

ERECTION WELDING SCHEDULE																				
SL. NO		DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT TEMP. in °C	NDT METHOD/ QUANTUM	* REF.-		REV	
									GTAW	SMAW	Qty in Nos.						SPEC. NO	ACC NORM REF.		
											Qty in gms	Ø2.5								Ø3.15
PG NO : 07																				
PG NAME : Circulation System																				
SYSTEM DESCRIPTION : Circulation System																				
CUST DOC NO : 9591-102-102-QVM-V-001 CUST DOC REV : 00																				
WELDING CODE : I.B.R / ASME																				
PRESSURE PARTS/NO-NPRESSURE PARTS																				
1	0-00-027-34643	F-01 NIPPLE + F-02TI	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∅	ER80S-B2	280	2035	2419	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift				
2	0-00-027-34685	F-07 NIPPLE + F-08TI	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∅	ER80S-B2	280	2035	2419	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift				
3	0-00-027-34643	F-02TI + F-02L	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	ER80S-B2	280	2115	3992	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift				
4	0-00-027-34685	CORNER-LEFT + F-02L	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	ER80S-B2	142	1073	2025	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift				
5	0-00-027-34685	F-02L-Bend + F-02L	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	ER80S-B2	349	2636	4975	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift				
6	0-00-027-34685	F-02L + CORNER-RIGHT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	ER80S-B2	280	2115	3992	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift				
7	0-00-027-34685	F-02L + BURNER - RIGHT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	ER80S-B2	142	1073	2025	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift				
8	0-00-027-34685	F-08TI + F-08L	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	ER80S-B2	280	2115	3992	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift				
9	0-00-027-34685	CORNER-RIGHT + F-08L	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	ER80S-B2	142	1073	2025	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift				
10	0-00-027-34685	F-08L-Bend + F-08L	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	ER80S-B2	349	2636	4975	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift				
PREPARED									CHECKED (W.T.C)				DATE		DOC NO.		REV NO :		PAGE NO.	
RUDRABHATLA SAIKUMAR									LAKAVATH PRAVEEN KUMAR				09-07-2018		1819-07-CIR-EWS		0		1/11	
CAUTION :		THE INFMN ON THIS DOCUMENT IS THE PROPERTY OF BHEL. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO INTEREST OF BHEL.																		
		* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98 NOTE: ALSO REFER QUALITY GUIDELINE NO. SIP:PP:29/REV.02																		

		ERECTION WELDING SCHEDULE																	
		PG NO : 07																	
		CUST No.:																	
		PROJECT :																	
		WELDING CODE : I.B.R / ASME		PRESSURE PARTS/NON-PRESSURE PARTS															
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT TEMP. in °C	NDT METHOD/ QUANTUM	* REF.-.		REMARKS	REV
				SIZE	THICK			GTAW	Qty in Nos.	Qty in gms	SMAW					Qty in Nos.	Ø2.5		
11	0-00-027-34685	F-08L + CORNER-LEFT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	280	2115	E8018-B2	3992	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift			
12	0-00-027-34685	F-08L +BURNER -LEFT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	142	1073	E8018-B2	2025	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift			
13	0-00-027-34684	F-17L-L + CORNER-FRONT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	142	1073	E8018-B2	2025	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift			
14	0-00-027-34684	F-17L-L+ CORNER-REAR	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	280	2115	E8018-B2	3992	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift			
15	0-00-027-34684	F-17L-L+ BURNER -LEFT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	142	1073	E8018-B2	2025	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift			
16	0-00-027-34683	F-17L-R + CORNER-FRONT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	280	2115	E8018-B2	3992	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift			
17	0-00-027-34683	F-17L-R + CORNER-REAR	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	142	1073	E8018-B2	2025	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift			
18	0-00-027-34683	F-17L-R + BURNER -RIGHT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	142	1073	E8018-B2	2025	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift			
19	0-00-027-34681	F-02U + BURNER-RIGHT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	358	2704	E8018-B2	5104	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift			
20	0-00-027-34681	F-02U + CORNER SOFA	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	154	1163	E8018-B2	2196	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift			
PREPARED		CHECKED (W.T.C)		APPROVED		DATE		DOC NO.		REV NO :		PAGE NO.							
RUDRABHATLA SAIKUMAR		LAKAVATH PRAVEEN KUMAR		ANAND KUMAR S		09-07-2018		1819-07-CIR-EWS		0		2/11							
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		* REFER NDE MANUAL No.P5:CMX:002 REV.No.01/12-98 NOTE: ALSO REFER QUALITY GUIDELINE NO. SIP:PP-29/REV.02																	

		ERECTION WELDING SCHEDULE																			
		PG NO : 07																			
		PG NAME : Circulation System																			
		SYSTEM DESCRIPTION : Circulation System																			
		CUST DOC NO : 9591-102-102-QVM-V-001 CUST DOC REV : 00																			
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC					WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT		NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV
								SIZE	THICK	GTAW	SMAW										
												Ø2.5			Ø3.15	Ø4.0					
21	0-00-027-34681	F-02U + CORNER-RIGHT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2		E8018-B2	126	952	1797	150		Nil	20% RT subject to min 2 weld/welder/shift				
22	0-00-027-34681	F-02U + BURNER-LEFT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2		E8018-B2	368	2779	5246	150		Nil	20% RT subject to min 2 weld/welder/shift				
23	0-00-027-34681	F-02U + CORNER SOFA-LEFT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2		E8018-B2	164	1239	2338	150		Nil	20% RT subject to min 2 weld/welder/shift				
24	0-00-027-34681	F-02U + CORNER LEFT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2		E8018-B2	106	801	1511	150		Nil	20% RT subject to min 2 weld/welder/shift				
25	0-00-027-34681	F-02U + TRANSITION	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2		E8018-B2	124	937	1768	150		Nil	20% RT subject to min 2 weld/welder/shift				
26	0-00-027-34681	F-02U + WALL SOFA	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2		E8018-B2	92	695	1312	150		Nil	20% RT subject to min 2 weld/welder/shift				
27	0-00-027-34681	WALL SOFA + F-02U	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2		E8018-B2	92	695	1312	150		Nil	20% RT subject to min 2 weld/welder/shift				
28	0-00-027-34679	F-17U + BURNER-REAR	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2		E8018-B2	368	2779	5246	150		Nil	20% RT subject to min 2 weld/welder/shift				
29	0-00-027-34679	F-17U + CORNER SOFA REAR	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2		E8018-B2	154	1163	2196	150		Nil	20% RT subject to min 2 weld/welder/shift				
30	0-00-027-34679	F-17U + CORNER REAR	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2		E8018-B2	106	801	1511	150		Nil	20% RT subject to min 2 weld/welder/shift				
PREPARED		CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.					
