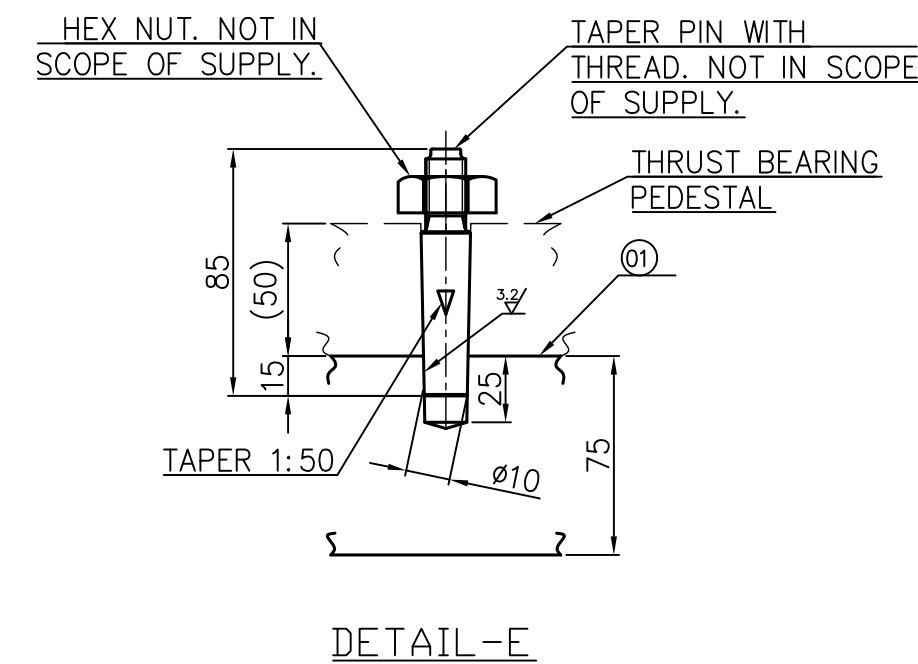
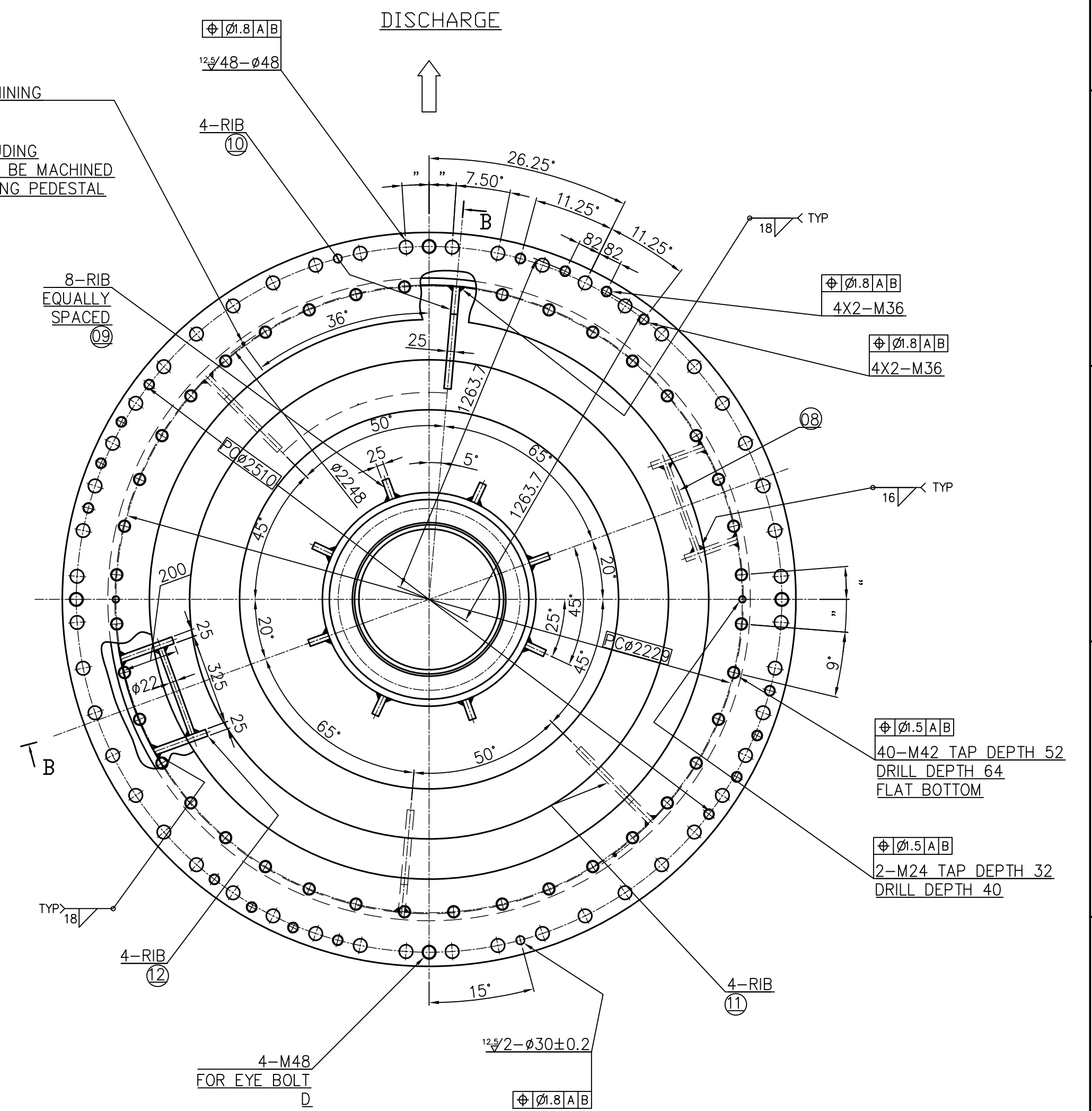


