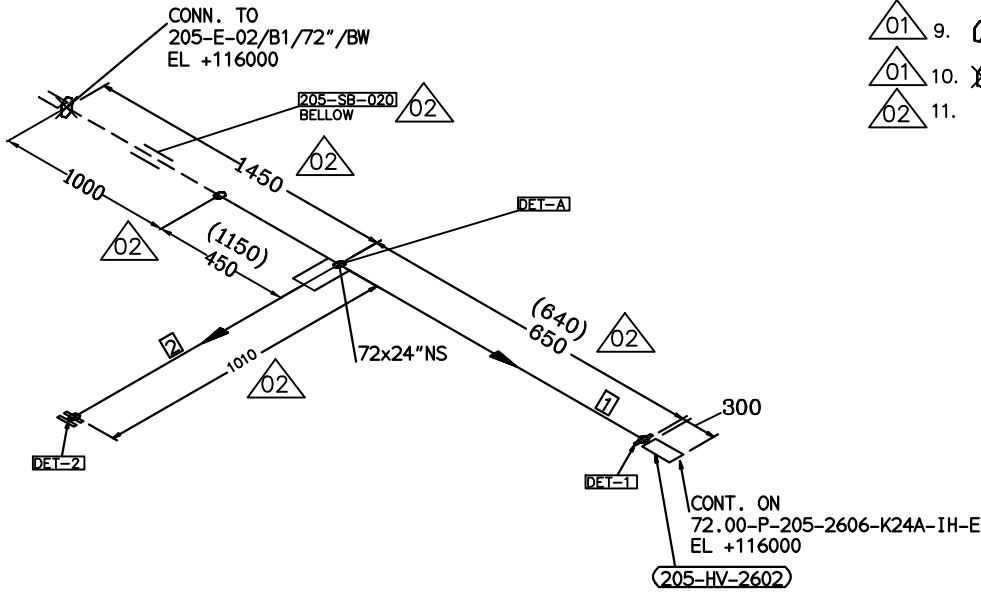


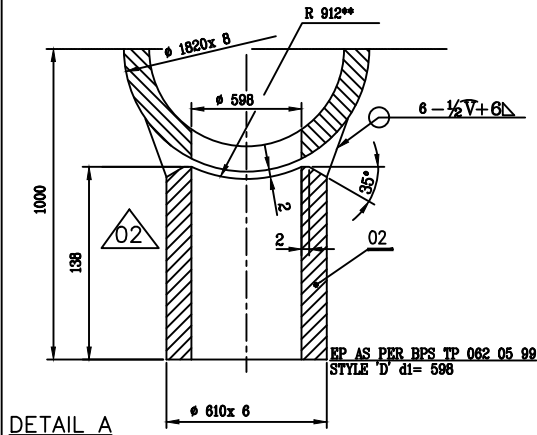
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3-80-655-35371

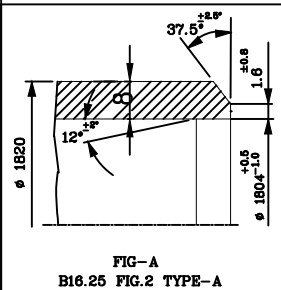
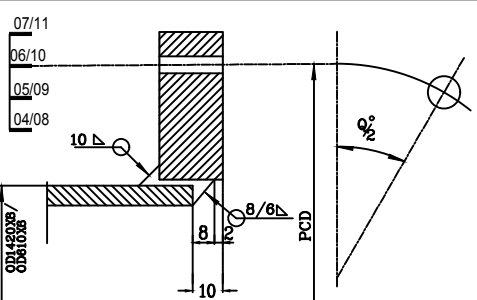
DRAWING NO



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



DETAIL-1/2



8. FOR ELECTRODE DATA REFER

PIPE SIZE	MATERIAL SPEC	EP FIG	WELD SPEC	ELECTRODE DATA	
				ROOT RUN	FILLER RUN
OD1820X8	ASTMA516 GR.70	FIG-A	8 V	ER70S-2/ E6010/E6013	ER70S-2/ E7016/E7018

- 01 9. INDICATES WELD AT SHOP.
- 01 10. INDICATES WELD AT SITE.
- 02 11. HANDLES FOR MANHOLE COVER(BLIND FLANGE) SHALL BE WELDED AT SITE.

