

52861-003-08-3

DRAWING No.

NOTES: - 01. APPLICABLE FOR P91/P92
 02. STRAIGHT WITH BEND/FITTING
 03. BEND WITH BEND/FITTING

01. OD OF STRAIGHT TO BE PHYSICALLY MEASURED/VERIFIED.
 02. t = THK OF CONNECTING PIPE (STRAIGHT)
 03. REFER STYLE-D1 FOR THICKNESS <14.2mm (FOR ALL OD/ID)
 04. REFER STYLE-P1 WHEN THICKNESS IS ≥ 14.2 mm & ≤ 20 mm (FOR ALL OD/ID)
 05. WHEN THICKNESS ≥ 20 mm & OD ≤ 219.1 mm, $\alpha = 6^\circ$ FOR WALL THICKNESS ≥ 20 mm AND ≤ 30 mm
 06. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm

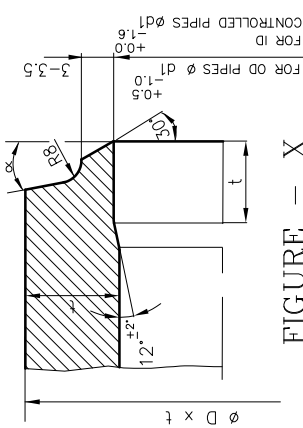
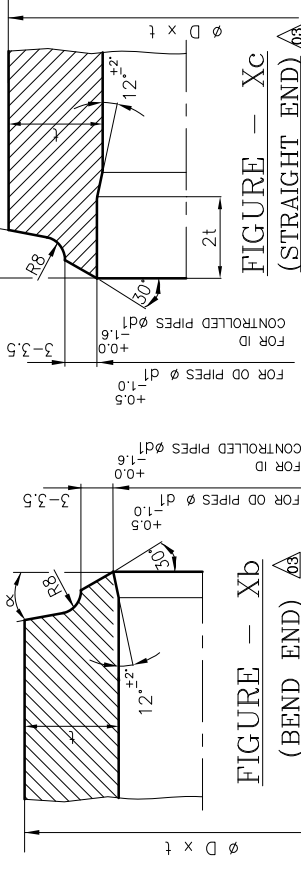


FIGURE - X

- NOTES: - 01. APPLICABLE FOR P91/P92 ZERO ARM PIPEBEND WELDED WITH P91/P92 STRAIGHT PIPE
 02. FOR OD MISMATCH, REFER FIGURE-Xa
 03. REFER STYLE-D1 FOR THICKNESS <14.2mm (FOR ALL OD/ID)
 04. REFER STYLE-P1

- i) WHEN THICKNESS IS ≥ 14.2 mm AND < 20 mm FOR ALL OD/ID.
 ii) WHEN THICKNESS ≥ 20 mm AND OD ≤ 219.1 mm.
 05. $\alpha = 6^\circ$ FOR WALL THICKNESS ≥ 20 mm AND ≤ 30 mm
 06. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm

FIGURE - Xb
(BEND END)FIGURE - Xc
(STRAIGHT END)

GENERAL NOTES :

01. THE MINIMUM THICKNESS AT WELD END SHALL NOT BE LESS THAN
 a) 0.875 TIMES t NOM. FOR OD PIPES.
 b) t MIN. FOR ID CONTROLLED PIPES.

02. t NOM & t MIN SHALL BE AS PER SPECIFIED PIPE SIZE.

03. SHARP CORNERS SHALL BE ROUNDED OFF WHEREVER 'R' IS INDICATED.

NOTES FOR WELDING:

01. WELD REINFORCEMENT TO BE FLUSH GROUND AND MERGED WITH PARENT METAL WITHOUT ANY UNEVENNESS.

MATCHING EDGE PREPARATION

- FOR MISMATCH OD APPLICABLE FOR BENDS/FITTINGS OF P91/P92 MATERIALS

NOTES: - 01. OD OF STRAIGHT TO BE PHYSICALLY MEASURED/VERIFIED.

