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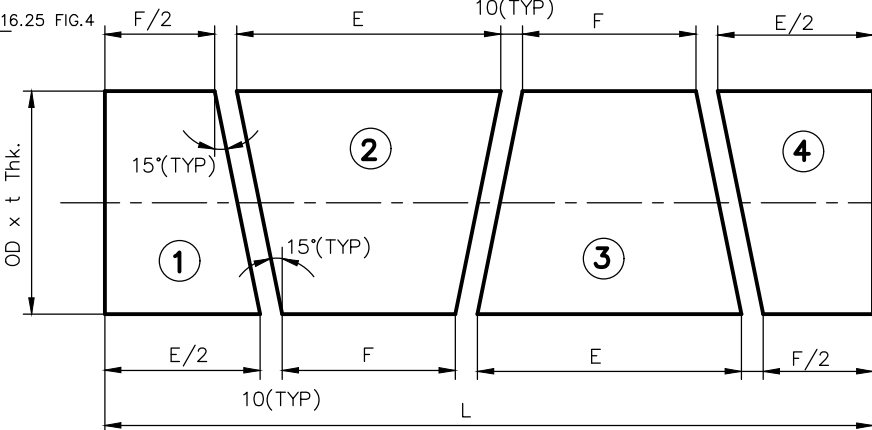
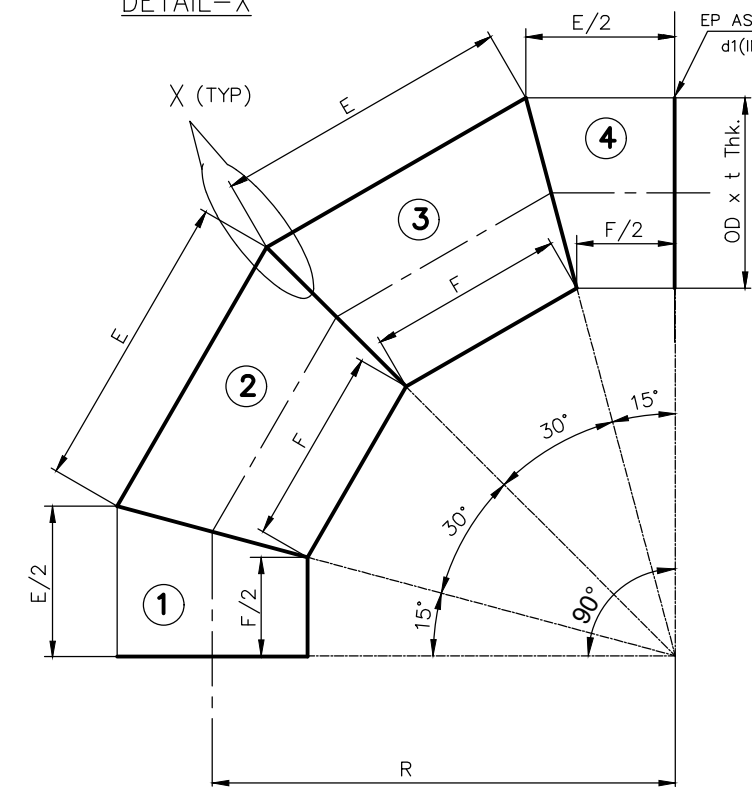
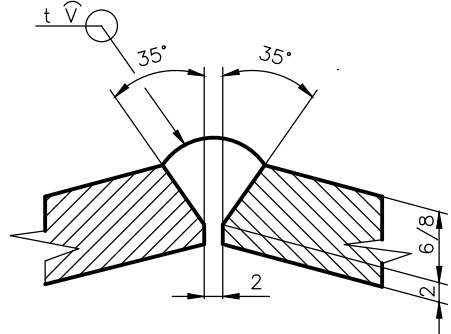
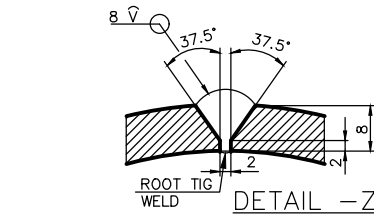
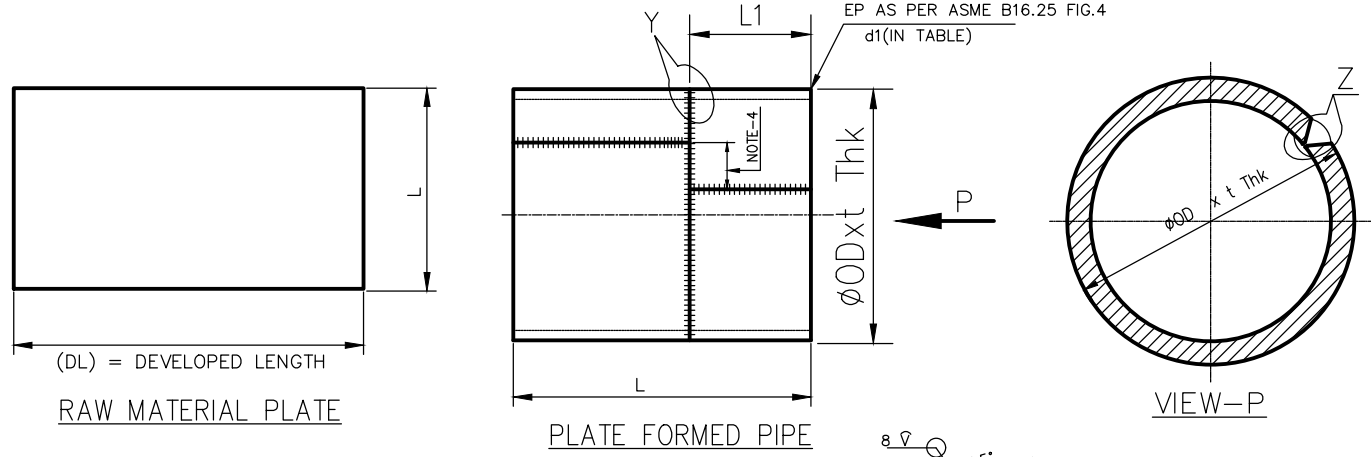
60091-559-08-2