NOTES:

- DESIGN PRESSURE - 0.2 KG/CM2 (G) DESIGN TEMPERATURE: 290°C
- FOR STANDARD NOTES OF PRODUCTION AND ERECTION OF PIPES AND TOLERANCE ON FITTINGS REFER DRG NO. 4-80-001-37654 & 4-80-301-26192
- FOLLOW APPLICABLE QP AND PAINTING SCHEDULE FOR THE PROJECT
- ALL UNMARKED BENDS/ELBOWS ARE 90 DEG
- PIPE ENDS SHALL BE BEVELLED AS PER B16.25 FIG.2 TYPE-A
- GASKET IS SUPPLIED VIDE 7419-80-733 PGMA.
- 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.

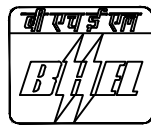
GKFDSC2Z040ZZZZZZ	11	GASKET JOB STD EXPANDED PTFE CORD 150# 7MM THK 24"	3-80-655-35371		----		----	
---	10	NUT 5/8" UNC	3-80-655-35371		----		----	1
---	09	STUD 5/8" UNC L=113	3-80-655-35371		A194 GR.2H		----	0 033 40
	08	FLANGE.SO CL.150 FF/125AARH 24"	2-80-655-16008		A193 GR.B7		----	0 224 20
				4	ASTM A 516 GR.70	C	----	27 781 1
GKFDSC2Z040ZZZZZZ	07	GASKET B16.2 SPIRAL WOUND 150# 72"	3-80-655-35371		----		----	1
---	06	NUT 3/4" UNC	3-80-655-35371		A194 GR.2H	C	----	0 065 120
---	05	STUD 3/4" UNC L=131	3-80-655-35371		A193 GR.B7	C	----	0 336 60
FNF6321Z048ZZZZZZ	04	FLANGE.SO CL.150 FF/125AARH 72"	2-80-655-16008	16	ASTM A 516 GR.70	C	----	80 573 1
FBF6321Z024ZZZZZZ	03	BLIND FLANGE. CL.150 FF/125AARH 24"	2-80-655-16009	4	ASTM A 516 GR.70	C	----	130 648 1
P18Y613Z02454ZZZZ	02	P.F BRANCH PIPE OD610X6 L=138	3-80-655-35531	1	ASTM A 516 GR.70	C	----	12 332 1
P18Y613Z04863ZZZZ	01	P.F PIPE OD1820X8 L=1790	3-80-655-35530	1	ASTM A 516 GR.70	C	----	639 736 1
ITEM CODE	ITEM NO.	DESCRIPTION	DRAWING NO.	ITEM NO.	MATERIAL CODE	A	UNIT WT.	
				VAR NO.	MATERIAL SPEC.	C	QTY.	

CLIENT INDIAN OIL CORPORATION LIMITED (HALDIA)

CONSULTANT ENGINEERS INDIA LIMITED (EIL) NEW DELHI

NAME OF PROJECT BS-VI, HALDIA

BHEL CUSTOMER NO: 7419



BHARAT HEAVY ELECTRICALS LTD.,
PIPING CENTRE,
CHENNAI 600 017

DRN	NAME M.P.K	SIGN -sd-	DATE 14.02.19	NO OF ITEMS
CHD	TRINADH	-sd-	14.02.19	
APPD	SARAVANAN.C	-sd-	14.02.19	

DEPT.	GRADE OF UN TOL. DIM	SCALE	WEIGHT (Kg).	REF TO ASSY / OLD DRG	ITEM No.
CODE	C/M/F				
TITLE	EIL DRAWING NO: 72-P-205-2605-K24A-IH-E			CARD CODE U 01	DRAWING No. 3-80-655-35371
					REV 02

SIZE A3