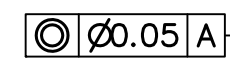


INVENTORY NO	SIGN. AND DATE	REF. DRG. NO.	COMPUTER FILE NAME :
		P1-QA527-R01	FP11824017004-R00

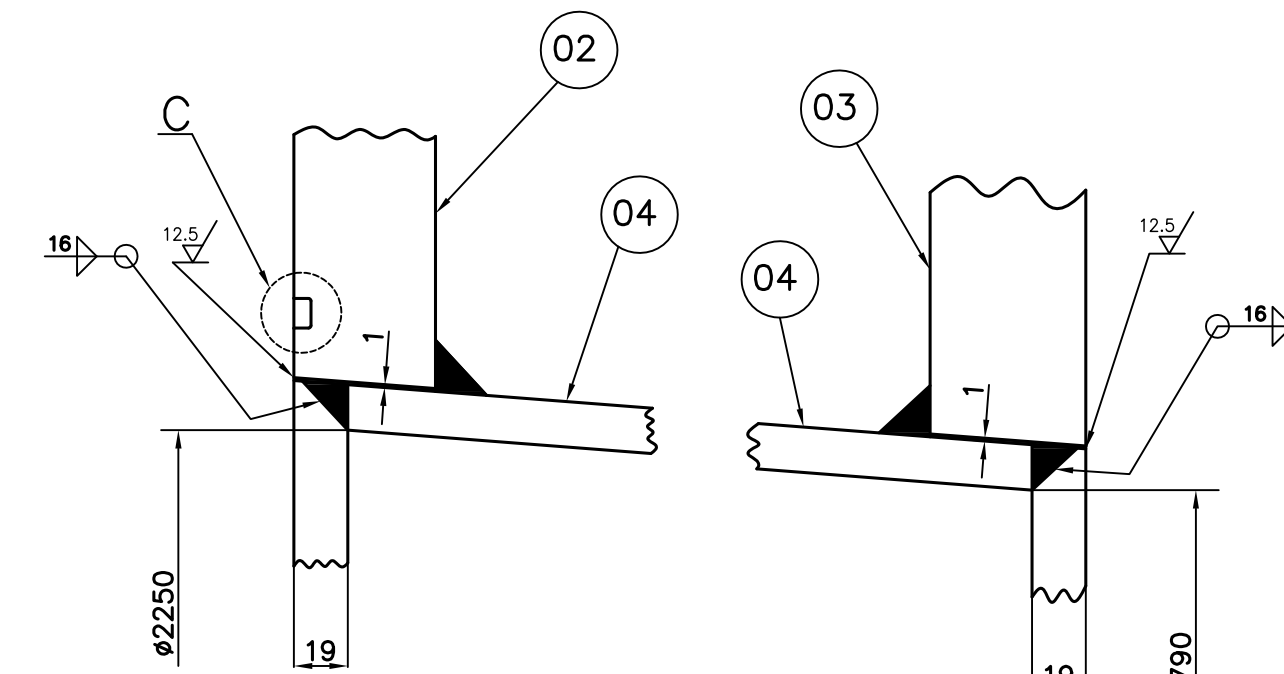
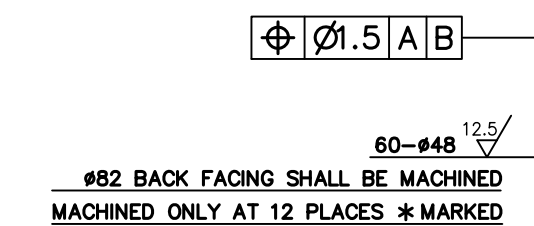
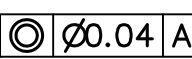
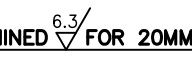


1. THE TOP SIDE OF COLUMN PIPE SHALL BE MATCHED WITH THE BOTTOM SIDE OF LIFTING COLUMN PIPE FOR EACH SET. THE MATCHING SHALL BE PCD, NO. OF HOLES AND FOR SPIGOT. MATCHING MARKS SHALL BE PROVIDED FOR EASY IDENTIFICATION AT SITE.

