

CAUTION THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY

87333-559-08-3

DRAWING NO

NOTES CONTD.:

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.

NOTES:

- DESIGN PRESSURE - 0.2 KG/CM2 (G) DESIGN TEMPERATURE: 100°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.
- FOR ELECTRODE DATA REFER

| PIPE SIZE | MATERIAL SPEC  | EP FIG | WELD SPEC | ELECTRODE DATA          |                         |
|-----------|----------------|--------|-----------|-------------------------|-------------------------|
|           |                |        |           | ROOT RUN                | FILLER RUN              |
| OD457x6   | ASTMA516 GR.70 | FIG-A  | 6         | ER70S-2/<br>E6010/E6013 | ER70S-2/<br>E7016/E7018 |

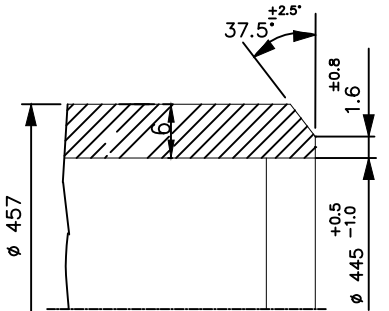
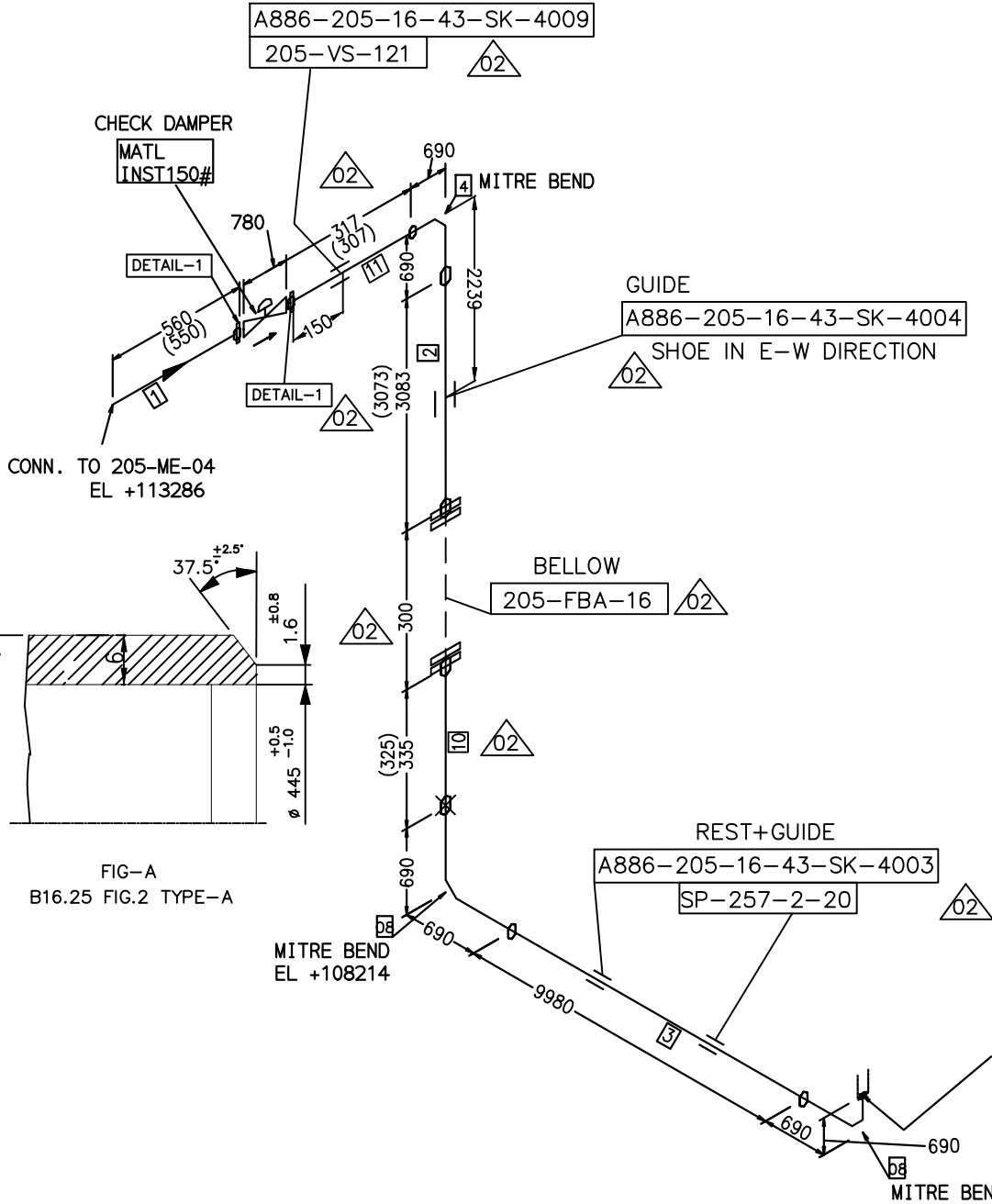
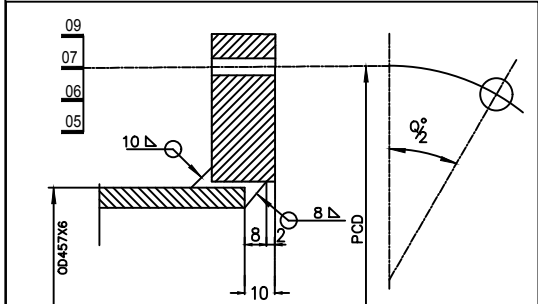


