

1-35-190-07443

FOR TOLERANCES OF UNTOLERANCED
DIMENSIONS DURING MANUFACTURE
REFER PLANT STD. NO TP 023 0299

SIZE AND TYPE OF WELD	TYPE OF ELECTRODE	TOTAL LENGTH OF WELDING
12	E 7018	1.50
25	E 7018	10.25

REQUIREMENT OF FASTENERS



DESCRIPTION	MATL.CODE	QTY	RELEASED UNDER PGMA
HSFG BOLT WITH NUT M24X160	41240-24160	16	35-700
HSFG BOLT WITH NUT M24X90	41240-24090	8	35-700
WASHER HSS A24	41418-00024	48	35-700

NOTES

- FOR GIRDER DETAILS REFER GIRDER DRG IN PG 35-212.
- REMOVE THIS WELD AFTER THE GIRDER HAS BEEN ERECTED AND BOLTED IN PLACE.
- LUBRICATED PIN SEATS BEFORE INSTALLATION (USE ONLY MOLYBDINUM DI-SULPHIDE GREASE - TO BE PROCURED BY ERECTOR.
- THREADED ROD (ITEM NO:02) MUST BE INSTALLED FOR RESISTANCE TO OVER TURNING DUE TO WIND DURING ERECTION.
- MATERIALS AND OTHER REQUIREMENTS ARE GIVEN FOR ONE ASSY.ONLY
- Ø26 HOLES TO BE DRILLED IN ITEM 03 & 05.
- ITEM 06 TO BE MANUFACTURED AND FINISHED TO A:193 - B7. CHARACTERISTICS.
- ITEMS 01,02,04 & 06 NEED NOT BE PAINTED.
- PAINTING AREA - 5 SQ.M.
- ITEMS 01,02,04 & 06 HAVE TO BE PROTECTED AGAINST RUST WITH AN APPLICATION OF A THIN FILM OF RUST PREVENTIVE OIL. THE THIN FILM OF OIL TO BE THOROUGHLY WIPED OFF AT SITE BEFORE ERECTION.
- MANUFACTURING REQUIREMENTS SHALL BE AS PER RELEVANT Q.C.P.
- THIS PORTION OF ROD IS TO BE CUT & REMOVED AFTER COMPLETE INSTALLATION OF CEILING STRUCTURE INCLUDING HORIZONTAL BRACING.

VARIANT NUMBER	ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER	ITEM NO VAR NO	MATERIAL CODE MATERIAL SPECN	A/C/P DI	UNIT QUANTITY	GS	ZONE
	09	WASHER PNCHD.A24				4140800024	No	0.093		
						4130400024	No	0.330		
	08	NUT HEX.Gr.C M24				15-011-081	No	7.065		
	07	PL 200X180X25				IS2062Fe410B		2		
	06	ROD Ø 100; 1102				15-039-358	No	67.942		
						SA193-B7		1		
	05	PL 700X100X25				15-011-081	No	13.738		
						IS2062Fe410B		4		
	04	PL 1000X300X125				15-911-787	No	294.373		
						ASTM-A36		1		
	03	PL 700X100X25				15-011-081	No	13.738		
						IS2062Fe410B		2		
	02	ROD Ø 25; 550				15-339-139	No	2.121		
						SA-105		8		
	01	PL1000X1000X150				15-911-723	No	1216.800		
						ASTM-A36		1		

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TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		DRN		NAME	SIGNATURE	DATE
 Bharat Heavy Electricals Ltd UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI - 620014		CHD	H. A. JAFFAR			07.11.09
		APPD	M. PENCHAL			09.11.09
		REF TO ASSY / OLD DWG				
DEPT ST-053	ALL DIMENSIONS ARE IN MM	PROJECTION 	SCALE N.T.S	WEIGHT (Kg) 1851.893		
CODE 122	TITLE GIRDER PIN CONNECTION FOR GIRDER-2 (COL S8L&R)				DRAWING NO : 1-35-190-07443	
					REV 01	