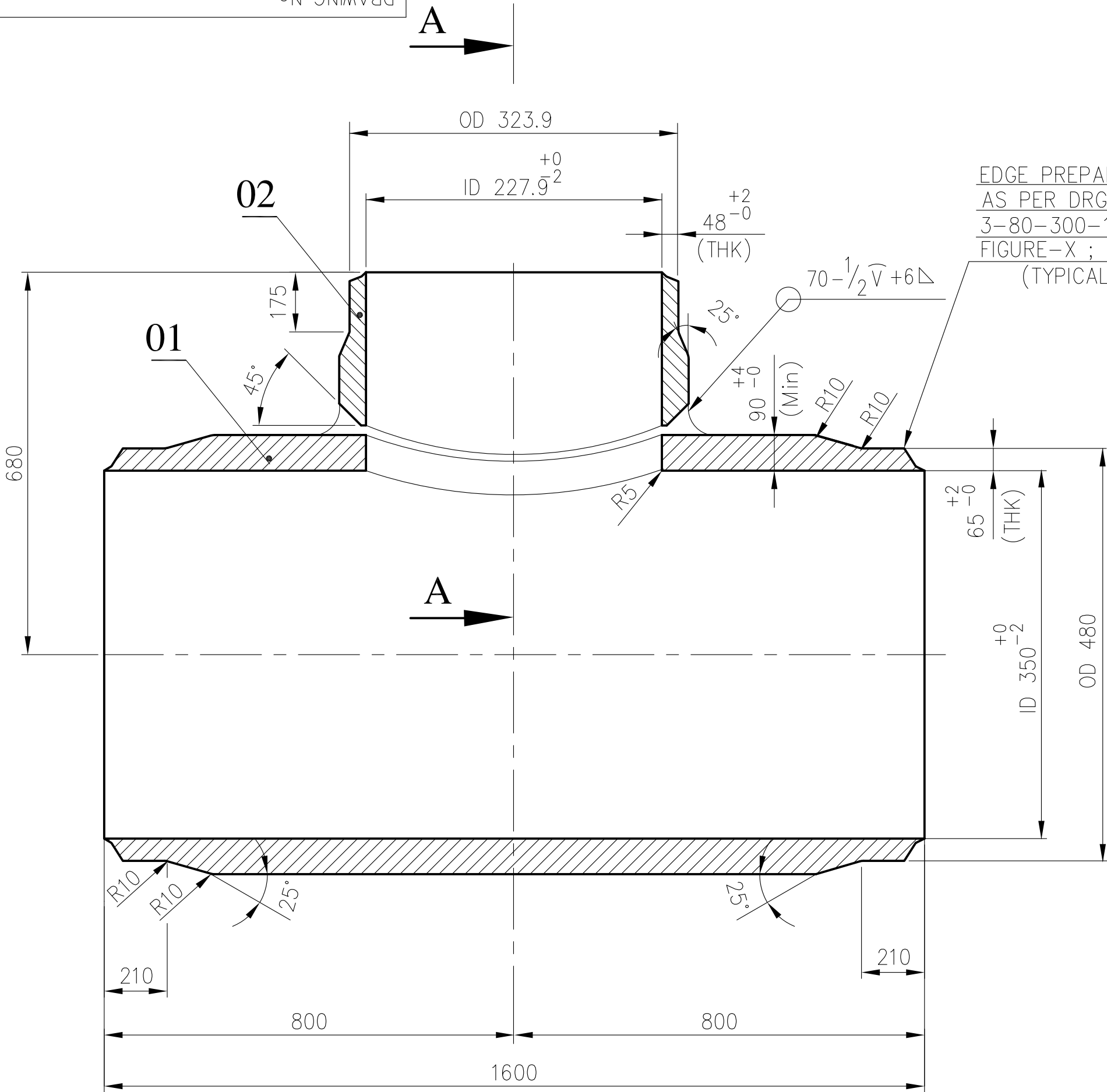


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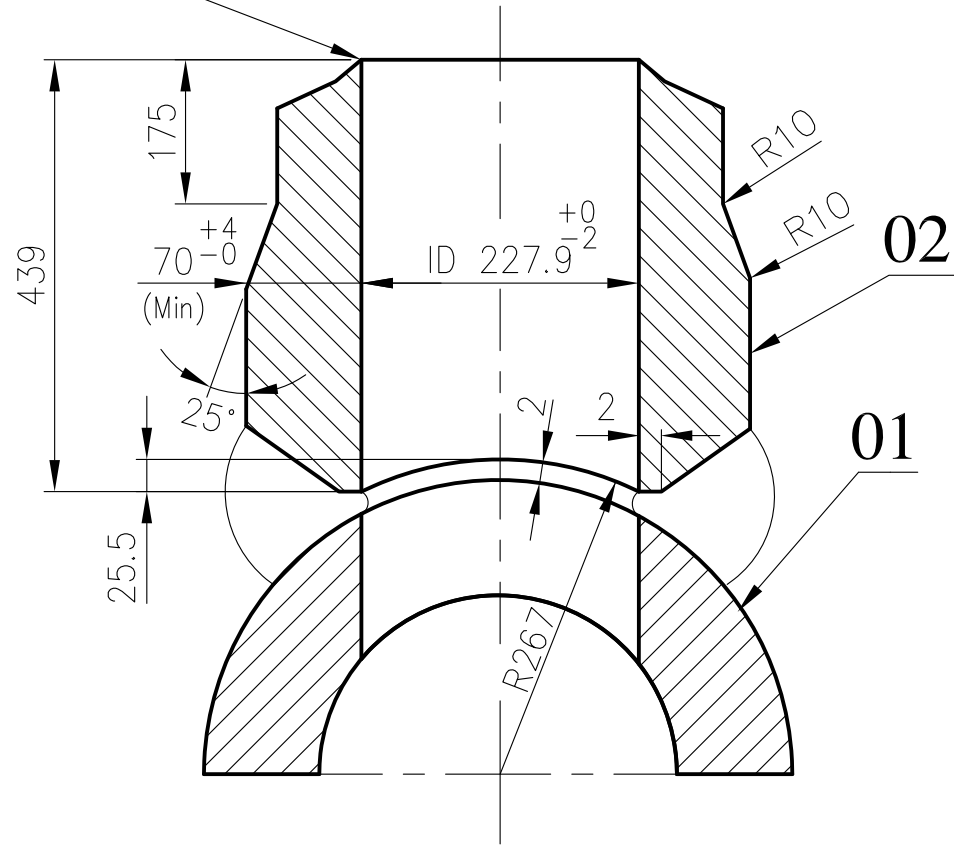
3-80-301-32309

DRAWING No



EDGE PREPARATION
AS PER DRG No.:
3-80-300-19825
FIGURE-X ; d1=350
(TYPICAL)

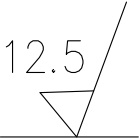
EDGE PREPARATION
AS PER DRG No.:
3-80-300-19825
FIGURE-X; d1=231.3



SECTION-AA

NOTES :-

- DESIGN PRESSURE : 271 Kg/Sq.Cm (g)
- DESIGN TEMPERATURE : 573° C
- FOLLOW TDG : 108 (LATEST REVISION)
- ELECTRODES TO BE USED ARE,
a) GTAW : ER90S-B9 (A)
b) SMAW : E9015-B9 (A)
ELECTRODES GIVEN ABOVE ARE INDICATIVE. VENDOR TO GIVE WPS FOR BHEL's APPROVAL.
- PIPE SA335P91(A) CAN ALSO BE USED IN PLACE OF SA182F91(A).
- WEIGHT INDICATED IS FOR FINISHED UNEQUAL TEE.
- FINISHED MATERIAL CODE FOR UNEQT IS 92 505 127 0000.