RUDRABHATLA SAIKUMAR		LAKAVATH PRAVEEN KUMAR				ANAND KUMAR S				09-07-2018		1819-07-CIR-EWS		0		3/11					
CAUTION :		* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98 NOTE: ALSO REFER QUALITY GUIDELINE NO. SIP:PP:29/REV.02																			

ERECTION WELDING SCHEDULE																			PG NO : 07	
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT TEMP. in °C	NDT METHOD/ QUANTUM	* REF.-.		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW		SPEC. NO					ACC NORM REF.				
									Qty in Nos.	Qty in gms							Qty in Nos.			
																				Ø2.5
31	0-00-027-34679	F-17U + BURNER-FRONT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2	2704	5104	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift					
32	0-00-027-34679	F-17U + CORNER SOFA-FRONT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2	1239	2338	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift					
33	0-00-027-34679	F-17U + CORNER-FRONT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2	786	1483	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift					
34	0-00-027-34679	F-17U + TRANSITION	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2	892	1682	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift					
35	0-00-027-34679	F-17U + WALL SOFA	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2	695	1312	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift					
36	0-00-027-34679	WALL SOFA + F-17U	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2	695	1312	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift					
37	0-00-027-34682	F-08U + BURNER-RIGHT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2	2704	5104	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift					
38	0-00-027-34682	F-08U + CORNER SOFA-RIGHT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2	1163	2196	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift					
39	0-00-027-34682	F-08U + CORNER-RIGHT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2	952	1797	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift					
40	0-00-027-34682	F-08U + BURNER-LEFT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ⚡	ER80S-B2	2779	5246	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift					
PREPARED			RUDRABHATLA SAIKUMAR		CHECKED (W.T.C)		LAKAVATH PRAVEEN KUMAR		APPROVED		DATE		DOC NO.		REV NO :		PAGE NO.			
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* REFER NDE MANUAL No P5:CMX:002 REV No 01/12-98 NOTE: ALSO REFER QUALITY GUIDELINE NO. SIP:PP:29/REV.02																				

ERECTION WELDING SCHEDULE																			PG NO : 07								
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				MIN. PRE HEAT TEMP. in °C	PWHT TEMP. in °C	NDT METHOD/ QUANTUM	* REF.-.		REMARKS	REV									
				SIZE	THICK			GTAW	SMAW	Qty in Nos.	WPS NO/REV NO.				SPEC. NO	ACC NORM REF.											
																			GTAW	SMAW	Qty in Nos.	Ø2.5	Ø3.15	Ø4.0			
																									Qty in Nos.	Qty in gms	
WELDING CODE : I.B.R / ASME								PRESSURE PARTS/NON-PRESSURE PARTS																			
CUST No. :		PG NAME : Circulation System																									
PROJECT :		SYSTEM DESCRIPTION : Circulation System																									
WELDING CODE : I.B.R / ASME		CUST DOC NO : 9591-102-102-QVM-V-001 CUST DOC REV : 00																									
41	0-00-027-34682	F-08U + CORNER SOFA-LEFT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∇	164	1239	2338	-	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift											
42	0-00-027-34682	F-08U + CORNER LEFT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∇	106	801	1511	-	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift											
43	0-00-027-34682	F-08U + TRANSITION	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∇	124	937	1768	-	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift											
44	0-00-027-34682	F-08U + WALL SOFA	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∇	92	695	1312	-	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift											
45	0-00-027-34682	WALL SOFA + F-08U	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∇	92	695	1312	-	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift											
46	0-00-027-34678	F-17L/U + BURNER FRONT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∇	368	2779	5246	-	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift											
47	0-00-027-34678	F-17U + CORNER SOFA FRONT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∇	154	1163	2196	-	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift											
48	0-00-027-34678	F-17U + CORNER FRONT	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∇	106	801	1511	-	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift											
49	0-00-027-34678	F-17U + BURNER REAR	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∇	358	2704	5104	-	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift											
50	0-00-027-34678	F-17U + CORNER SOFA REAR	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∇	164	1239	2338	-	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift											
PREPARED				RUDRABHATLA SAIKUMAR				CHECKED (W.T.C)				LAKAVATH PRAVEEN KUMAR				APPROVED		ANAND KUMAR S		DATE		DOC NO.		REV NO :		PAGE NO.	
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				SIZE	THICK			GTAW	Qty in Nos.	Qty in gms	SMAW					Qty in Nos.	Ø2.5			Ø3.15	Ø4.0	SPEC. NO	ACC NORM REF.
51	0-00-027-34678	F-17U + CORNER REAR	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	104	786	-	1483	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift							
52	0-00-027-34678	F-17U + TRANSITION	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	118	892	-	1682	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift							
53	0-00-027-34678	F-17U + WALL SOFA	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	92	695	-	1312	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift							
54	0-00-027-34678	WALL SOFA + F-17U	SA213T12 + SA213T12	42.4	8.8	GTAW + SMAW	8.8 ∅	92	695	-	1312	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift							
55	0-00-027-34663	F-02TO + F-02X SPOOL	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∅	140	1018	-	1210	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift							
56	0-00-027-34663	F-02TO + F-03 NIPPLE	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∅	140	1018	-	1210	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift							
57	0-00-027-34663	F-08TO + F-08X SPOOL	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∅	140	1018	-	1210	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift							
58	0-00-027-34663	F-08TO + F-09 NIPPLE	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∅	140	1018	-	1210	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift							
59	0-00-027-34662	F-17TO-L + F-17X SPOOL	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∅	140	1018	-	1210	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift							
60	0-00-027-34662	F-17TO-L + F-18 NIPPLE	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∅	140	1018	-	1210	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift							
RUDRBHATLA SAIKUMAR		LAKAVATH PRAVEEN KUMAR				ANAND KUMAR S				DATE				DOC NO.				REV NO :				PAGE NO.	
