

DRAWING No. 3-80-300-19825

NOTES: - 01. APPLICABLE FOR P91/P92
03 i) STRAIGHT WITH STRAIGHT/FITTING
03 ii) BEND WITH BEND/FITTING

- 04 02. FOR OD MISMATCH, REFER FIGURE-Xa
04 03. REFER STYLE-DL FOR THICKNESS <14.2mm (FOR ALL OD/ID)
04 04. REFER STYLE-PL
i) WHEN THICKNESS IS ≥ 14.2 mm & <20mm (FOR ALL OD/ID)
ii) WHEN THICKNESS ≥ 20 mm & OD <219.1mm.
04 05. $\alpha = 6^\circ$ FOR WALL THICKNESS ≥ 20 MM AND ≤ 30 mm
06. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm

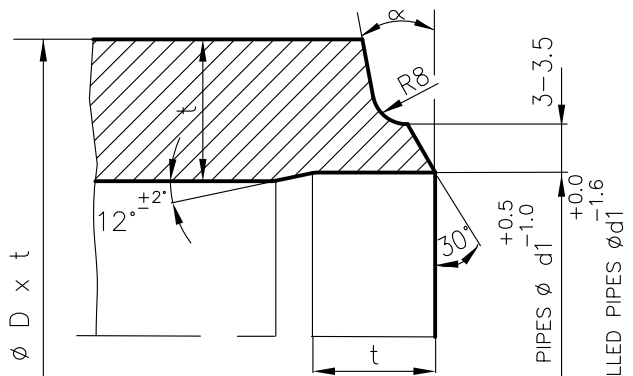


FIGURE - X

- MATCHING EDGE PREPARATION
02 FOR MISMATCH OD APPLICABLE FOR
BENDS/FITTINGS OF P91/P92 MATERIALS 03
NOTES: -
01. OD OF STRAIGHT TO BE PHYSICALLY MEASURED/VERIFIED.
02. t = THK OF CONNECTING PIPE (STRAIGHT)

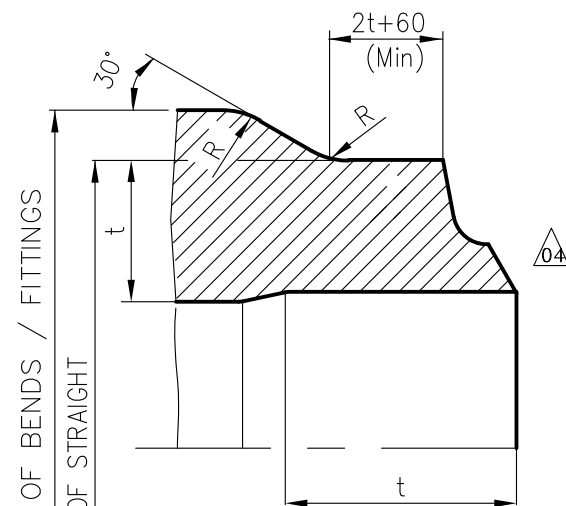
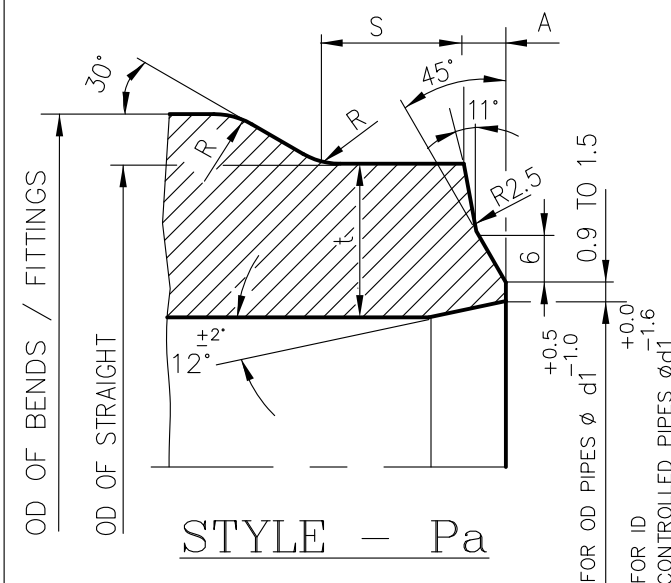


