

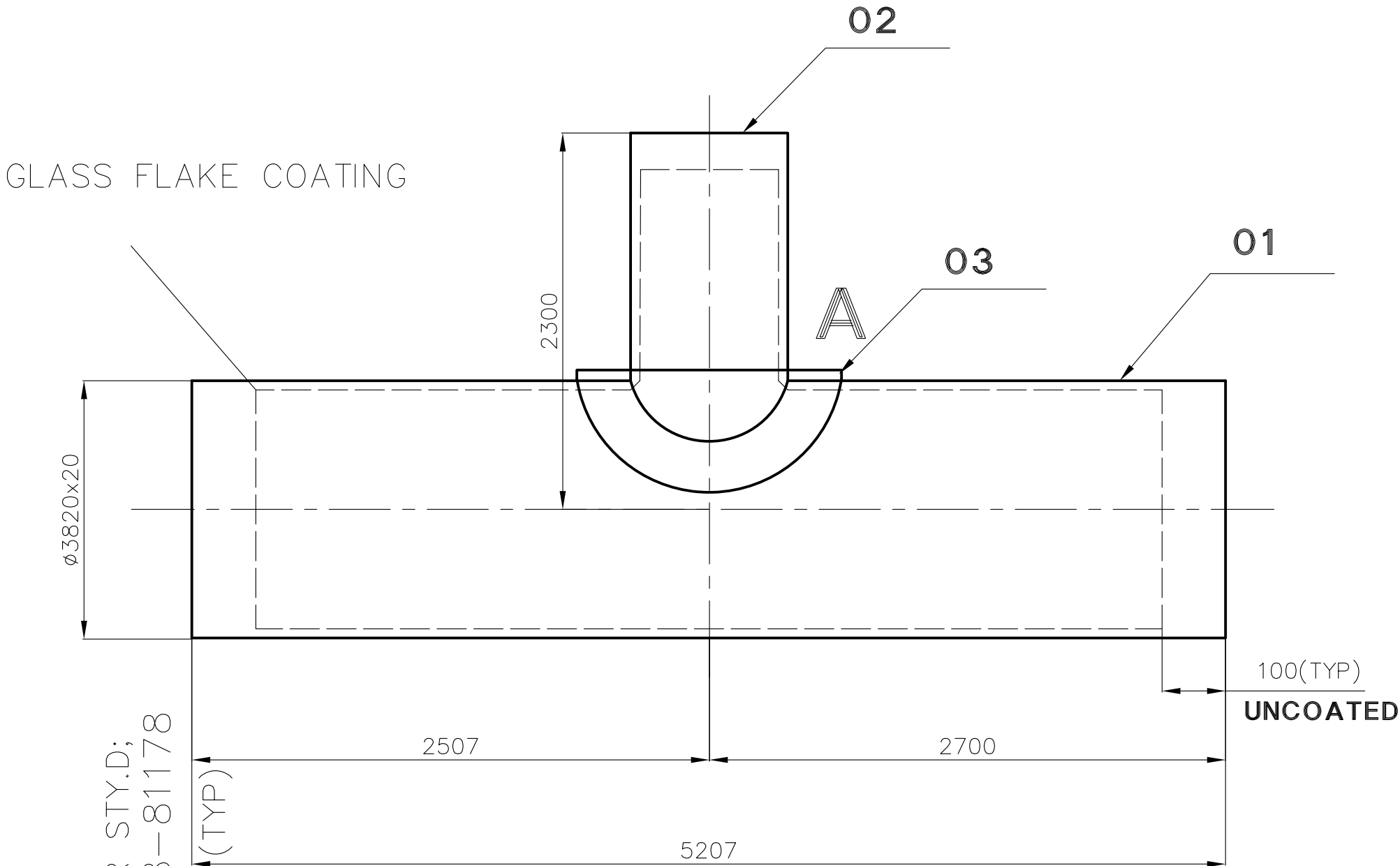
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3-80-468-33953

DRAWING No

NOTES: –

1. PIPE LENGTH INDICATED WITH CUTTING ALLOWANCE TO BE CUT AS PER CUTTING PLAN
2. WELDED PORTIONS SHALL HAVE A UNIFORMLY SMOOTH TOOL FINISH WITHOUT BURRS, WELD SPATTER, CRACKS ETC.
3. FULL PENETRATION OF WELDS TO BE ENSURED
4. SPIDER/LIFTING LUG HAS TO BE WELDED AT SHOP AFTER EDGE PREPARATION.
FOR DETAILS REFER DWG.NO. 3–80–468–33980 (FOR OD2132) , 3–80–468–31263 (FOR OD2540) AND 3–80–468–33979 (FOR OD3820)
5. INTERNAL GLASS FLAKE COATING SHALL BE AS PER APPROVED QUALITY PLAN AND DRAWING 4–80–468–81177
6. GLASS FLAKE COATING SHALL BE DONE AFTER WELDING THE STUBS AND ATTACHMENTS WHEREVER APPLICABLE.