1819-07-CIR-EWS		09-07-2018				0				1819-07-CIR-EWS				6/11									
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		* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98 NOTE: ALSO REFER QUALITY GUIDELINE NO. SIP:PP:29/REV.02																					

 ERECTION WELDING SCHEDULE		PG NO : 07																	
		PG NAME : Circulation System																	
		SYSTEM DESCRIPTION : Circulation System																	
		CUST DOC NO : 9591-102-102-QVM-V-001 CUST DOC REV : 00																	
		WELDING CODE : I.B.R / ASME																	
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT TEMP. in °C	NDT METHOD/ QUANTUM	* REF.-.		REMARKS	REV
				SIZE	THICK			GTAW	Qty in Nos.	Qty in Nos.	SMAW					Qty in Nos.	ACC		
61	0-00-027-34662	F-17TO-R + F-17X SPOOL	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∅	ER80S-B2	1210	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift					
62	0-00-027-34662	F-17TO-R + F-18 NIPPLE	SA213T12 + SA213T12	38.1	7.11	GTAW + SMAW	7.11 ∅	ER80S-B2	1210	-	1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift					
63	0-00-027-34677	F-04TI + F-02X SPOOL	SA213T22 + SA213T22	33.4	5.59	GTAW + SMAW	5.59 ∅	ER90S-B3	2070	-	1084/00	200	740 ± 10	20% RT subject to min 2 weld/welder/shift				100% HC, 260HB (MAX)	
64	0-00-027-34677	F-04TI + F-03 NIPPLE	SA213T22 + SA213T22	33.4	5.59	GTAW + SMAW	5.59 ∅	ER90S-B3	2070	-	1084/00	200	740 ± 10	20% RT subject to min 2 weld/welder/shift				100% HC, 260HB (MAX)	
65	0-00-027-34677	F-10TI + F-08X SPOOL	SA213T22 + SA213T22	33.4	5.59	GTAW + SMAW	5.59 ∅	ER90S-B3	2070	-	1084/00	200	740 ± 10	20% RT subject to min 2 weld/welder/shift				100% HC, 260HB (MAX)	
66	0-00-027-34677	F-10TI + F-09 NIPPLE	SA213T22 + SA213T22	33.4	5.59	GTAW + SMAW	5.59 ∅	ER90S-B3	2070	-	1084/00	200	740 ± 10	20% RT subject to min 2 weld/welder/shift				100% HC, 260HB (MAX)	
67	0-00-027-34677	F-19TI-L + F-17X SPOOL	SA213T22 + SA213T22	33.4	5.59	GTAW + SMAW	5.59 ∅	ER90S-B3	2070	-	1084/00	200	740 ± 10	20% RT subject to min 2 weld/welder/shift				100% HC, 260HB (MAX)	
68	0-00-027-34677	F-19TI-L + F-18 NIPPLE	SA213T22 + SA213T22	33.4	5.59	GTAW + SMAW	5.59 ∅	ER90S-B3	2070	-	1084/00	200	740 ± 10	20% RT subject to min 2 weld/welder/shift				100% HC, 260HB (MAX)	
69	0-00-027-34677	F-19TI-R + F-17X SPOOL	SA213T22 + SA213T22	33.4	5.59	GTAW + SMAW	5.59 ∅	ER90S-B3	2070	-	1084/00	200	740 ± 10	20% RT subject to min 2 weld/welder/shift				100% HC, 260HB (MAX)	
70	0-00-027-34677	F-19TI-R + F-18 NIPPLE	SA213T22 + SA213T22	33.4	5.59	GTAW + SMAW	5.59 ∅	ER90S-B3	2070	-	1084/00	200	740 ± 10	20% RT subject to min 2 weld/welder/shift				100% HC, 260HB (MAX)	
RUDRABHATLA SAIKUMAR				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
PREPARED				LAKAVATH PRAVEEN KUMAR				ANAND KUMAR S				09-07-2018		1819-07-CIR-EWS		0		7/11	
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		* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98 NOTE: ALSO REFER QUALITY GUIDELINE NO. SIP:PP:29/REV.02																	

ERECTION WELDING SCHEDULE																				PG NO : 07			
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	CUST No. : PROJECT :	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC						WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT		NDT METHOD/ QUANTUM	* REF.-.		REMARKS	REV
					SIZE	THICK			GTAW	SMAW			TIME in mins	SPEC. NO			ACC NORM REF.						
										Qty in Nos.	Qty in gms	Qty in Nos.						Ø2.5		Ø3.15	Ø4.0		
PRESSURE PARTS/ NON-PRESSURE PARTS																				CUST DOC NO : 9591-102-102-QVM-V-001		CUST DOC REV : 00	
WELDING CODE : I.B.R / ASME																				PG NAME : Circulation System			
SYSTEM DESCRIPTION : Circulation System																							
71	0-00-027-34677		F-02X + F-04L	SA213T22 + SA213T22	38.1	8.13	GTAW + SMAW	8.13 ♂	420	2786	4642	-	-	1084/00	200	740 ± 10 60	20% RT subject to min 2 weld/welder/shift					100% HC, 260HB (MAX)	
72	0-00-027-34677		F-04L + F-04U	SA213T22 + SA213T22	38.1	8.13	GTAW + SMAW	8.13 ♂	420	2786	4642	-	-	1084/00	200	740 ± 10 60	20% RT subject to min 2 weld/welder/shift					100% HC, 260HB (MAX)	
73	0-00-027-34651		F-04U + F-05 NIPPLE	SA213T23 + SA213T22	38.1	11	GTAW + SMAW	11 ♂	420	2036	8200	-	-	1053/04	200	745 ± 15 60	20% RT subject to min 2 weld/welder/shift					100% HC, 260HB (MAX)	
74	0-00-027-34677		F-08X + F-11	SA213T22 + SA213T22	38.1	8.13	GTAW + SMAW	8.13 ♂	420	2786	4642	-	-	1084/00	200	740 ± 10 60	20% RT subject to min 2 weld/welder/shift					100% HC, 260HB (MAX)	
75	0-00-027-34677		F-11 + F-12	SA213T22 + SA213T23	38.1	8.13	GTAW + SMAW	8.13 ♂	280	1857	3095	-	-	1053/04	200	745 ± 15 60	20% RT subject to min 2 weld/welder/shift					100% HC, 260HB (MAX)	
76	0-00-027-34677		F-11 + F-13	SA213T22 + SA213T22	38.1	8.13	GTAW + SMAW	8.13 ♂	140	929	1548	-	-	1084/00	200	740 ± 10 60	20% RT subject to min 2 weld/welder/shift					100% HC, 260HB (MAX)	
77	0-00-027-34677		F-12 + F-14 NIPPLE	SA213T23 + SA213T23	38.1	8.13	GTAW + SMAW	8.13 ♂	280	1857	5158	-	-	1052/06	200	745 ± 15 60	20% RT subject to min 2 weld/welder/shift					100% HC, 260HB (MAX)	
78	0-00-027-34638		F-13 + F14 NIPPLE	SA213T23 + SA213T23	63.5	12.7	GTAW + SMAW	12.7 ♂	140	1636	2180	1563	-	1052/06	200	745 ± 15 60	20% RT subject to min 2 weld/welder/shift					100% HC, 260HB (MAX)	
79	0-00-027-34677		F-17X + F-19L-L	SA213T22 + SA213T22	38.1	9.5	GTAW + SMAW	9.5 ♂	420	2428	6211	-	-	1084/00	200	740 ± 10 60	20% RT subject to min 2 weld/welder/shift					100% HC, 260HB (MAX)	
80	0-00-027-34677		F-17X + F-19L-R	SA213T22 + SA213T22	38.1	9.5	GTAW + SMAW	9.5 ♂	420	2428	6211	-	-	1084/00	200	740 ± 10 60	20% RT subject to min 2 weld/welder/shift					100% HC, 260HB (MAX)	
PREPARED				CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.					