FIGURE - Xa

- MATCHING EDGE PREPARATION FOR MISMATCH OD
DIAMETRICALLY GREATER THAN 8 mm
(ie OD1 - OD2 > 8mm) APPLICABLE FOR
BENDS/FITTINGS OTHER THAN P91/P92 MATERIALS
NOTES: -
01. OD OF STRAIGHT TO BE PHYSICALLY MEASURED/VERIFIED.
02. WHEN $t < 65$, $S+A = 65$ Min. & $t > 65$, $S=65$ Min.
WHERE t=THK OF CONN.PE(STRIGHT).



STYLE - Pa

- MATCHING EDGE PREPARATION FOR MISMATCH OD
DIAMETRICALLY GREATER THAN 8 mm
(ie OD1 - OD2 > 8mm) APPLICABLE FOR
ELBOWS OTHER THAN P91/P92 MATERIALS
NOTES: -
01. OD = OUTSIDE DIA OF CONN. PIPE (STRAIGHT)
TO BE PHYSICALLY MEASURED/VERIFIED.
02. t = THK OF CONN.PE(STRIGHT)
03. t = THK OF CONN.PE(STRIGHT)

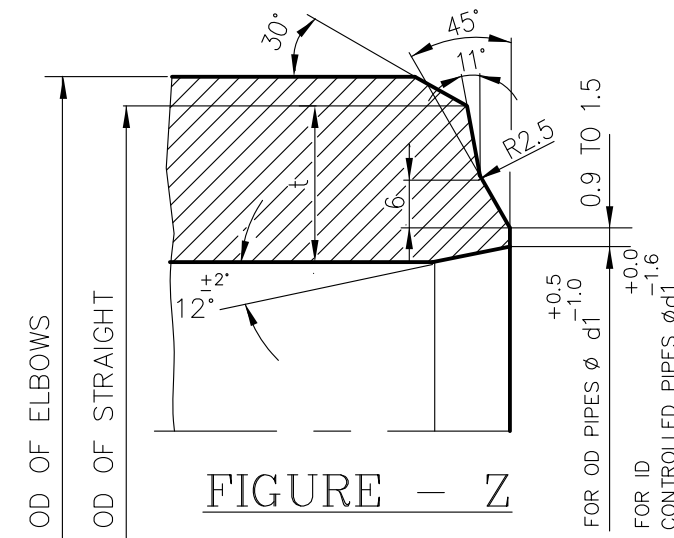


FIGURE - Z

- NOTES: - 01. APPLICABLE FOR P91/P92 ZERO ARM PIPEBEND WELDED WITH P91/P92 STRAIGHT PIPE
02. FOR OD MISMATCH, REFER FIGURE-Xa
03. REFER STYLE-DL FOR THICKNESS <14.2mm (FOR ALL OD/ID)
04 04. REFER STYLE-PL
i) WHEN THICKNESS IS ≥ 14.2 mm AND <20 mm FOR ALL OD/ID.
ii) WHEN THICKNESS ≥ 20 mm AND OD < 219.1 mm.
05. $\alpha = 6^\circ$ FOR WALL THICKNESS ≥ 20 MM AND ≤ 30 mm
06. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm

