000	ASTM A182–F316 SH,CERTIFY	41.275	55	33.6	425	961	75	52	28	34	4.5					0.4	46	1.625"–4ACME	10.7	12"–300C GO CF8

ABOVE & INCLUDING	b9
ø18–ø30	–0.160 –0.212
ø30–ø40	–0.172 –0.232
ø40–ø50	–0.180 –0.242

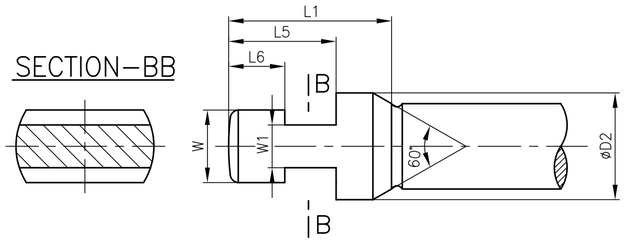
DETAIL–B





VIEW–P

(ONLY'FOR SL.NO.05 & 06–3"–150C & 300C)



NOTES:–

1. HARDNESS 250 TO 300 BHN FOR SA182–F6a CL.3

No OFF	DESCRIPTION	MATL CODE	MATL SPECN	HEAT TREATMENT	SCRAP SORT	NET WT (kg)	GROSS WT (kg)	DRAWING No	ITEM No

REV	DATE	ALTERED
12	12.06.08	T.R.RAMAMURTHY
		CHD & APPD P.BOOMINATHAN
ZONE		SL. No. 23 INCLUDED

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TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: CS

DRG. REDRAWN WITH REVISION 12 ON 12.06.2008
(REFER DCN.CS:0342,0257,0477,0688,0785,0835)
(REFER DCP.800223)

BHARAT HEAVY ELECTRICALS LTD.,
UNIT: HIGH PRESSURE BOILER PLANT.
TIRUCHIRAPALLI -620014.
365–120

	NAME	SIGN	DATE	NO.OF VAR.
DRN	K.P.LEON		31.08.03	–
CHD	P.BOOMINATHAN		31.08.03	
APPD	K.S.RAMAN		31.08.03	

DEPT VL | CODE 320 | SCALE NTS. | WEIGHT (KG). – | REFERENCE INFORMATIONS CAD:C205573 | NO. OF ITEMS –

TITLE: STEM | CARD CODE U 01 | DRAWING NO. 2–V–0000–05573 | REV 12

Size A2