DRAWING No.

VAR. NO	ODXT (MM)	BEND RADIUS (MM)	E (MM)	F (MM)	L (MM)	DL (MM)	d1 (MM)
01	457X6	690	492	247	1139	1415	445
02	508X6	760	543	271	1251	1575	496
03	610X6	910	651	324	1493	1896	598
04	711X6	1070	764	383	1751	2213	699
05	813X8	1220	872	436	1992	2527	797
06	914X8	1370	979	489	2232	2844	898
07	1020X8	1520	1088	541	2474	3177	1004
08	1120X8	1680	1200	600	2730	3491	1104
09	1220X8	1830	1308	654	2973	3806	1204
10	1320X8	1980	1415	707	3213	4120	1304
11	1420X8	2130	1522	761	3455	4434	1404
12	1520X8	2290	1634	820	3711	4748	1504
13	1620X8	2440	1742	874	3954	5062	1604
14	1720X8	2590	1849	927	4194	5376	1704
15	1820X8	2740	1956	981	4436	5691	1804
16	1920X8	2900	2069	1040	4694	6005	1904
17	2020X8	3050	2176	1093	4934	6319	2004
18	2120X8	3200	2283	1147	5175	6633	2104
19	559X6	840	600	300	1350	1738	547

NOTES:-

- 1 WELDED PORTIONS SHALL HAVE A UNIFORMLY SMOOTH SURFACE FINISH WITHOUT BURRS, WELD SPATTER, CRACKS ETC.
- 2 FULL PENETRATION OF WELDS TO BE ENSURED.
- 3 IF SINGLE PLATE OF GIVEN SIZE IS NOT AVAILABLE, THEN TWO PLATES (MAXIMUM) CAN BE JOINED AND ROLLED AS SHOWN.
- 4 SUITABLE STAGGERING OF LONGITUDINAL WELD JOINTS IS TO BE DONE, IF PIPE LENGTH (L) HAS TO BE BUILT UP.
- 5 FOR PIPE LENGTH (L) LESS THAN 2500mm, NO CIRCUMFERENTIAL JOINT IS PERMITTED.
- 6 WELD JOINTS ARE TO BE RADIOGRAPHED AS PER APPLICABLE QCP.
- 7 FOR SHOP PAINTING/COATING REFER APPROVED PAINTING SCHEDULE & Q.P.
- 8 MINIMUM LENGTH OF L1 IS 1500mm.