RUDRABHATLA SAIKUMAR				LAKAVATH PRAVEEN KUMAR				ANAND KUMAR S				09-07-2018		1819-07-CIR-EWS		0		8/11					
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* REFER NDE MANUAL No.P5:CMX:002 REV.No 01/12-98 NOTE: ALSO REFER QUALITY GUIDELINE NO. SIP:PP:29/REV.02																							

ERECTION WELDING SCHEDULE																					
		PG NO : 07																			
		PG NAME : Circulation System																			
		SYSTEM DESCRIPTION : Circulation System																			
CUST No :		CUST DOC NO : 9591-102-102-QVM-V-001 CUST DOC REV : 00																			
PROJECT :																					
WELDING CODE : I.B.R / ASME		PRESSURE PARTS/NO.N PRESSURE PARTS																			
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT		NDT METHOD/ QUANTUM	* REF.-.		REMARKS	REV	
				SIZE	THICK			GTAW	Qty in gms	Qty in Nos.	SMAW			TEMP. in °C	TIME in mins		SPEC. NO	ACC NORM REF.			
											Ø2.5										Ø3.15
81	0-00-027-34677	F-19L-L + F-19U-L	SA213T22 + SA213T22	38.1	9.5	GTAW + SMAW	9.5 	ER90S-B3	2428	6211	-	-	1084/00	200	740 ± 10	60	20% RT subject to min 2 weld/welder/shift			100% HC, 260HB (MAX)	
82	0-00-027-34677	F-19L-R + F-19U-R	SA213T22 + SA213T22	38.1	9.5	GTAW + SMAW	9.5 	ER90S-B3	2428	6211	-	-	1084/00	200	740 ± 10	60	20% RT subject to min 2 weld/welder/shift			100% HC, 260HB (MAX)	
83	0-00-027-34677	F-19U-L + F-20 NIPPLE	SA213T22 + SA213T22	38.1	9.5	GTAW + SMAW	9.5 	ER90S-B3	2428	6211	-	-	1084/00	200	740 ± 10	60	20% RT subject to min 2 weld/welder/shift			100% HC, 260HB (MAX)	
84	0-00-027-34677	F-19U-R + F-20 NIPPLE	SA213T22 + SA213T22	38.1	9.5	GTAW + SMAW	9.5 	ER90S-B3	2428	6211	-	-	1084/00	200	740 ± 10	60	20% RT subject to min 2 weld/welder/shift			100% HC, 260HB (MAX)	
85	0-00-027-34643	F-01 + F-16 L&R	SA106GRC + SA106GRC	406.4	80	GTAW + SMAW	70 	ER70S-A1	237	59	96	818	1004/04	150	610 ± 15	200	100% (ISRT + UT)				
86	0-00-027-34643	F-07 + F-16 L&R	SA106GRC + SA106GRC	406.4	80	GTAW + SMAW	70 	ER70S-A1	237	59	96	818	1004/04	150	610 ± 15	200	100% (ISRT + UT)				
87	0-00-027-34634	F-06 + F-05 NOZZLE	SA335P12 + SA182F12CL2	219.1	40	GTAW + SMAW	35 	ER80S-B2	270	63	103	261	1010/06	150	650-670	100	100% RT				
88	1-07-318-01065 1-07-318-01066	F-06 + F-06	SA335P12 + SA234WP12CL1	219.1	40	GTAW + SMAW	35 	ER80S-B2	539	126	206	521	1010/06	150	650-670	100	100% RT				
89	0-00-027-34634	F-06 + F-31 NOZZLE	SA335P12 + SA182F22CL3	219.1	40	GTAW + SMAW	35 	ER80S-B2	270	63	103	261	1012/04	150	680-720	100	100% RT				
90	0-00-027-34634	F-20 NOZZLE + F-21	SA182F12CL2 + SA335P12	219.1	40	GTAW + SMAW	35 	ER80S-B2	539	126	206	521	1010/06	150	650-670	100	100% RT				
PREPARED							CHECKED (W.T.C)		APPROVED		DATE		DOC NO.		REV NO :		PAGE NO.				
RUDRABHATLA SAIKUMAR							LAKAVATH PRAVEEN KUMAR		ANAND KUMAR S		09-07-2018		1819-07-CIR-EWS		0		9/11				
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ERECTION WELDING SCHEDULE																			
 CUST No : PROJECT : WELDING CODE : I.B.R / ASME		PG NO : 07																	
		PG NAME : Circulation System																	
		SYSTEM DESCRIPTION : Circulation System																	
CUST DOC NO : 9591-102-102-QVM-V-001 CUST DOC REV : 00																			
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT TEMP. in °C TIME in mins	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV
				SIZE	THICK			GTAW	Qty in Nos.	SMAW	Qty in Nos.					SPEC. NO	ACC NORM REF.		