02	BRANCH NOZZLE L=439 ID 227.9 x Thk 70 Min	3-80-301-32309		SA 182 F91	A	188,000
						1
01	BASE PIPE L = 1600 ID 350 x Thk 90 Min	3-80-301-32309		SA 182 F91	A	1383,000
						1
ITEM NO.	DESCRIPTION	DRAWING NO.	ITEM NO.	MATERIAL CODE	A	UNIT WT.
			VAR NO.	MATERIAL SPEC.	C	QTY.

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT



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

DRN	NAME R.MANDAL	SIGN Sd/-	DATE 23.02.16	NO OF ITEMS
CHD	I.BISWAS	Sd/-	23.02.16	
APPD	S.RAMAMURTHY	Sd/-	23.02.16	

REV 01	DATE 04.05.18	ALTD:R.BHARATH APPD:I.BISWAS
ZONE	NOTE NO-5 DELETED	
	REVISION MARKED AS	

DEPT.	GRADE OF UN TOL. DIM C/M/F		SCALE N.T.S.	WEIGHT (Kg). 1571.000	BHEL PO REF.NO:		ITEM No.
CODE	TITLE FABRICATED UNEQUAL TEE ID350x60/OD323.9x48 SA182F91			CARD CODE U 01	DRAWING No. 3-80-301-32309		REV 01