02. t = THK OF CONNECTING PIPE (STRAIGHT)

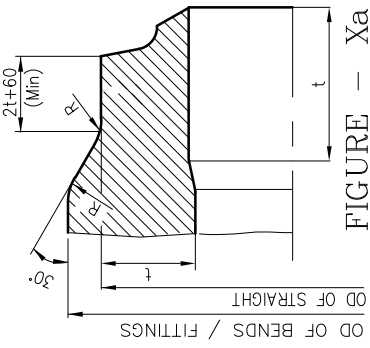


FIGURE - Xa

MATCHING EDGE PREPARATION FOR MISMATCH OD DIAMETRICALLY GREATER THAN 8 mm

(ie. OD1 - OD2 > 8mm) APPLICABLE FOR BENDS/FITTINGS OTHER THAN P91/P92 MATERIALS

NOTES: - 01. OD OF STRAIGHT TO BE PHYSICALLY MEASURED/VERIFIED.

02. WHEN t < 65, S+A = 65 Min. & t > 65, S=65 Min.
 WHERE t = THK OF CONN.PIPES(STRAIGHT).

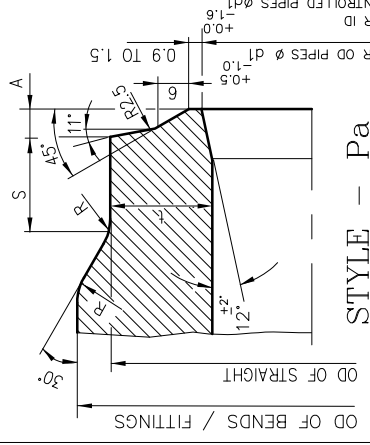


FIGURE - Pa

MATCHING EDGE PREPARATION FOR MISMATCH OD DIAMETRICALLY GREATER THAN 8 mm

(ie. OD1 - OD2 > 8mm) APPLICABLE FOR ELBOWS OTHER THAN P91/P92 MATERIALS

NOTES: - 01. OD = OUTSIDE DIA OF CONN. PIPE (STRAIGHT) TO BE PHYSICALLY MEASURED/VERIFIED.

02. t = THK OF CONN.PIPES (STRAIGHT)
 03. t = THK OF CONN.PIPES (STRAIGHT)

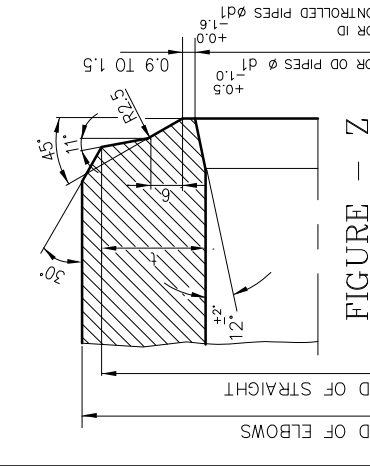


FIGURE - Z

NOTES: - 01. USE WHEN t < 14.2 mm.

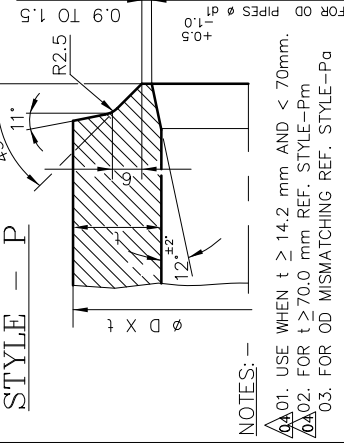


FIGURE - P

NOTES: - 01. USE WHEN t > 14.2 mm AND < 70mm.

02. FOR t > 70.0 mm REF. STYLE-Pm
 03. FOR OD MISMATCHING REF. STYLE-Pa

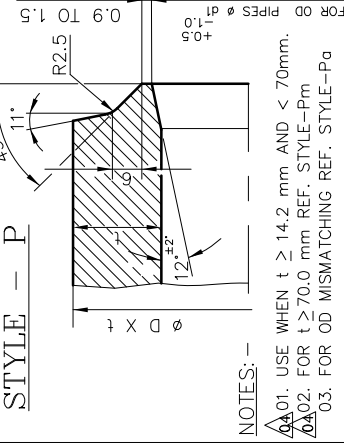
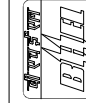