NOTE:

- 1 PIPE LENGTH INDICATED WITH CUTTING ALLOWANCE TO BE CUT AS PER THE CUTTING PLAN
- 2 WELDED PORTIONS SHALL HAVE A UNIFORMLY SMOOTH TOOL FINISH WITHOUT BURRS, WELD SPATTER, CRACKS ETC.
- 3 FULL PENETRATION OF WELDS TO BE ENSURED

FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)

ALL DIMENSIONS ARE IN MILLIMETRES

559X6	19	PLATE 6 x 1738 x 1350	2-80-655-16010	----- SA516 GR.70	110	510
2120X8	18	PLATE 8 x 5175 x 6633	2-80-655-16010	----- SA516 GR.70	2143	162
2020X8	17	PLATE 8 x 4934 x 6319	2-80-655-16010	----- SA516 GR.70	1946	070
1920X8	16	PLATE 8 x 4694 x 6005	2-80-655-16010	----- SA516 GR.70	1758	859
1820X8	15	PLATE 8 x 4436 x 5691	2-80-655-16010	----- SA516 GR.70	1574	681
1720X8	14	PLATE 8 x 4194 x 5376	2-80-655-16010	----- SA516 GR.70	1405	819
1620X8	13	PLATE 8 x 3954 x 5062	2-80-655-16010	----- SA516 GR.70	1247	414
1520X8	12	PLATE 8 x 3711 x 4748	2-80-655-16010	----- SA516 GR.70	1098	579
1420X8	11	PLATE 8 x 3455 x 4434	2-80-655-16010	----- SA516 GR.70	953	709
1320X8	10	PLATE 8 x 3213 x 4120	2-80-655-16010	----- SA516 GR.70	823	556
1220X8	09	PLATE 8 x 2973 x 3806	2-80-655-16010	----- SA516 GR.70	703	426
1120X8	08	PLATE 8 x 2730 x 3491	2-80-655-16010	----- SA516 GR.70	591	933
1020X8	07	PLATE 8 x 2474 x 3177	2-80-655-16010	----- SA516 GR.70	487	616
914X8	06	PLATE 8 x 2232 x 2844	2-80-655-16010	----- SA516 GR.70	393	284
813X8	05	PLATE 8 x 1992 x 2527	2-80-655-16010	----- SA516 GR.70	311	360
711X6	04	PLATE 6 x 1751 x 2213	2-80-655-16010	----- SA516 GR.70	179	383
610X6	03	PLATE 6 x 1493 x 1896	2-80-655-16010	----- SA516 GR.70	130	648
508X6	02	PLATE 6 x 1251 x 1575	2-80-655-16010	----- SA516 GR.70	90	576
457X6	01	PLATE 6 x 1139 x 1415	2-80-655-16010	----- SA516 GR.70	73	910

OD X T	VAR NO.	DESCRIPTION	DRAWING NO.	ITEM NO. VAR NO.	MATERIAL CODE MATERIAL SPEC.	A C	UNIT WT. QTY.
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CUSTOMER INDIAN OIL CORPORATION LIMITED (HALDIA)

CONSULTANT ENGINEERS INDIA LIMITED (EIL) NEW DELHI

NAME OF PROJECT BS-VI, HALDIA

	BHARAT HEAVY ELECTRICALS LTD.,	DRN	M.P.K	SIGN	DATE	NO OF ITEMS
	PIPING CENTRE,	CHD	TRINADH	--sd--	05.02.19	
	CHENNAI 600 017	APPD	C.SARAVANAN	--sd--	05.02.19	

REV 01	DATE	ALTERED APPROVED	DEPT.	GRADE OF UN TOL. DIM	SCALE	WEIGHT (Kg).	REF TO ASSY / OLD DRG	ITEM No.
ZONE			CODE	C/M/F				
TITLE 90DEG MITRE BEND R=1.5D (CS)						CARD CODE U 01	DRAWING No. 2-80-655-16010	REV 00