FIG-A  
B16.25 FIG.2 TYPE-A

DETAIL-1



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

|                   |          |                                                      |                |                     |                                 |                  |
|-------------------|----------|------------------------------------------------------|----------------|---------------------|---------------------------------|------------------|
| PI8Y713Z02154ZZZZ | 11       | P.F PIPE OD457X6 L=307                               | 3-80-655-35453 | 11                  | ASTM A 516 GR.70                | 20   486         |
| PI8Y713Z02154ZZZZ | 10       | P.F PIPE OD457X6 L=325                               | 3-80-655-35453 | 10                  | ASTM A 516 GR.70                | 21   687         |
| GKFDSC2Z021ZZZZZZ | 09       | GASKET JOB STD EXPANDED PTFE CORD 150# 7MM THK - 18" | 3-80-655-35378 |                     |                                 | 4                |
| WDMBZ41Z0215404ZZ | 08       | MITRE BEND OD457X6 R=690                             | 2-80-655-16010 | 01                  | ASTM A 516 GR.70                | 2                |
| ---               | 07       | NUT 5/8" UNC                                         | 3-80-655-35378 |                     | A194 GR.2H                      | 128              |
| ---               | 06       | STUD BOLT 5/8" UNC L=113                             | 3-80-655-35378 |                     | A193 GR.B7                      | 64               |
| FNFK521Z021ZZZZZZ | 05       | FLANGE.S0 CL.150 FF/125AARH 18"                      | 2-80-655-16008 | 02                  | ASTM A 516 GR.70                | 22   905         |
| WDMBZ41Z0215404ZZ | 04       | MITRE BEND OD457X6 R=690                             | 2-80-655-16010 | 01                  | ASTM A 516 GR.70                | 73   910         |
| PI8Y713Z02154ZZZZ | 03       | P.F PIPE OD457X6 L=9980                              | 3-80-655-35453 | 09                  | ASTM A 516 GR.70                | 665   132        |
| PI8Y713Z02154ZZZZ | 02       | P.F PIPE OD457X6 L=3073                              | 3-80-655-35453 | 08                  | ASTM A 516 GR.70                | 205   061        |
| PI8Y713Z02154ZZZZ | 01       | P.F PIPE OD457X6 L=550                               | 3-80-655-35453 | 07                  | ASTM A 516 GR.70                | 36   655         |
| ITEM CODE         | ITEM NO. | DESCRIPTION                                          | DRAWING NO.    | ITEM NO.<br>VAR NO. | MATERIAL CODE<br>MATERIAL SPEC. | UNIT WT.<br>QTY. |

CLIENT 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        | SIGN | DATE     | NO OF |
|------|-------------|------|----------|-------|
| CHD  | TRADEEP     | -sd- | 14.03.19 | ITEMS |
| APPD | TRINADH     | -sd- | 14.03.19 |       |
|      | SARAVANAN C | -sd- | 14.03.19 |       |

| DEPT.                    | GRADE OF UN TOL. DIM | SCALE | WEIGHT (Kg). | REF TO ASSY / OLD DRG | ITEM No. |
|--------------------------|----------------------|-------|--------------|-----------------------|----------|
| CODE                     | C/M/F                |       |              |                       |          |
| TITLE                    |                      |       | CARD CODE    | DRAWING No.           | REV      |
| 18-AH-205-4501-K22A-IH-E |                      |       | U 01         | 3-80-655-35378        | 02       |

SIZE A3