91	1-07-315-01059 1-07-315-01060 1-07-315-01061 1-07-315-01062	F-21 + F-21	SA234WP12CL1 + SA335P12	219.1	40	GTAW + SMAW	35 	ER80S-B2	24	1615	E8018-B2	1010/06	150	650-670 100	100% RT				
92	0-00-027-34634	F-21 + F-31 NOZZLE	SA335P12 + SA182F22CL3	219.1	40	GTAW + SMAW	35 	ER80S-B2	8	539	E8018-B2	1012/04	150	680-720 100	100% RT				
93	0-00-027-34634	F-14 NOZZLE + F-15	SA182F12CL2 + SA335P12	219.1	40	GTAW + SMAW	35 	ER80S-B2	4	270	E8018-B2	1010/06	150	650-670 100	100% RT				
94	1-07-316-01063 1-07-316-01064	F-15 + F-15	SA234WP12CL1 + SA335P12	219.1	40	GTAW + SMAW	35 	ER80S-B2	12	808	E8018-B2	1010/06	150	650-670 100	100% RT				
95	0-00-027-34634	F-15 + F-31 NOZZLE	SA335P12 + SA182F22CL3	219.1	40	GTAW + SMAW	35 	ER80S-B2	4	270	E8018-B2	1012/04	150	680-720 100	100% RT				
96	0-00-027-34650	F-31 NOZZLE + F-32	SA182F22CL3 + SA335P12	355.6	65	GTAW + SMAW	56.88 	ER80S-B2	4	432	E8018-B2	1012/04	150	680-720 165	100% (ISRT + UT)				
97	0-07-102-01748	F-32 + F-32	SA335P12 + SA234WP12CL1	355.6	65	GTAW + SMAW	56.88 	ER80S-B2	4	432	E8018-B2	1010/06	150	650-670 165	100% (ISRT + UT)				
98	0-00-027-34650	F-32 + F-33 NOZZLE	SA335P12 + SA182F22CL3	355.6	65	GTAW + SMAW	56.88 	ER80S-B2	4	432	E8018-B2	1012/04	150	680-720 165	100% (ISRT + UT)				
99	0-07-110-01747	F-33 NOZZLE + F-49	SA182F22CL3 + SA335P12	406.4	70	GTAW + SMAW	61.25 	ER80S-B2	2	253	E8018-B2	1012/04	150	680-720 175	100% (ISRT + UT)				
100	0-00-027-34650	F-49 + F-50 NOZZLE	SA335P12 + SA182F12CL2	406.4	70	GTAW + SMAW	61.25 	ER80S-B2	2	253	E8018-B2	1010/06	150	650-670 175	100% (ISRT + UT)				
CAUTION :		PREPARED		CHECKED (W.T.C)		APPROVED		DATE		DOC NO.		REV NO :		PAGE NO.		* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98 NOTE: ALSO REFER QUALITY GUIDELINE NO. SIP:PP:29/REV.02			
		RUDRABHATLA SAIKUMAR		LAKAVATH PRAVEEN KUMAR		ANAND KUMAR S		09-07-2018		1819-07-CIR-EWS		0		10/11					

ERECTION WELDING SCHEDULE																						
 CUST No : PROJECT :		PG NO : 19																				
		PG NAME : Economiser System																				
		SYSTEM DESCRIPTION : Economiser System																				
WELDING CODE : I.B.R / ASME		CUST DOC NO : 9591-102-102-QVM-V-001 CUST DOC REV : 00																				
		PRESSURE PARTS/NO-N PRESSURE PARTS		ELECTRODE FILLER SPEC																		
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	GTAW			SMAW			WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT TEMP. in °C		NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV
				SIZE	THICK			Qty in Nos.	Qty in gms	Ø2.5	Qty in Nos.		Ø3.15			Ø4.0	TIME in mins		SPEC. NO	ACC NORM REF.		
21	0-00-027-34631	E-08L + R-04L HANGER	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ♂	ER70S-A1	5320	4188	E7018-1		1004/04	Nil	610 ± 15	40	20% RT subject to min 2 weld/welder/shift					
22	0-00-027-34631	R-04L HANGER + R-04LI HANGER	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ♂	ER70S-A1	5320	4188	E7018-1		1004/04	Nil	610 ± 15	40	20% RT subject to min 2 weld/welder/shift					
23	0-00-027-34631	R-04LI HANGER + R-04I HANGER	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ♂	ER70S-A1	5320	4188	E7018-1		1004/04	Nil	610 ± 15	40	20% RT subject to min 2 weld/welder/shift					
24	0-00-027-34631	R-04I HANGER + R-04UI HANGER	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ♂	ER70S-A1	5320	4188	E7018-1		1004/04	Nil	610 ± 15	40	20% RT subject to min 2 weld/welder/shift					
25	0-00-027-34631	R-04UI HANGER + R-04U HANGER	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ♂	ER70S-A1	5320	4188	E7018-1		1004/04	Nil	610 ± 15	40	20% RT subject to min 2 weld/welder/shift					
26	0-00-027-34631	R-04U HANGER + E-08U	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ♂	ER70S-A1	5320	4188	E7018-1		1004/04	Nil	610 ± 15	40	20% RT subject to min 2 weld/welder/shift					
27	0-00-027-34656, 0-00-027-34631	E-08U + E-08TO	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ♂	ER70S-A1	5320	4188	E7018-1		1004/04	Nil	610 ± 15	40	20% RT subject to min 2 weld/welder/shift					
28	0-00-027-34656, 0-00-027-34631	E-08TO + E-09 NIPPLE	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ♂	ER70S-A1	5320	4188	E7018-1		1004/04	Nil	610 ± 15	40	20% RT subject to min 2 weld/welder/shift					
29	0-00-027-34656, 0-00-027-34631	E-09 NIPPLE + E-08X	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ♂	ER70S-A1	717	564	E7018-1		1004/04	Nil	610 ± 15	40	20% RT subject to min 2 weld/welder/shift					
30	0-00-027-34656, 0-00-027-34631	E-08X + E-08X	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ♂	ER70S-A1	2865	2255	E7018-1		1004/04	Nil	610 ± 15	40	20% RT subject to min 2 weld/welder/shift					
		PREPARED		CHECKED (W.T.C)		APPROVED		DATE		DOC NO.		REV NO :		PAGE NO.								
