

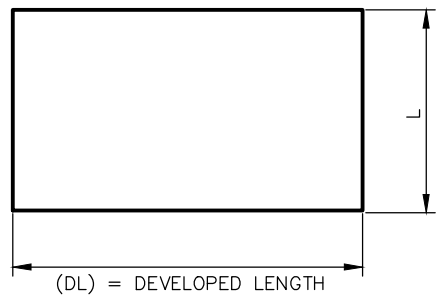
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FIRST ANGLE PROJECTION (ALL DIMENSIONS IN MILLIMETRES)

85091-559-08-2-80-655-16058

DRAWING No.

VAR. NO	ODXT (MM)	BEND RADIUS (MM)	E (MM)	F (MM)	L (MM)	DL (MM)	d1 (MM)
01	457X4	690	492	247	1139	1410	
02	508X4	760	543	271	1251	1570	
03	610X4	910	651	324	1493	1891	
04	711X4	1070	764	383	1751	2208	
05	813X4	1220	872	436	1992	2529	
06	914X4	1370	979	489	2232	2846	
07	1020X4	1520	1088	541	2474	3179	
08	1120X4	1680	1200	600	2730	3493	
09	1220X4	1830	1308	654	2973	3807	
10	1320X4	1980	1415	707	3213	4121	
11	1420X4	2130	1522	761	3455	4435	
12	1520X4	2290	1634	820	3711	4750	
13	1620X4	2440	1742	874	3954	5064	
14	1720X4	2590	1849	927	4194	5378	
15	1820X4	2740	1956	981	4436	5705	1812
16	1920X4	2900	2069	1040	4694	6006	1912
17	2020X4	3050	2176	1093	4934	6320	2012
18	2120X4	3200	2283	1147	5175	6660	2112



RAW MATERIAL PLATE

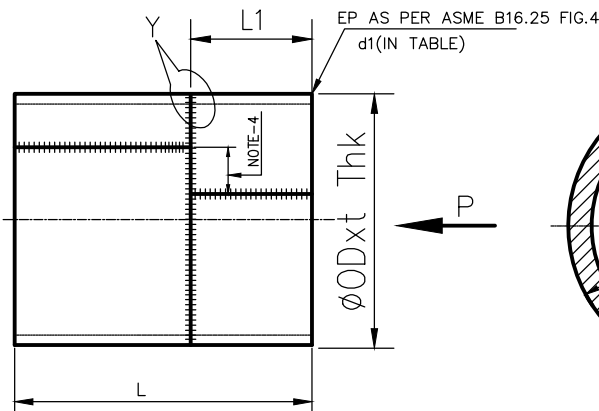
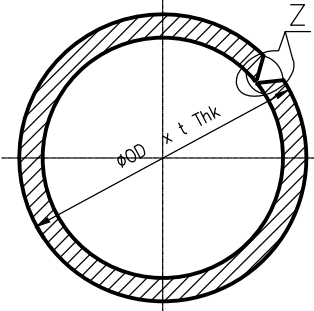
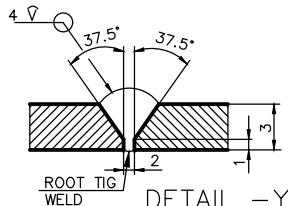


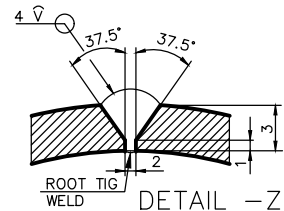
PLATE FORMED PIPE



VIEW-P



DETAIL -Y



DETAIL -Z

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.

ALL DIMENSIONS ARE IN MILLIMETRES

2120X4	18	PLATE 4 x 5175 x 6633	2-80-655-16010	----	ASTMA182Gr.F316L	2143	162
2020X4	17	PLATE 4 x 4934 x 6319	2-80-655-16010	----	ASTMA182Gr.F316L	1946	070
1920X4	16	PLATE 4 x 4694 x 6005	2-80-655-16010	----	ASTMA182Gr.F316L	1758	859
1820X4	15	PLATE 4 x 4436 x 5705	2-80-655-16010	----	ASTMA182Gr.F316L	809	836
1720X4	14	PLATE 4 x 4194 x 5376	2-80-655-16010	----	ASTMA182Gr.F316L	1405	819
1620X4	13	PLATE 4 x 3954 x 5062	2-80-655-16010	----	ASTMA182Gr.F316L	1247	414
1520X4	12	PLATE 4 x 3711 x 4748	2-80-655-16010	----	ASTMA182Gr.F316L	1098	579
1420X4	11	PLATE 4 x 3455 x 4434	2-80-655-16010	----	ASTMA182Gr.F316L	953	709
1320X4	10	PLATE 4 x 3213 x 4120	2-80-655-16010	----	ASTMA182Gr.F316L	823	556
1220X4	09	PLATE 4 x 2973 x 3806	2-80-655-16010	----	ASTMA182Gr.F316L	703	426
1120X4	08	PLATE 4 x 2730 x 3491	2-80-655-16010	----	ASTMA182Gr.F316L	591	933
1020X4	07	PLATE 4 x 2474 x 3177	2-80-655-16010	----	ASTMA182Gr.F316L	487	616
914X4	06	PLATE 4 x 2232 x 2844	2-80-655-16010	----	ASTMA182Gr.F316L	393	284
813X4	05	PLATE 4 x 1992 x 2527	2-80-655-16010	----	ASTMA182Gr.F316L	311	360
711X4	04	PLATE 4 x 1751 x 2213	2-80-655-16010	----	ASTMA182Gr.F316L	179	383
610X4	03	PLATE 4 x 1493 x 1896	2-80-655-16010	----	ASTMA182Gr.F316L	130	648
508X4	02	PLATE 4 x 1251 x 1575	2-80-655-16010	----	ASTMA182Gr.F316L	90	576
457X4	01	PLATE 4 x 1139 x 1415	2-80-655-16010	----	ASTMA182Gr.F316L	73	910
OD x T	VAR NO.	DESCRIPTION	DRAWING NO.	ITEM NO. VAR NO.	MATERIAL CODE MATERIAL SPEC.	UNIT WT. QTY.	

CUSTOMER INDIAN OIL CORPORATION LIMITED (HALDIA)

CONSULTANT ENGINEERS INDIA LIMITED (EIL)
NEW DELHI

NAME OF PROJECT BS-VI, HALDIA

	BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, CHENNAI 600 017		DRN	NAME M.P.K	SIGN -sd-	DATE 05.02.19	NO OF ITEMS
	CHD	TRINADH	-sd-	05.02.19			
	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 (SS)						CARD CODE U 01	DRAWING No. 2-80-655-16058	REV 00