FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm).

DRG. NO. 3 258 02 01400

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ORDERING PARTICULARS FOR METRIC O.D HIGH PRESSURE STEEL TUBES:-

1. SCOPE:-

THIS SPECIFICATION COVERS THE ORDERING PARTICULARS FOR HIGH PRESSURE METRIC OUTSIDE DIAMETER STEEL TUBES TO BE USED FOR BRAKING/JACKING AND HYDRO STATIC LUBRICATION SYSTEM.

2. MATERIAL:- (DESIGNATION: DIN 2391-C-ST 35 GBK 20x2)
DIN 2391-C-ST 35 GBK 25x3)

THE TUBES SHALL BE COLD DRAWN, ANNEALED & DESCALED & SHALL BE SUPPLIED IN A HYDRAULICALLY CLEAN CONDITION IN ACCORDANCE WITH DIN 2391/C. THE MINIMUM UTS SHALL BE 3300 BARS. IT SHALL BE MANUFACTURED FROM STEEL HAVING THE FOLLOWING CHEMICAL COMPOSITION KILLED STEEL SHALL BE USED.

CARBON	= 0.20% MAX.
MANGENESE	= 0.70% MAX.
SILICON	= 0.35% MAX.
SULPHUR	= 0.05% MAX.
PHOSPHORUS	= 0.05% MAX.

3. THE SIZE OF THE TUBE SHALL BE AS SPECIFIED ON THE ORDER 20 mm. O/D & 25 mm. O/D WILL NORMALLY BE ORDERED. THE LENTH OF TUBE SHALL BE 3 TO 6 METERS.

4. TOLERANCE ON O/D:-

FOR ø20 O/D TUBE : ±0.08 (INCLUDING OVALITY)
FOR ø25 O/D TUBE : ±0.08 (INCLUDING OVALITY)

5. PRESSUE:-

(i) MAX. WORKING PRESSSURE
(a) 20 O/D TUBE : 160 BAR
(b) 25 O/D TUBE : 250 BAR

(ii) TEST PRESSURE
$1^{1/2}$ TIMES THE MAX. WORKING PRESSURE.

6. WALL THICKNESS:-

(a) 20 O/D TUBE : 2 mm.
(b) 25 O/D TUBE : 3 mm.

7. WEIGHT:-

APPROX. WEIGHT IN KG/100 METRE LENGTH:
(a) 20 O/D TUBE : 89.00
(b) 25 O/D TUBE : 163.00

8. TEST CERTIFICATES:-

12 COPIES OF TEST CERTIFICATES SHALL BE SUPPLIED FOR EACH CAST/HEAT OF THE MATERIAL. THE TEST CERTIFICATE SHALL CONTAIN THE FOLLOWING INFORMATIONS:-
(a) OUR ORDER NO.
(b) DRAWING NO. (3 258 02 01400)
(c) CAST NO. / HEAT NO.
(d) CHEMICAL & MECHANICAL PROPERTIES TEST RESULTS
(e) PRESSURE TEST RESULTS
(f) DIMENSIONAL INSPECTION (O/D & TOL.)

9. PACKING & MARKING:-

THE MATERIAL SHALL BE SUITABLY PACKED TO PREVENT DAMAGE DURING TRANSIT. EACH PACKAGE/BUNDLE SHALL HAVE THE FOLLOWING INFORMATIONS:
(a) HIGH PRESSURE STEEL TUBES TO DRG. 3 258 02 01400.
(b) OUR ORDER NO.
(c) SUPPLIER'S NAME
(d) IDENTIFICATION OR CAST NO.
(e) SIZE & WEIGHT.

~~AVAILABLE FROM~~:-

~~M/s ALENCO INDUSTRIAL COMPONENTS LIMITED.~~
~~BELMOUNT ROAD,~~
~~MAIDEN HEAD,~~
~~BERKSHIRE SL 6 6 JP,~~
~~ENGLAND~~

FOR B.H.E.L USE:-

ITEM NO. 1:- STEEL TUBE PRESSURE 20 O/D - BP 9023002788.
ITEM NO. 2:- STEEL TUBE PRESSURE 25 O/D - BP 9023002792.

VAR00 (59–64)	REMARKS (65–75)	VAR. NO. (78 79)	ITEM NO. (25–27)	DESCRIPTION (29–58)	STD (59)	DRAWING NO. (60–77)	IT.NO. (29–31) / VAR. (32 33)	MATL. CODE (34–45) / MATL. SPCN. (46–54)	A C I (55)	UNIT (56 57)	UNIT WT. (58–65) / QTY. (68–71)	GS (72)
28 → CARD TYPE-3				28 → CARD TYPE-1				28 → CARD TYPE-2				

ADDITIONAL INFORMATION: NA

STATUS OF DRAWING: 'S'

DISTRIBUTION OF PRINTS: HGE- 1 HGM- 1 TEX- 1

उत्पाद का प्रकार या ग्राहक/परियोजना का नाम
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT: हाइड्रोजनरेटर HYDRO GENERATOR

STANDARD DRAWING
REVISION TO BE APPROVED BY STANDARD GROUP

भारत हेवी इलेक्ट्रिकल्स लिमिटेड भोपाल
BHARAT HEAVY ELECTRICALS LTD. BHOPAL

	नाम/ NAME	हस्ता/ SIGN.	दिनांक/ DATE	वे. सं. NO. OF VAR.
बनाया DRN.	–		–	
जाँचा CKD.	S.S. RAJAN	Sd/-	21.03.79	
अनुमोदित APPD.	R.K. PANDEY	Sd/-	21.03.79	NA

REV.	DATE	ALTERED-	CHECKED-	APPROVED-	REMARKS
03	18.02.20	MKS	JJ	JJ	LENGTH OF TUBE WAS 2 TO 2.5 AT SL. NO 3.
02	20.04.98	K.N.S. Sd/-	P.CHOUDHARI Sd/-		SL.NO.- 2 :-DESIGNATION ADDED. SL.NO.- 4 :-MODIFIED SL.NO.- 8 :-(f) ADDED. "AVAILABLE FROM" STRUCK OUT. DETAILS FOR B.H.E.L USE ADDED.
01	05.06.89	MANDWADE Sd/-	MKS/A.K.S.GURU Sd/-		DRG. RETRACED

INVENTORY NO.

विभाग DEPT: HGE
कोड CODE: 403
उन. टा. नाप की त्रुटि UNTOL. DIMS. GR.: 32500001404
उलूपात SCALE: NTS
भार कि.ग्रा. WEIGHT (K.G.): NA
उसे. ड्राईंग का संदर्भ REF. TO ASSY. DRG.: NA
मद सं. ITEM NO.: NA
मद. संख्या NO. OF ITEM: NA

शीर्षक/ TITLE: ORDERING PARTICULARS FOR METRIC O.D. HIGH PRESSURE STEEL TUBES.

उरेस क्र/ DRAWING NO.: 3 258 02 01400
पुन./ REV.: 03
पृष्ठ क्र/ SHT. NO. 01 पृष्ठों की संख्या /NO. OF SHT. 01

A3 SIZE