		RUDRABHATLA SAIKUMAR		LAKAVATH PRAVEEN KUMAR		ANAND KUMAR S		09-07-2018		1819-19-ECO-EWS		0		3/4								
CAUTION :		* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98																				

ERECTION WELDING SCHEDULE																				
		PG NO : 19																		
		PG NAME : Economiser System																		
		SYSTEM DESCRIPTION : Economiser System																		
CUST No. :		CUST DOC NO : 9591-102-102-QVM-V-001 CUST DOC REV : 00																		
PROJECT :																				
WELDING CODE : I.B.R / ASME		PRESSURE PARTS/NO-N-PRESSURE PARTS																		
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC			WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT		NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK			GTAW	SMAW				TEMP. in °C	TIME in mins		SPEC. NO	ACC NORM REF.			
									Qty in Nos.	Qty in gms										Qty in Nos.
31	0-00-027-34656, 0-00-027-34631	E-08X + E-09 NIPPLE	SA210GRC + SA210GRC	69.85	14.1	GTAW + SMAW	14.1 ∇ 56	ER70S-A1 717	564	647	-	1004/04	Nil	610 ± 15 40	20% RT subject to min 2 weld/welder/shift					
32	0-19-851-02025, 0-00-027-34653	E-09 + EF-01	SA106GRC + SA106GRC	558.8	76.2	GTAW + SMAW	66.68 ∇ 2	ER70S-A1 376	81	132	1103	1004/04	150	610 ± 15 195	100% (ISRT + UT)					
33	0-19-851-02025, 0-00-027-34653	EF-01 + EF-01	SA106GRC + SA106GRC	558.8	76.2	GTAW + SMAW	66.68 ∇ 12	ER70S-A1 2255	481	788	6616	1004/04	150	610 ± 15 195	100% (ISRT + UT)					
34	0-19-851-02025, 0-00-027-34653	EF-01 + EF-02	SA106GRC + SA234WPC	558.8	76.2	GTAW + SMAW	66.68 ∇ 2	ER70S-A1 376	81	132	1103	1004/04	150	610 ± 15 195	100% (ISRT + UT)					
35	0-19-852-02032, 0-00-027-34653	EF-02 + EF-03	SA234WPC + SA106GRC	558.8	76.2	GTAW + SMAW	66.68 ∇ 2	ER70S-A1 376	81	132	1103	1004/04	150	610 ± 15 195	100% (ISRT + UT)					
36	0-19-853-02028, 0-00-027-34653	EF-03 + EF-03	SA106GRC + SA106GRC	558.8	76.2	GTAW + SMAW	66.68 ∇ 4	ER70S-A1 752	161	263	2206	1004/04	150	610 ± 15 195	100% (ISRT + UT)					
37	0-19-853-02028, 0-00-027-34653	EF-03 + F-16 L&R	SA106GRC + SA234WPC	558.8	76.2	GTAW + SMAW	66.68 ∇ 2	ER70S-A1 376	81	132	1103	1004/04	150	610 ± 15 195	100% (ISRT + UT)					
38		GAMMA PLUG	SA105 + SA106GRC			SMAW	7 ∇ 36	- -	10	-	-	1101/01	150	Nil	100% LPI or MPI			FOR T >75 MM		
39		GAMMA PLUG	SA105 + SA106GRC			SMAW	7 ∇ 10	- -	3	-	-	1101/01	100	Nil	100% LPI or MPI			FOR T- (25-75) MM		
PREPARED			CHECKED (W.T.C)			APPROVED			DATE			DOC NO.			REV NO :			PAGE NO.		
RUDRABHATLA SAIKUMAR			LAKAVATH PRAVEEN KUMAR			ANAND KUMAR S			09-07-2018			1819-19-ECO-EWS			0			4/4		
CAUTION :			* REFER NDE MANUAL No.PS:CMX:002 REV.No.01/12-98																	

ERECTION WELDING SCHEDULE																						
 CUST No : PROJECT : WELDING CODE : I.B.R / ASME		PG NO : 17																				
		PG NAME : Reheater System																				
		SYSTEM DESCRIPTION : Reheater System																				
CUST DOC NO : 9591-102-102-QVM-V-001 CUST DOC REV : 00																						
SL NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT		NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV		
				SIZE	THICK			GTAW	SMAW	Qty in Nos.	Qty in gms			Ø2.5	Ø3.15		Ø4.0	TEMP. in °C			TIME in mins	SPEC. NO
1	0-15-136-00363	R-03 HDR + R-03 SPOOL	SA335P12 + SA335P12	558.8	40	GTAW + SMAW	35 	ER80S-B2	E8018-B2	2	432	81	132	379	1010/06	150	650-670	100	100% RT			
2	0-00-027-34631	R-03 NIPPLE + R-04TI	SA213T11 + SA213T11	69.85	4.57	GTAW + SMAW	4.57 	ER80S-B2	E8018-B2	936	17512	6844	-	-	1009/03	150	Nil		20% RT subject to min 2 weld/welder/shift			
3	0-00-027-34631	R-04TI + R-04L	SA213T11 + SA213T11	69.85	4.57	GTAW + SMAW	4.57 	ER80S-B2	E8018-B2	936	17512	6844	-	-	1009/03	150	Nil		20% RT subject to min 2 weld/welder/shift			
4	0-00-027-34631	R-04L + R-04LI	SA213T11 + SA213T11	69.85	4.57	GTAW + SMAW	4.57 	ER80S-B2	E8018-B2	936	17512	6844	-	-	1009/03	150	Nil		20% RT subject to min 2 weld/welder/shift			
5	0-00-027-34631	R-04LI + R-04I	SA213T11 + SA213T22	69.85	5.08	GTAW + SMAW	5.08 	ER80S-B2	E8018-B2	936	17216	8177	-	-	1011/01	150	Nil		20% RT subject to min 2 weld/welder/shift			
6	0-00-027-34631	R-04I + R-04UI	SA213T22 + SA213T22	69.85	5.08	GTAW + SMAW	5.08 	ER90S-B3	E9018-B3	936	17216	8177	-	-	1013/02	150	Nil		20% RT subject to min 2 weld/welder/shift			
7	0-00-027-34631	R-04UI + R-04U	SA213T91 + SA213T91	69.85	4.57	GTAW	4.57 	ER90S-B9	E9015-B91	936	93949	-	-	-	1036/08	220	745 ± 15	30	100% RT		100% HC, 190 HB TO 300HB	
8	0-00-027-34631	R-04U + R-07	SA213T91 + SA213T91	63.5	4.2	GTAW	4.2 	ER90S-B9	E9015-B91	936	74407	-	-	-	1036/08	220	745 ± 15	30	100% RT		100% HC, 190 HB TO 300HB	
9	0-00-027-34631	R-07 + R-07TO	SA213T91 + SA213T91	63.5	4.2	GTAW	4.2 	ER90S-B9	E9015-B91	936	74407	-	-	-	1036/08	220	745 ± 15	30	100% RT		100% HC, 190 HB TO 300HB	
10	0-00-027-34631	R-07TO (1) + R-08 NIPPLE	SA213T91 + SA213T91	63.5	4.2	GTAW	4.2 	ER90S-B9	E9015-B91	104	8268	-	-	-	1036/08	220	745 ± 15	30	100% RT		100% HC, 190 HB TO 300HB	
PREPARED							CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.	