FIGURE - Pm

FIGURE - D

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

STANDARD



BHARAT HEAVY ELECTRICALS LTD.,
 PIPING CENTRE, MADRAS

REV	DATE	APPROVED	DESIGNED
0.1	07.12.16	APPROVED	R. SESHAGIRI
0.2	10.04.13	APPROVED	C.K.N
0.3	10.04.13	APPROVED	C.K.N
0.4	10.04.13	APPROVED	C.K.N
0.5	10.04.13	APPROVED	C.K.N
0.6	10.04.13	APPROVED	C.K.N
0.7	10.04.13	APPROVED	C.K.N
0.8	10.04.13	APPROVED	C.K.N
0.9	10.04.13	APPROVED	C.K.N
1.0	10.04.13	APPROVED	C.K.N

DEPT.	GRADE OF UN TOL. DIM	SCALE	WEIGHT (kg)	CARD CODE	DRAWING No.	REV
C/M/F	C/M/F	C/M/F	C/M/F	U 01	3-80-300-19825	04
ITEM No.	ITEM No.	ITEM No.	ITEM No.	ITEM No.	ITEM No.	ITEM No.
11.10.01	11.10.01	11.10.01	11.10.01	11.10.01	11.10.01	11.10.01
NAME OF ORIGINAL ORGANISATION	NAME OF ORIGINAL ORGANISATION	NAME OF ORIGINAL ORGANISATION	NAME OF ORIGINAL ORGANISATION	NAME OF ORIGINAL ORGANISATION	NAME OF ORIGINAL ORGANISATION	NAME OF ORIGINAL ORGANISATION
NAME	NAME	NAME	NAME	NAME	NAME	NAME
K.B.RAGUNATH	K.B.RAGUNATH	K.B.RAGUNATH	K.B.RAGUNATH	K.B.RAGUNATH	K.B.RAGUNATH	K.B.RAGUNATH
CHD	CHD	CHD	CHD	CHD	CHD	CHD
APPD	APPD	APPD	APPD	APPD	APPD	APPD
DATE	DATE	DATE	DATE	DATE	DATE	DATE
11.10.01	11.10.01	11.10.01	11.10.01	11.10.01	11.10.01	11.10.01
SIGN	SIGN	SIGN	SIGN	SIGN	SIGN	SIGN
NO OF ITEMS	NO OF ITEMS	NO OF ITEMS	NO OF ITEMS	NO OF ITEMS	NO OF ITEMS	NO OF ITEMS
1	1	1	1	1	1	1

EDGE PREPARATION
 DETAILS

U 01

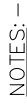
DRAWING No.

3-80-300-19825

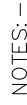
SHEET 1 OF 2

SIZE A3

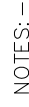
STYLE – Pm



- STYLE – DL



- STYLE - P_L

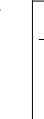


01. USE FOR P91 / P92 FITTINGS
02. REFER STYLE-DL FOR THICKNESS <14.2mm FOR ALL OD/ID.
03. REFER STYLE-PL
 - i) WHEN THICKNESS IS ≥ 14.2 mm AND < 20 mm FOR ALL OD/ID.
 - ii) WHEN THICKNESS ≥ 20 mm AND OD < 219.1 mm.
04. $\alpha = 6^\circ$ FOR WALL THICKNESS ≥ 20 MM AND ≤ 30 mm
05. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm.
06. FIGURE-Xf IS APPLICABLE FOR ALL BUTT WELDED FITTINGS NOT COVERED IN NOTES 02 & 03

FIGURE-Xf

01. FOR GENERAL NOTES AND NOTES FOR WELDING REFER SHEET 1 OF 2.

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

		BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, MADRAS				NAME P SURESH		SIGN	DATE 07.12.16	NO OF ITEMS
DEPT.	GRADE OF UN TOL. DIM C/M/F		SCALE	WEIGHT (Kg.) —	NAME OF ORIGINAL ORGANISATION	CHD R SESHAGIRI		07.12.16		
						APPD		07.12.16		
CODE		TITLE		CARD CODE		DRAWING No.		REV		
		EDGE PREPARATION DETAILS		U 01		3-80-300-19825		04		
SHEET 2 OF 2										