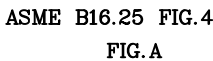


DRAWING NO.



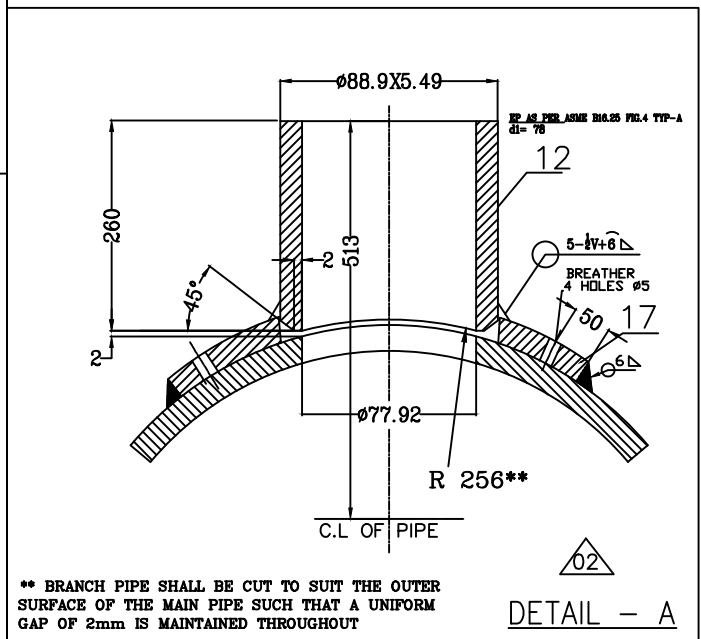
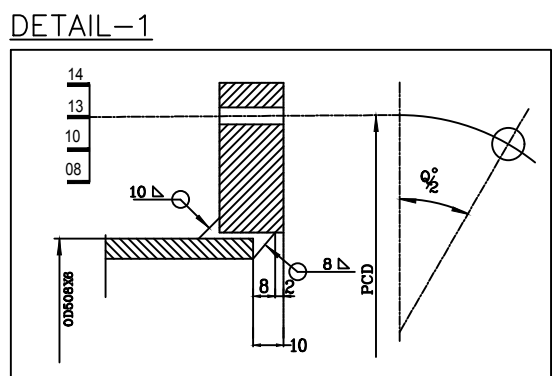
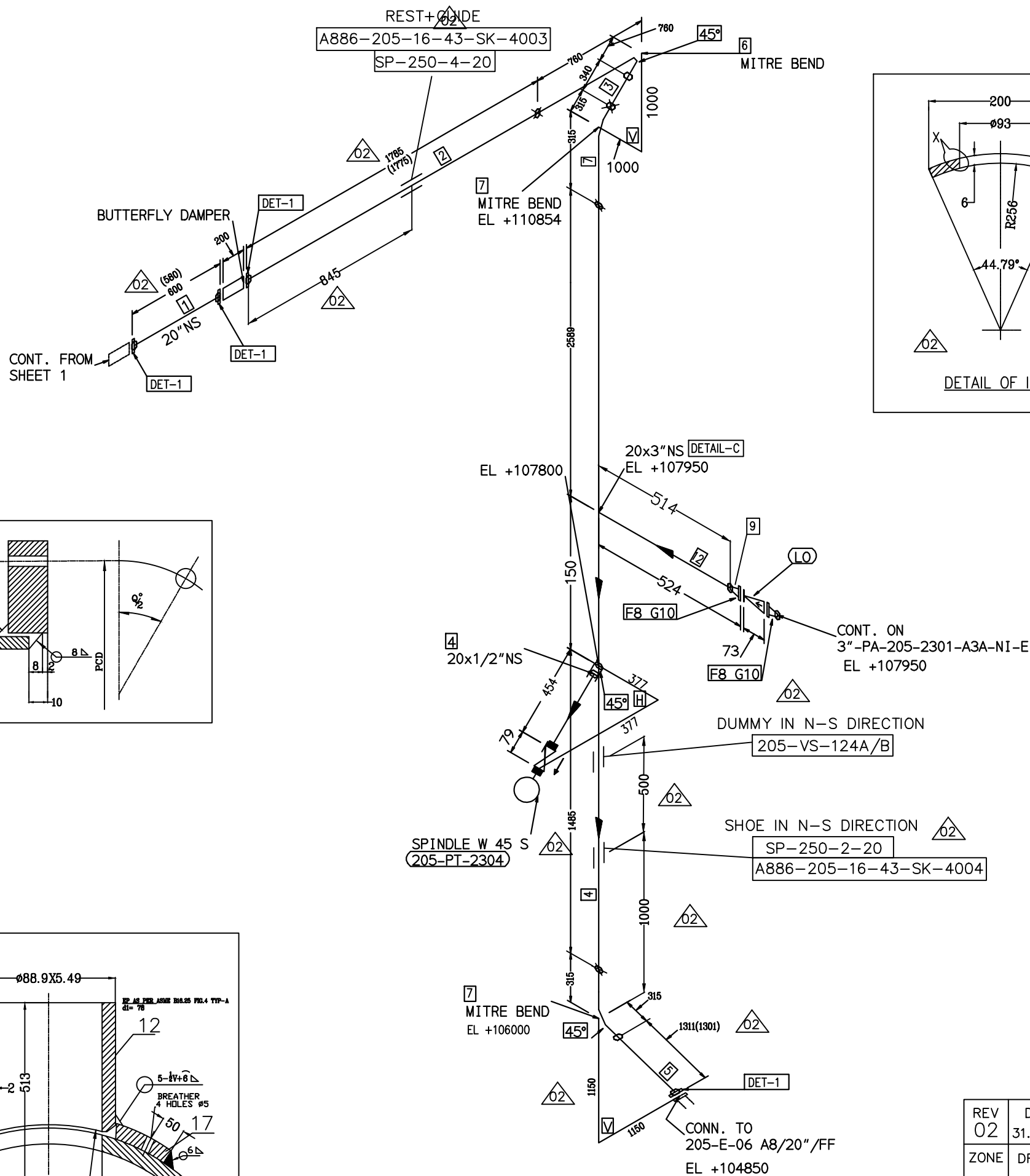
ALL DIMENSIONS ARE IN MILLIMETRES