1. HYDRAULIC PRESSURE TEST SHALL BE CARRIED AT 9.2 KG/CM2 FOR 30 MINUTES
2. FLANGES CAN BE FORMED BY ONE PIECE BENDING ALSO. MAXIMUM 4 SEGMENTS ARE ALLOWED FOR FORMING FLANGE
3. REGARDING THE WELDING GROOVE AND LEG LENGTH ONLY REPRESENTATIVE DIMENSIONS ARE INDICATED. OTHER AREA SHALL BE ALSO FIRMLY WELDED
4. DIMENSIONS SHOWN ARE FINISH MACHINED DIMENSIONS.
5. WELDING AS PER BHEL WELD PROCEDURE SPECN NO. WE--001.
6. RAW MATERIAL PROCUREMENT SHALL BE AS PER AA10119, UT TESTED PLATES SHALL BE PROCURED FOR PLATES HAVING MORE THAN OR EQUAL TO 25 MM THICK
7. D.P.T SHALL BE DONE ON 100 % OF WELDS AS PER AA0850131 ACCEPTANCE AS PER AA0850129, LEVEL-IV.
8. SPOT R T TO BE CARRIED OUT ON 10 % OF BUTT WELDS FOR PLATES UPTO 25 MM AS PER THE QUALIFICATION PROCEDURE-ASME SECTION VIII DIV I. UW 52.
9. RT TO BE CARRIED OUT ON 100% BUTT WELD JOINT FOR MORE THAN 25 MM THICK PLATES PER THE QUALIFICATION PROCEDURE-ASME SECTION VIII DIV I. UW 51.
10. UT TO BE CARRIED OUT ON 100% BUTT WELD JOINT FOR MORE THAN 25 MM IF UT IS TO BE DONE IN PLACE OF RT PER THE MANUFACTURER STANDARD PRACTICE.
11. STRESS RELIEVING TO BE DONE AS PER HY0640763
12. SHOT BLASTING TO BE DONE TO REMOVE SCALES, AFTER SHOT BLASTING ONE COAT OF PRIMER TO BE APPLIED WITHIN 2 HOURS
13. WHEREVER NOT SPECIFIED, ALL SHARP EDGES TO BE CHAMFERED TO 2x45°.
14. WHEREVER NOT SPECIFIED TOLERANCE ON MACHINED DIMENSIONS SHALL BE AS PER AA0230208 MEDIUM CLASS.
15. VISUAL INSPECTION SHALL BE CARRIED OUT. THE RECORD SHALL BE SUBMITTED.

1. ALL SURFACES SHALL BE PAINTED WITH TWO COATS (EACH 35 MICRONS THICK, TDFT = 70) OF CHEMICAL RESISTANT EPOXIDE PRIMER PAINT AS PER AA56105. EXCEPT MACHINED SURFACES.

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



DETAIL-'C'

THE FOLLOWING CONDITIONS APPLY
EXCEPT OTHERWISE STATED

1. REF. TO HY0230261 FOR UN
TOLERANCES.
2. CHAMFER M/CD SHARP ED
1.2 TO 1.0 AT 45°.
3. INTERNAL M/CD 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.

 भारत हेवी इलेक्ट्रिकल्स लिमिटेड
हैदराबाद
BHARAT HEAVY ELECTRICALS LTD
HYDERABAD

	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	SATISH	SATISH	10.07.20	
CHD.	SATISH	SATISH	10.07.20	
APPD.	K.H.R.K	K.H.R.K	10.07.20	

DEPT.	PUMPS	
CODE	410	

DRAWING NO.	
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1	182	40	1	700
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1	103	10	1	100
THREE MS 21			NO 65 8	

REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED SATISH	
		CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.	01	12.10.2020	CHECKED SATISH	APPD. MS
ZONE				ZONE				ZONE				ZONE				ZONE				ZONE		POINT NO.6 ADDED UNDER NOTES	