INVENTORY NO	SIGN. AND DATE	REF. DRG. NO.	COMPUTER FILE NAME :
			1 182 35 1 6853 S00 R00



1. THE MANUFACTURER SHALL ADOPT WELDING PROCEDURE SUITABLE FOR SPECIFIED MATERIAL ASTM A516 Gr.70.
2. ITEM NO. ⑪, ⑫ SHALL BE MANUFACTURED EITHER FROM (MAX. NO. 4) AS PER WELD DETAIL—G SHOWN. CARE SHALL BE TAKEN WHILE WELDING SUCH THAT JOINTS DO NOT INTERFERE WITH BOLT AND TAP HOLES.
3. ALL WELDING AREAS SHALL BE CHECKED BY LPI, AS PER ASME SEC. V ARTICLE 6 & 24, AND THE RESULT SHALL CONFIRM TO ASME SEC. VIII DIV.1 APPENDIX 8.
4. PAINTING PROCEDURE SHALL BE REFERRED TO FP13627.

12	RIB	ASTM A516 Gr.70	4
11	RIB	ASTM A516 Gr.70	4
10	RIB	ASTM A516 Gr.70	4
09	RIB	ASTM A516 Gr.70	8
08	Ø 22 ROD	ASTM A516 Gr.70	8
07	SHELL PLATE	ASTM A516 Gr.70	1
06	SHELL PLATE	ASTM A516 Gr.70	1
05	SHELL PLATE	ASTM A516 Gr.70	1
04	SHELL PLATE	ASTM A516 Gr.70	
03	SHELL PLATE	ASTM A516 Gr.70	1
02	BOTTOM FLANGE	ASTM A516 Gr.70	1
01	TOP FLANGE	ASTM A516 Gr.70	1
ITEM NO.	DESCRIPTION	MATERIAL SPECIFICATION	QTY

1. REF. TO HY0230261 FOR UNIFORM 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 हवी इलेक्ट्रिकल्स लिमिटेड हेडक्वार्टर BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		NAME DRN. SUDHEER GHD. MSRAM APPD. K.H.R.K		SIGN. sd- sd- sd-		DATE 30.11.19 30.11.19 30.11.19		NO.OF VAR. 			
DEPT. PUMPS				SCALE N.T.S		WEIGHT (KG) 4036.5		REF. TO ASSY DRG. —NA—		ITEM NO. —NA—		NO.OF ITEMS —NA—	
CODE 410													
TITLE CASING COVER: CV-CWP						DRAWING NO. 1 182 35 1 6853				REV. 00			
						SHEET NO. 01				NO OF SHEETS 01			

REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED		REV.	DATE	ALTERED	
		CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.			CHECKED	APPD.
ZONE				ZONE				ZONE				ZONE				ZONE				ZONE			
1				3				4				5				6				7			