RUDRABHATLA SAIKUMAR							LAKAVATH PRAVEEN KUMAR				ANAND KUMAR S				09-07-2018		1819-17-RH-EWS		0		1/3	
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		ERECTION WELDING SCHEDULE																		
		CUST No : PROJECT : WELDING CODE : I.B.R / ASME		PRESSURE PARTS/NOAL PRESSURE PARTS															PG NO : 12	
				PG NAME : Superheater System SYSTEM DESCRIPTION : Superheater System CUST DOC NO : 9591-102-102-QVM-V-001 CUST DOC REV : 00																
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT TEMP. in °C	NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV	
				SIZE	THICK		Qty in Nos.	GTAW	Qty in gms		SMAW		Qty in Nos.			TIME in mins		SPEC. NO	ACC NORM REF.	
1	0-12-850-02915, 0-12-850-02916	F-31 NOZZLE + S-01	SA182F22CL3 + SA335P12	323.9	60	GTAW + SMAW	52.5 ∅	8	782	186	E8018-B2		1012/04	150	680-720 150	100% RT				
2	0-12-850-02915, 0-12-850-02916	S-01 + S-01	SA335P12 + SA234WP12CL1	323.9	60	GTAW + SMAW	52.5 ∅	16	1564	372	609	E8018-B2		1010/06	150	650-670 150	100% RT			
3	0-12-850-02915, 0-12-850-02916	S-01 + S-01A NOZZLE	SA335P12 + SA182F12CL2	323.9	60	GTAW + SMAW	52.5 ∅	8	782	186	305	E8018-B2		1010/06	150	650-670 150	100% RT			
4	0-12-862-02895	S-01A + S-01A	SA335P12 + SA335P12	508	85	GTAW + SMAW	74.38 ∅	1	159	37	60	E8018-B2		1010/06	150	650-670 215	100% (ISRT + UT)			
5	0-12-862-02895	S-01A + S-01B	SA335P12 + SA335P12	508	85	GTAW + SMAW	74.38 ∅	2	318	73	120	E8018-B2		1010/06	150	650-670 215	100% (ISRT + UT)			
6	0-12-862-02896	S-01B + S-01C	SA335P12 + SA335P12	508	85	GTAW + SMAW	74.38 ∅	2	318	73	120	E8018-B2		1010/06	150	650-670 215	100% (ISRT + UT)			
7	0-12-862-02896	S-01C + S-02 TEE	SA234WP12CL1 + SA234WP22CL1	406.4	100	GTAW + SMAW	87.5 ∅	2	207	59	96	E8018-B2		1012/04	150	680-720 250	100% (ISRT + UT)			
8	0-00-027-34636	S-02 NIPPLE + S-03	SA213T12 + SA213T12	54	8.13	GTAW + SMAW	8.13 ∅	208	2407	1928	300	E8018-B2		1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift			
9	0-00-027-34636	S-02 NIPPLE + S-03	SA213T12 + SA213T12	50.8	8.64	GTAW + SMAW	8.64 ∅	2	21	17	4	E8018-B2		1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift			
10	0-00-027-34636	S-03 + S-04	SA213T12 + SA213T12	60.3	10.16	GTAW + SMAW	10.16 ∅	210	2577	2043	796	E8018-B2		1009/03	150	Nil	20% RT subject to min 2 weld/welder/shift			
		PREPARED	CHECKED (W.T.C)				APPROVED				DATE		DOC NO.		REV NO :		PAGE NO.			
		RUDRABHATLA SAIKUMAR	LAKAVATH PRAVEEN KUMAR				ANAND KUMAR S				09-07-2018		1819-12-SH-EWS		0		1/10			
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ERECTION WELDING SCHEDULE																				
		CUST No. :		PG NO : 12																
		PROJECT :		PG NAME : Superheater System																
		WELDING CODE : I.B.R. / ASME		SYSTEM DESCRIPTION : Superheater System																
		CUST DOC NO : 9591-102-QVM-V-001 CUST DOC REV : 00																		
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT		NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV
				SIZE	THICK			GTAW	Qty in Nos.	SMAW	Qty in Nos.			Ø2.5	Ø3.15		Ø4.0	TEMP. in °C		
41	0-00-027-34654	S-13 ELBOW L&R + S-17	SA234WP91 + SA335P91	406.4	90	GTAW + SMAW	78.75 	ER90S-B9	222	98	130	1357	1050/06	220	740-770 225	100% UT			100% HC, 190HB TO 300HB	
42	0-12-852-02920	S-22 + S-25A	SA234WP12CL1 + SA335P12	457	80	GTAW + SMAW	70 	ER80S-B2	282	66	108	941	1010/06	150	650-670 200	100% (ISRT + UT)				
43	0-12-852-02920	S-25A + S-25A	SA335P12 + SA335P12	457	80	GTAW + SMAW	70 	ER80S-B2	282	66	108	941	1010/06	150	650-670 200	100% (ISRT + UT)				
44	0-12-852-02921	S-25A + S25B REDUCER	SA335P12 + SA234WP12CL1	457	80	GTAW + SMAW	70 	ER80S-B2	282	66	108	941	1010/06	150	650-670 200	100% (ISRT + UT)				
45	0-12-852-02921	S-25B + S-25B	SA335P12 + SA335P12	508	80	GTAW + SMAW	70 	ER80S-B2	326	73	120	1064	1010/06	150	650-670 200	100% (ISRT + UT)				
46	0-00-027-34634	S-25B + S-26 TEE	SA335P12 + SA335P12	508	80	GTAW + SMAW	70 	ER80S-B2	326	73	120	1064	1010/06	150	650-670 200	100% (ISRT + UT)				
47	0-00-027-34634	S-24 + S-25B	SA335P12 + SA182F12CL2	273	45	GTAW + SMAW	39.38 	ER80S-B2	174	40	65	206	1010/06	150	650-670 115	100% RT				
48	0-00-027-34634	S-24 + S-01C	SA335P12 + SA182F12CL2	273	45	GTAW + SMAW	39.38 	ER80S-B2	174	40	65	206	1010/06	150	650-670 115	100% RT				
49	0-12-187-02894	S-24 + S-24	SA335P12 + SA335P12	273	45	GTAW + SMAW	39.38 	ER80S-B2	522	118	193	616	1010/06	150	650-670 115	100% RT				
50	0-11-078-03583, 0-10-176-01670	S-26 NIPPLE + S-27 (1)	SA213T22 + SA213T22	57.15	8.13	GTAW + SMAW	8.13 	ER90S-B3	427	337	52	-	1014/03	150	680-720 30	20% RT subject to min 2 weld/welder/shift				
		PREPARED	RUDRABHATLA SAIKUMAR	CHECKED (W.T.C)		APPROVED		DATE		DOC NO.		REV NO. :		PAGE NO.						