1. DESIGN PRESSURE - 0.2 KG/CM² (G) DESIGN TEMPERATURE: 500°C
2. FOR STANDARD NOTES OF PRODUCTION AND ERECTION OF PIPES AND TOLERANCE ON FITTINGS REFER DRG NO. 4-80-001-37654 & 4-80-301-26192
3. FOLLOW APPLICABLE QP AND PAINTING SCHEDULE FOR THE PROJECT
4. ALL UNMARKED BENDS/ELBOWS ARE 90 DEG
5. PIPE ENDS SHALL BE BEVELLED AS PER B16.25 FIG4
6. GASKET IS SUPPLIED VIDE 7419-80-733 PGMA.
7. FOR ELECTRODE DATA REFER

PIPE SIZE	MATERIAL SPEC	EP FIG	WELD SPEC	ELECTRODE DATA	
				ROOT RUN	FILLER RUN
OD1020x8	ASTMA516 GR.70	FIG--A	8 $\widehat{V}$	ER70S-B2L/ ER80S-B2	ER70S-B2L/ ER80S-B2/ER7016 -B2L/ER7016-B2L

8. THREADS SHALL BE UNIFIED(UNC FOR UPTO 1" DIA) AS PER ASME B1.1 WITH CLASS 2A FIT FOR STUDS AND CLASS 2B FIT FOR NUTS.

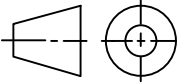
 9.  INDICATES WELD AT SHOP.
 10.  INDICATES WELD AT SITE.



