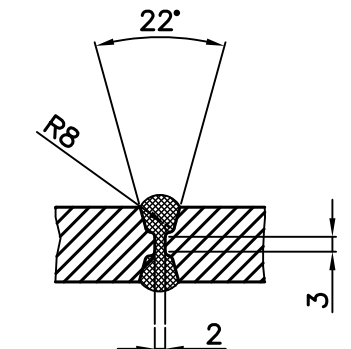




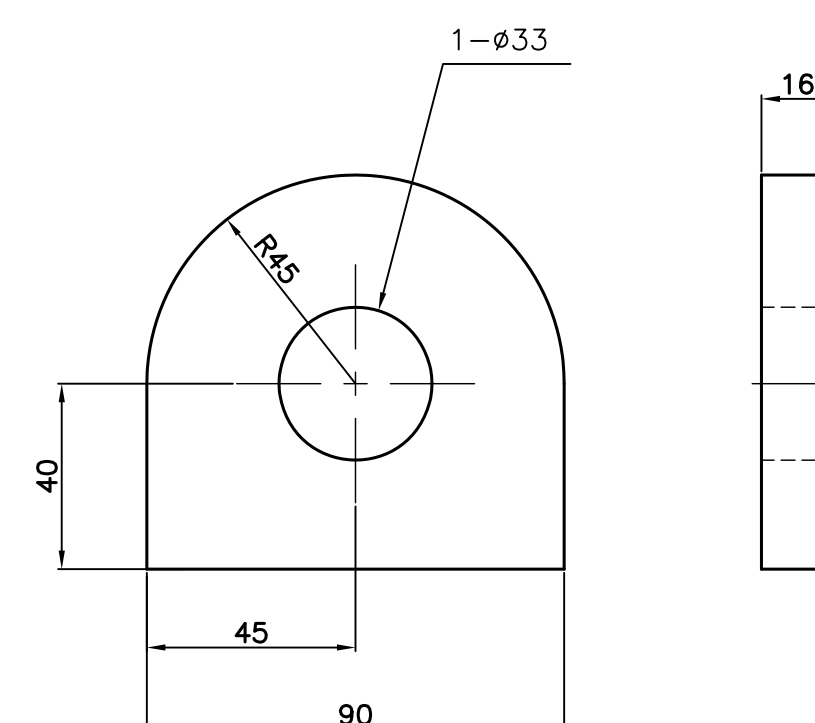
DETAIL—'D'

1. FOR FLANGES POS.No.2 &3; SEGMENTAL WELDING IS PERMITTED (MAXIMUM 4 SEGMENTS) SEGMENTS SHALL BE WELDED WITH DOUBLE "U" TYPE WELDING AS SHOWN IN DETAIL "D".
2. FOR SHELL POS.No.1; MAXIMUM 1 NO VERTICAL WELD JOINT IS PERMITTED. HORIZONTAL/RADIAL WELD JOINTS ARE NOT PERMITTED ON THE SHELL.
3. DIMENSIONS SHOWN ARE FINISH MACHINED DIMENSIONS. SUPPLIER SHALL SELECT SUITABLE RAW MATERIAL SIZES TO PROVIDE REQUIRED ALLOWANCES FOR MACHINING.
4. ALL MATERIAL SHALL BE ARRANGED BY SUPPLIER.
- 4A) MATERIAL FOR SHELL (POSITION NO.1) SHALL BE SS304 GRADE
- 4B) MATERIAL FOR FLANGES (POSITION NO.2, 3 & 4) SHALL BE IS 2062 GR.B

1. WELDING AS PER BHEL WELD PROCEDURE SPECN NO. WE-046
2. D.P.T SHALL BE DONE ON 100 % OF WELDS AS PER AA0850131 ACCEPTANCE AS PER AA0850129 LEVEL-IV
3. R.T TO BE CARRIED OUT ON 10 % OF BUTT WELDS AS PER THE QUALIFICATION PROCEDURE-ASME SECTION IX.
4. STRESS RELIEVING TO BE DONE AS PER HY0640783.
5. SHOT BLASTING TO BE DONE TO REMOVE SCALES, AFTER SHORT BLASTING ONE COAT OF PRIMER TO BE APPLIED WITHIN 2 HOURS.
6. WHEREVER NOT SPECIFIED, ALL SHARP EDGES TO BE CHAMFERED TO 2x45°
7. WHEREVER NOT SPECIFIED TOLERANCE ON MACHINED DIMENSIONS AS PER AA0230208 MEDIUM CLASS.
8. COMPONENT SHALL BE PRESSURE TESTED AT 7.5 Kg/Sq. Cm. FOR 30 MINUTES DURATION.

1. MACHINED SURFACES SHALL NOT BE PAINTED.
2. MACHINED SURFACES SHALL BE COATED WITH SUITABLE RUST PREVENTIVE COAT AS PER HY0490563, CATEGORY 'B'

1. TO BE PROPERLY PACKED AND DESPATCHED SUCH THAT NO DAMAGE IS CAUSED DURING HANDLING AND TRANSIT.



ITEM-4

ZONE		ZONE		ZONE		ZONE		ZONE		ZONE		ZONE	POINT NO 1 MODIFIED UNDER NOTES
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THE FOLLOWING CONDITIONS APPLY EXCEPT OTHERWISE STATED:- 1. REF. TO HY0230261 FOR UNSPECIFIED TOLERANCES. 2. CHAMFER M/C/D SHARP EDGES 1.2 TO 1.0 AT 45°. 3. INTERNAL M/C/D CORNER RADII 1 TO 0.7. 4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS SHOWN OUT SIDE BACK SLASHES GIVEN AT THE TOP MOST RIGHT CORNER OF THE DRG.	TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT  BHARAT HEAVY ELECTRICALS LTD. HYDERABAD	CW1Q BELLARY-700 MW
REF. TO ASSY DRG. —NA—		
DRAWING NO. 1 182 36 1 7048		
SHEET NO. NO OF SHEETS		

4. THE SURFACE ROUGHNESS WHEREVER NOT SHOWN SHALL BE TAKEN FROM THE SURFACE ROUGHNESS

CODE 410		N.T.S	645	-NA-
TITLE				DRAWING

SECTION LINER	1 100 0
	SHEET NO.