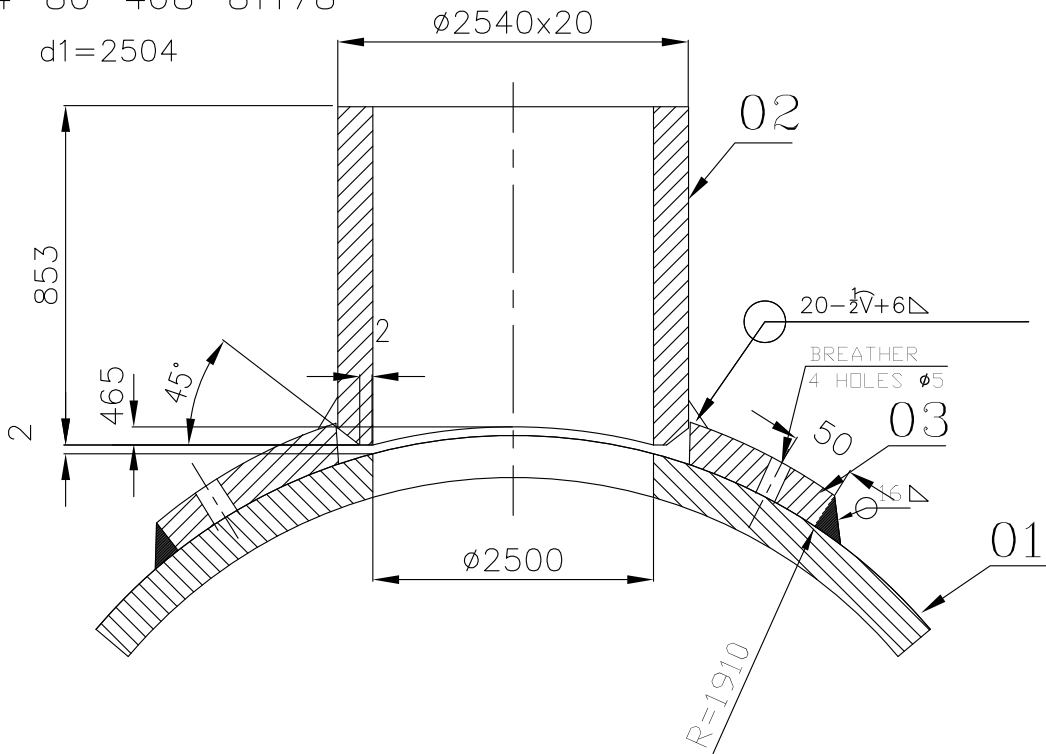


EP AS PER STY.D;
4–80–468–81178

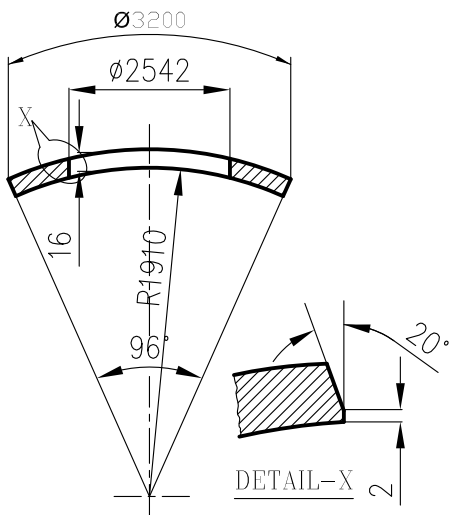
d1=3784 (TYP)

EP AS PER STY.D;
4–80–468–81178

d1=2504



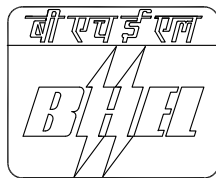
DETAIL – A



DETAIL OF ITEM No.-03

03	PAD PLATE; T=16MM OD3200; ID2542	3–80–468–33953		15 011 026 0000		372	707
				IS 2062 Fe410B			1
02	P.F.PIPE ø2540x20 ; L=853	3–80–468–33906	01	15 011 150 0000		1059	907
				IS 2062 Fe410A			1
01	P.F.PIPE ø3820x20 ; L=5207	3–80–468–33905	20	15 011 150 0000		9757	707
				IS 2062 Fe410A			1
ITEM NO.	DESCRIPTION	DRAWING NO.	ITEM NO.	MATERIAL CODE	A — C	UNIT WT.	
			VAR NO.	MATERIAL SPEC.		QTY.	

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT



BHARAT HEAVY ELECTRICALS LTD.,
PIPING CENTRE,
CHENNAI 600 017

DRN	NAME	SIGN	DATE	NO OF ITEMS
	BABU		16.10.2017	
	SURESH		16.10.2017	
	SESHAGIRI		16.10.2017	

REV 01	DATE	ALTERED APPROVED	DEPT.	GRADE OF UN TOL. DIM		SCALE N.T.S	WEIGHT (Kg).	REF TO ASSY DRG	ITEM No.
ZONE			CODE	C / M / F					
TITLE FABRICATED UNEQT OD 3820/2540							CARD CODE U 01	DRAWING No. 3-80-468-33953	REV 00