**** BRANCH PIPE SHALL BE CUT TO SUIT THE OUTER SURFACE OF THE MAIN PIPE SUCH THAT A UNIFORM GAP OF 2mm IS MAINTAINED THROUGHOUT**

REV 02	DATE 31.05.19	ALTERED APPROVED	M.P.K TRINADH
ZONE	DRAWING REVISED AS PER LATEST EIL DRAWING. REVISION MARKED AS 		
REV 01	DATE 29.04.19	ALTERED APPROVED	M.P.K TRINADH
ZONE	DRAWING REVISED AS PER MAIL FROM EIL DT: 24.04.19 REVISION MARKED AS 		

	17	PAD PLATE T=6mm OD200/ID93	2-80-655-15990		-	C	4	636
					ASTM A 387 GR.11 CL2			1
GKBDR22Z01102ZZZZ	16	GASKET B16.21/ANSI B16.5 FF 150CLASS, 2MM KLINGER	2-80-655-15990		---		0	065
					--			2
	15	STUD 5/8" UNC L=168	2-80-655-15990		-----		0	333
					A193 GR.B7			8
	14	NUT 5/8" UNC	2-80-655-15990		-----		0	033
					A194 GR.2H			180
	13	STUD 5/8" UNC L=113	2-80-655-15990		-----		0	224
					A193 GR.B7			80
PI24917Z01118ZZZZ	12	BRANCH PIPE OD88.9X5.49 L=260	2-80-655-15990		---	C	2	935
					ASTM A335P11			1
WK638D3Z004ZZZZZZ	11	B16.11 SW HALF COUPLING 1/2" CL 6000	4-80-655-83170		---	C	0	210
					A-182 Gr.F11 CL2			1
GKFRDR22Z02202ZZZZ	10	GASKET CL150 7MM THK 20MM WIDTH EXPANDED PTFE	2-80-655-15990		---	C	0	065
					--			2
FWC3721Z01118ZZZZ	09	ASME B16.5 FLANGE WN FF CL150 125AARH 3"	3-80-655-83153		---	C	5	220
					ASTM A 182GR F11 CL2			2
FNFC621Z022ZZZZZZ	08	FLANGE SO FF CL150 20"	2-80-655-16024		---	C	27	146
				03	ASTM A 387 GR.11 CL2			4
WGBMX41Z0225403ZZ	07	45DEG MITRE BEND OD508x6 R=760	3-80-655-35532		---	C	44	954
					ASTM A 387 GR.11 CL2			2
WDBMX41Z0225404ZZ	06	90DEG MITRE BEND OD508x6 R=760	2-80-655-16084		-	C	90	576
				02	ASTM A 387 GR.11 CL2			1
PI8Y513Z02254ZZZZ	05	P.F PIPE OD508x6 L=1301 	3-80-655-35553		-	C	96	633
				08	ASTM A 387 GR.11 CL2			1
PI8Y513Z02254ZZZZ	04	P.F PIPE OD508x6 L=4224 	3-80-655-35553		-	C	313	741
				07	ASTM A 387 GR.11 CL2			1
PI8Y513Z02254ZZZZ	03	P.F PIPE OD508x6 L=340	3-80-655-35553		-	C	25	220
				06	ASTM A 387 GR.11 CL2			1
PI8Y513Z02254ZZZZ	02	P.F PIPE OD508x6 L=1775 	3-80-655-35553		-	C	131	840
				05	ASTM A 387 GR.11 CL2			1
PI8Y513Z02254ZZZZ	01	P.F PIPE OD508x6 L=580 	3-80-655-35553		-	C	43	080
				04	ASTM A 387 GR.11 CL2			1
ITEM CODE	ITEM NO.	DESCRIPTION	DRAWING NO.	ITEM NO. VAR	MATERIAL CODE	A	UNIT WT.	
					MATERIAL SPEC.	C	QTY.	

CUSTOMER		INDIAN OIL CORPORATION LIMITED (HALDIA)					BHEL	
CONSULTANT		ENGINEERS INDIA LIMITED (EIL) NEW DELHI					CUSTOMER NO: 7419	
NAME OF PROJECT		BS-VI, HALDIA						
		BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, CHENNAI 600 017		DRN	NAME M.P.K	SIGN -sd-	DATE 15.03.19	NO OF ITEMS
				CHD	TRINADHA RAO	-sd-	15.03.19	
				APPD	SESHAGIRI	-sd-	15.03.19	
DEPT.	GRADE OF UN TOL. DIM		SCALE	WEIGHT (Kg).				ITEM No.
CODE	C/M/F							
TITLE EIL DRAWING NO:				CARD CODE	DRAWING No.			REV
20-AH-205-4502-K34D-IH-E (SHEET 2 OF 2)				U 01	2-80-655-15990			02