		LAKAVATH PRAVEEN KUMAR		ANAND KUMAR S		09-07-2018		1819-12-SH-EWS		0		5/10								
CAUTION :		* REFER NDE MANUAL No.PS:CMX-002 REV.No.01/12-98																		
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		ERECTION WELDING SCHEDULE																		
		PG NO : 12																		
		PG NAME : Superheater System																		
		SYSTEM DESCRIPTION : Superheater System																		
CUST No :		CUST DOC NO : 9591-102-102-QVM-V-001 CUST DOC REV : 00																		
PROJECT :																				
WELDING CODE : I.B.R / ASME		PRESSURE PARTS/NOV-PRESSURE PARTS																		
SL. NO	DRG NO. FOR WELD LOCATION & IDENTIFICATION MARK	DESCRIPTION OF PARTS TO BE WELDED	MATERIAL SPEC.	DIMENSIONS		PROCESS OF WELDING	TYPE OF WELD	ELECTRODE FILLER SPEC				WPS NO/REV NO.	MIN. PRE HEAT TEMP. in °C	PWHT		NDT METHOD/ QUANTUM	* REF.-		REMARKS	REV
				SIZE	THICK			GTAW	Qty in Nos.	SMAW	Qty in Nos.			Ø2.5	Ø3.15		Ø4.0	TEMP. in mins		
51	0-11-078-03583, 0-10-176-01670	S-26 NIPPLE + S-27 (2-5)	SA213T22 + SA213T22	38.1	6	GTAW + SMAW	6 ✓	GTAW	Qty in gms	ER90S-B3	1082	866	-	-	1013/02	150	Nil	20% RT subject to min 2 weld/welder/shift		
52	0-11-078-03583, 0-10-176-01670	S-26 NIPPLE + S-27 (6-8)	SA213T22 + SA213T22	38.1	7.62	GTAW + SMAW	7.62 ✓	GTAW	709	ER90S-B3	1001	-	-	-	1013/02	150	Nil	20% RT subject to min 2 weld/welder/shift		
53	0-11-078-03583, 0-10-176-01670	S-26 NIPPLE + S-27 (9-12)	SA213T22 + SA213T22	38.1	8.13	GTAW + SMAW	8.13 ✓	GTAW	902	ER90S-B3	1504	-	-	-	1014/03	150	680-720 30	20% RT subject to min 2 weld/welder/shift		
54	0-11-078-03583, 0-10-176-01670	S-26 NIPPLE + S-27 (13-20)	SA213T22 + SA213T22	33.4	7.11	GTAW + SMAW	7.11 ✓	GTAW	1579	ER90S-B3	2060	-	-	-	1013/02	150	Nil	20% RT subject to min 2 weld/welder/shift		
55	0-00-027-34648	S-27 (1) + S-27TO (1)	SA213T91 + SA213T91	50.8	8.13	GTAW + SMAW	8.13 ✓	GTAW	360	ER90S-B9	488	64	-	-	1036/08	220	745 ± 15 30	100% RT		100% HC, 190HB TO 300HB
56	0-00-027-34648	S-27 (2-20) + S-27TO (2-20)	SA213T91 + SA213T91	44.45	7.11	GTAW + SMAW	7.11 ✓	GTAW	5968	ER90S-B9	10850	-	-	-	1036/08	220	745 ± 15 30	100% RT		100% HC, 190HB TO 300HB
57	0-00-027-34648	S-27TO (1) + S-28 NIPPLE	SA213T91 + SA213T91	57.15	8.13	GTAW + SMAW	8.13 ✓	GTAW	427	ER90S-B9	562	70	-	-	1036/08	220	745 ± 15 30	100% RT		100% HC, 190HB TO 300HB
58	0-00-027-34648	S-27TO (2-5) + S-28 NIPPLE	SA213T91 + SA213T91	38.1	6.1	GTAW + SMAW	6.1 ✓	GTAW	1074	ER90S-B9	1486	-	-	-	1036/08	220	745 ± 15 30	100% RT		100% HC, 190HB TO 300HB
59	0-00-027-34648	S-27TO (6-8) + S-28 NIPPLE	SA213T91 + SA213T91	38.1	8.13	GTAW + SMAW	8.13 ✓	GTAW	677	ER90S-B9	1879	-	-	-	1036/08	220	745 ± 15 30	100% RT		100% HC, 190HB TO 300HB
60	0-00-027-34648	S-27TO (9-20) + S-28 NIPPLE	SA213T91 + SA213T91	33.4	7.11	GTAW + SMAW	7.11 ✓	GTAW	2369	ER90S-B9	5150	-	-	-	1036/08	220	745 ± 15 30	100% RT		100% HC, 190HB TO 300HB
PREPARED		CHECKED (W.T.C)		APPROVED		DATE		DOC NO.		REV NO. :		PAGE NO.		6/10						
RUDRABHATLA SAIKUMAR		LAKAVATH PRAVEEN KUMAR		ANAND KUMAR S		09-07-2018		1819-12-SH-EWS		0										
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