

92861-008-30-80-3
DRAWING No.

NOTES: - 01. APPLICABLE FOR P91/P92
i) STRAIGHT WITH STRAIGHT/FITTING
ii) BEND WITH BEND/FITTING

02. FOR OD MISMATCH, REFER FIGURE-Xa
03. REFER STYLE-DL FOR THICKNESS <14.2mm (FOR ALL OD/ID)
04. REFER STYLE-P
i) WHEN THICKNESS IS ≥ 14.2 mm & <20mm (FOR ALL OD/ID)
ii) WHEN THICKNESS ≥ 20 mm & OD <219.1mm.
05. $\alpha = 6^\circ$ FOR WALL THICKNESS ≥ 20 MM AND ≤ 30 mm
06. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm

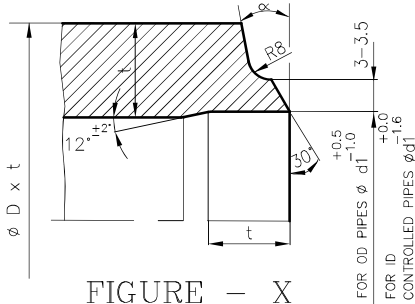


FIGURE - X

- 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)

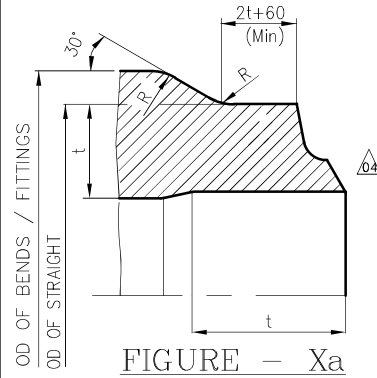
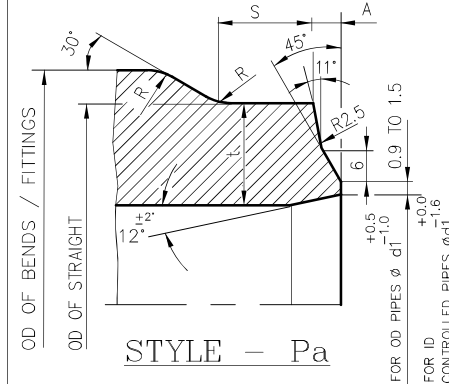


FIGURE - Xa

- 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).



STYLE - 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)

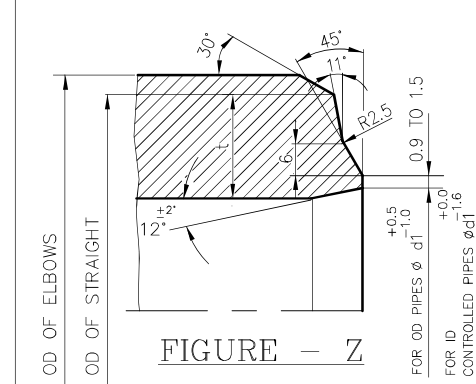
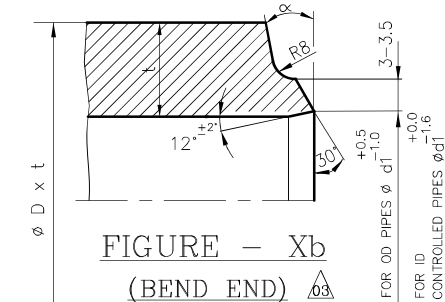
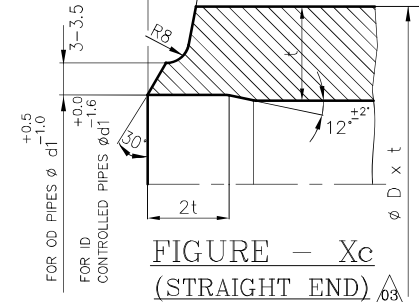
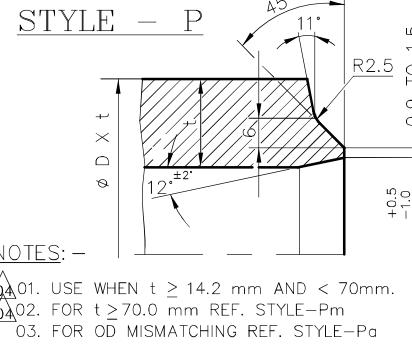


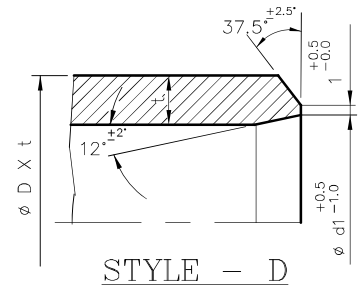
FIGURE - Z

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

- NOTES: -
01. USE WHEN $t \geq 14.2$ mm AND < 70mm.
02. FOR $t > 70.0$ mm REF. STYLE-Pm
03. FOR OD MISMATCHING REF. STYLE-Pa

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



STYLE - D

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

STANDARD

		BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, MADRAS		NAME		SIGN	DATE	NO OF ITEMS	
				K B.RAGUNATH			11.10.01		
				CHD M.C.SEKARAN			11.10.01		
				APPD A.VELAYUTHAM			11.10.01		
DEPT.	GRADE OF UN TOL DIM C/M/F		SCALE	WEIGHT (Kg).	NAME OF ORIGINAL ORGANISATION			ITEM No.	
CODE									
TITLE EDGE PREPARATION DETAILS					CARD CODE U 01	DRAWING No. 3-80-300-19825			REV 04
SHEET 1 OF 2									

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.