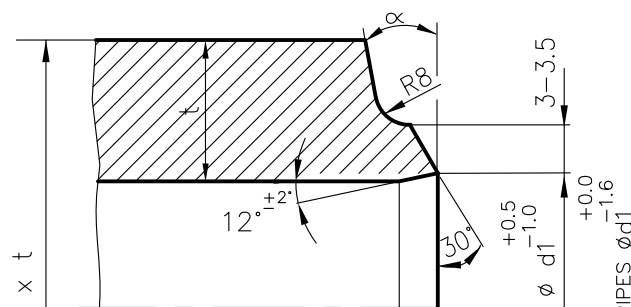


FIGURE - Xb

(BEND END) 03

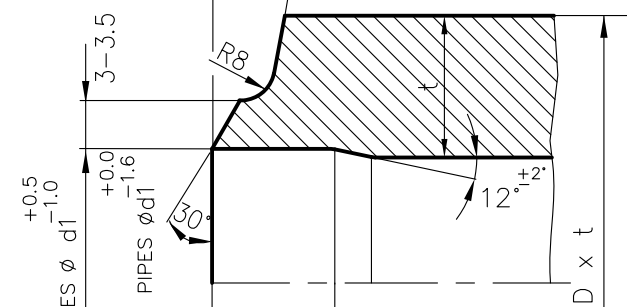
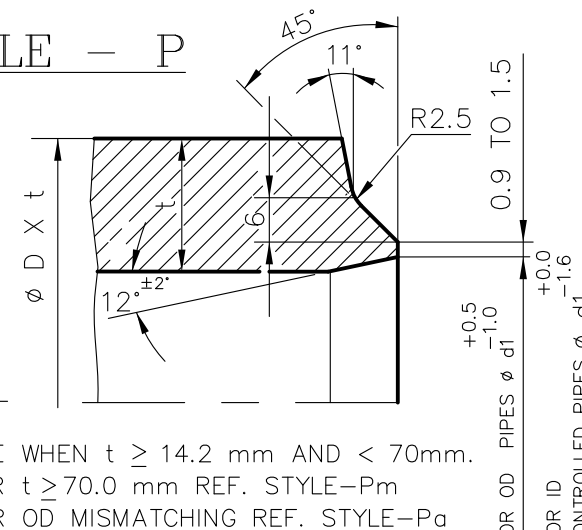


FIGURE - Xc

(STRAIGHT END) 03

STYLE - P

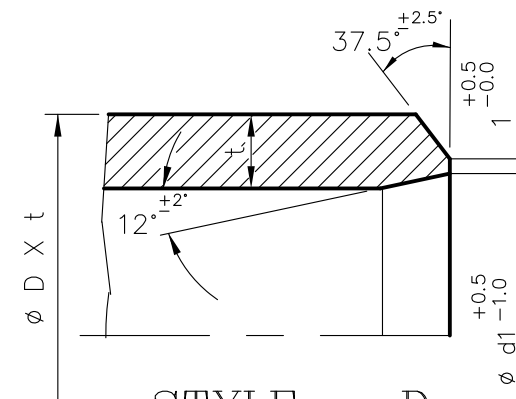


NOTES: -

- 04 01. USE WHEN $t \geq 14.2$ mm AND < 70mm.
04 02. FOR $t \geq 70.0$ mm REF. STYLE-Pm
03. FOR OD MISMATCHING REF. STYLE-Pa

NOTES: -

01. USE WHEN $t < 14.2$ mm.



STYLE - D

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

01 STANDARD

GENERAL NOTES :

01. THE MINIMUM THICKNESS AT WELD END SHALL NOT BE LESS THAN
a) 0.875 TIMES t NOM. FOR OD PIPES.
b) t MIN. FOR ID CONTROLLED PIPES.
02. t NOM & t MIN SHALL BE AS PER SPECIFIED PIPE SIZE.
03. SHARP CORNERS SHALL BE ROUNDED OFF WHEREEVER 'R' IS INDICATED. 02

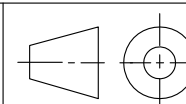
NOTES FOR WELDING:

01. WELD REINFORCEMENT TO BE FLUSH GROUND AND MERGED WITH PARENT METAL WITHOUT ANY UNEVENNESS.

REV 04	DATE 07.12.16	ALTERED: P SURESH APPROVED: R SESHAGIRI
ZONE	SHEET 2 OF 2 IS ADDED. NOTES ADDED, MODIFIED AND DELETED IN FIGURE-X, Xa, Xb, Xc AND STYLE-P	
REV 03	DATE 10.04.13	ALTERED: M.R.K APPROVED: C.K.N
ZONE	FIG Xb AND FIG Xc ADDED. IN FIG.X, NOTE 01 MODIFIED. IN FIG.Xa, STY-Pa, FIG.Z, P92 MATERIAL ADDED	
REV 02	DATE 10.01.13	ALTERED: M.R.K APPROVED: C.K.N
ZONE	IN FIG.Xa, NOTE 04 ADDED. GENERAL NOTES 03 ADDED. IN FIG.Xa, 8MM OD MISMATCH IS REMOVED	
REV 01	DATE 11.05.04	ALTERED: R.SENDHIL APPROVED: A.VELAYUTHAM
ZONE	PROJECT NAME REMOVED AND STANDARD INCORPORATED IN TITLE BLOCK	

BHARAT HEAVY ELECTRICALS LTD.,
PIPING CENTRE, MADRAS

DEPT.

GRADE OF
UN TOL. DIM

SCALE

WEIGHT (Kg).

NAME OF ORIGINAL
ORGANISATIONITEM
No.

CODE

C/M/F

TITLE

EDGE PREPARATION
DETAILSCARD
CODE

U 01

DRAWING No.

3-80-300-19825

SHEET 1 OF 2

REV

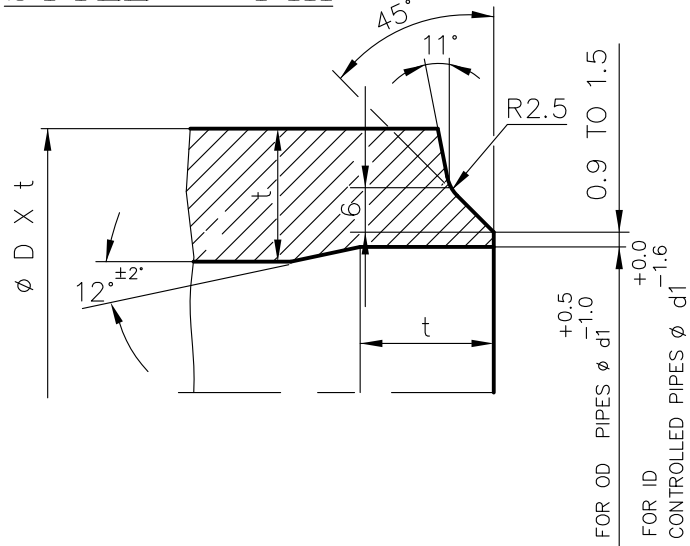
04

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3-80-300-19825

DRAWING No.

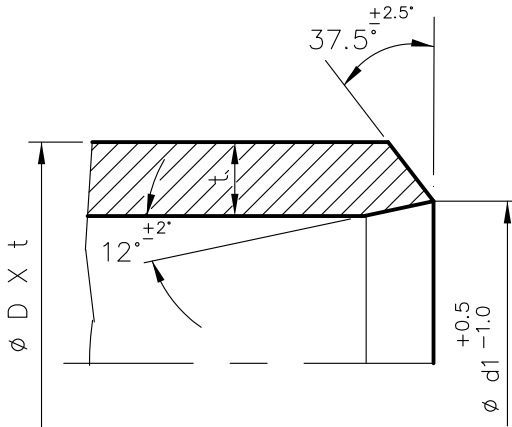
STYLE - P_m



NOTES: -

01. USE FOR SA106GRC PIPES WHEN $t \geq 70.0$ mm.
02. FOR OD MISMATCHING REF. FIGURE-P_a
03. FOR FITTINGS USE STYLE-P.

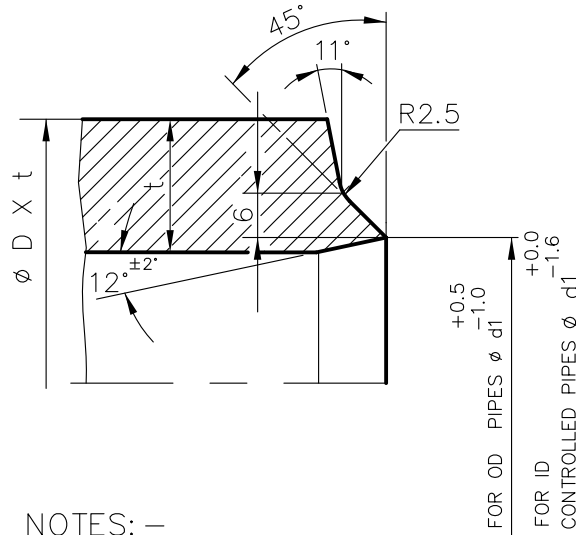
STYLE - D_L



NOTES: -

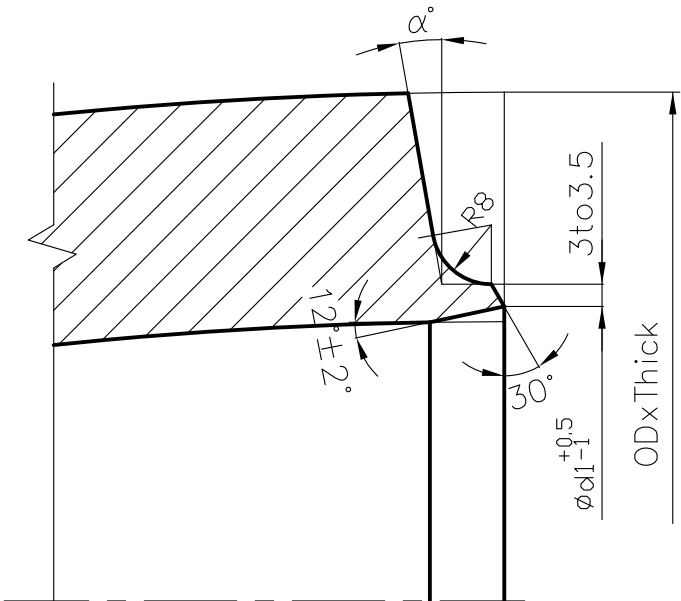
01. USE FOR P91 / P92 PIPES AND FITTINGS WHEN $t < 14.2$ mm (ALL OD/ID).

STYLE - P_L



NOTES: -

01. USE FOR P91 / P92 PIPES AND FITTINGS
i) WHEN THICKNESS IS ≥ 14.2 mm AND < 20 mm FOR ALL OD/ID.
ii) WHEN THICKNESS ≥ 20 mm AND OD < 219.1 mm.
02. FOR OD MISMATCHING REF. FIGURE-P_a



01. USE FOR P91 / P92 FITTINGS
02. REFER STYLE-D_L FOR THICKNESS < 14.2 mm FOR ALL OD/ID.
03. REFER STYLE-P_L
i) WHEN THICKNESS IS ≥ 14.2 mm AND < 20 mm FOR ALL OD/ID.
ii) WHEN THICKNESS ≥ 20 mm AND OD < 219.1 mm.
04. $\alpha = 6^\circ$ FOR WALL THICKNESS ≥ 20 mm AND ≤ 30 mm
05. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm.
06. FIGURE-Xf IS APPLICABLE FOR ALL BUTT WELDED FITTINGS NOT COVERED IN NOTES 02 & 03

FIGURE-Xf

NOTE :

01. FOR GENERAL NOTES AND NOTES FOR WELDING REFER SHEET 1 OF 2.

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

STANDARD

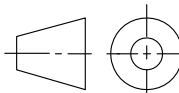


BHARAT HEAVY ELECTRICALS LTD.,
PIPING CENTRE, MADRAS

DRN	NAME	SIGN	DATE	NO OF ITEMS
CHD	P SURESH		07.12.16	
APPD	R SESHAGIRI		07.12.16	
	C KARUNAKARAN		07.12.16	

DEPT.

GRADE OF
UN TOL. DIM



SCALE

WEIGHT (Kg).

NAME OF ORIGINAL
ORGANISATION

ITEM
No.

CODE

C/M/F

TITLE

EDGE PREPARATION
DETAILS

CARD
CODE

U 01

DRAWING No.

3-80-300-19825

SHEET 2 OF 2

REV

04