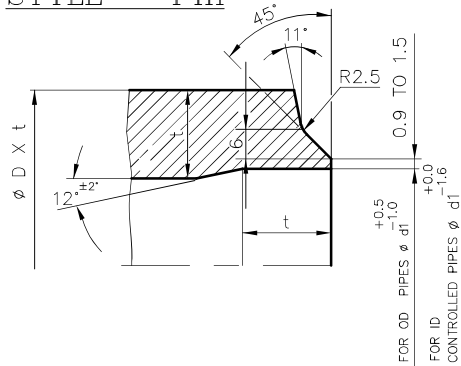
NOTES FOR WELDING:

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

REV 04	DATE 07.12.16	ALTERED: P SURESH APPROVED: R SESHAGIRI
ZONE	SHEET 2 OF 2 IS ADDED. NOTES ADDED, MODIFIED AND DELETED IN FIGURE-X, Xa, Xb, Xc AND STYLE-P	
REV 03	DATE 10.04.13	ALTERED: M.R.K APPROVED: C.K.N
ZONE	FIG.Xb AND FIG.Xc ADDED. IN FIG.X, NOTE 01 MODIFIED. IN FIG.Xa, STYLE-Pa, FIG.Z, P92 MATERIAL ADDED	
REV 02	DATE 10.01.13	ALTERED: M.R.K APPROVED: C.K.N
ZONE	IN FIG.Xa, NOTE 04 ADDED. GENERAL NOTES 03 ADDED. IN FIG.Xa, 8MM OD MISMATCH IS REMOVED	
REV 01	DATE 11.05.04	ALTERED: R.SENDHIL APPROVED: A.VELAYUTHAM
ZONE	PROJECT NAME REMOVED AND STANDARD INCORPORATED IN TITLE BLOCK	

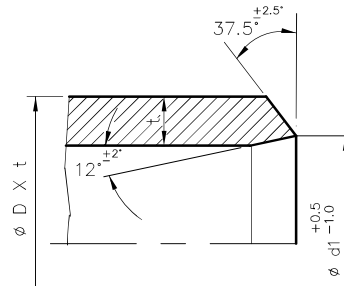
3-80-300-19825

DRAWING No.

STYLE - P_m

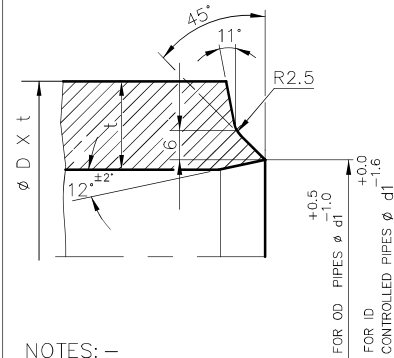
NOTES: -

01. USE FOR SA106GRC PIPES WHEN $t \geq 70.0$ mm.
02. FOR OD MISMATCHING REF. FIGURE-P_a
03. FOR FITTINGS USE STYLE-P.

STYLE - D_L

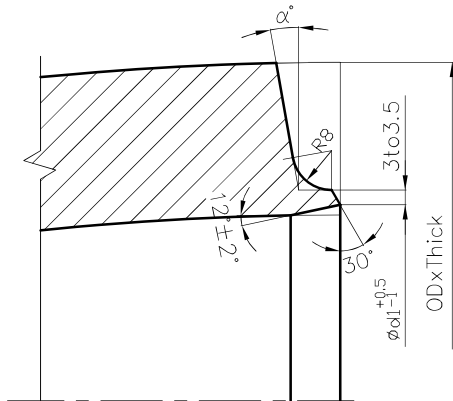
NOTES: -

01. USE FOR P91 / P92 PIPES AND FITTINGS WHEN $t < 14.2$ mm (ALL OD/ID).

STYLE - P_L

NOTES: -

01. USE FOR P91 / P92 PIPES AND FITTINGS
 - i) WHEN THICKNESS IS ≥ 14.2 mm AND < 20 mm FOR ALL OD/ID.
 - ii) WHEN THICKNESS ≥ 20 mm AND OD < 219.1 mm.
02. FOR OD MISMATCHING REF. FIGURE-P_a



01. USE FOR P91 / P92 FITTINGS
02. REFER STYLE-D_L FOR THICKNESS < 14.2 mm FOR ALL OD/ID.
03. REFER STYLE-P_L
 - 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

NOTE :

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

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

STANDARD

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