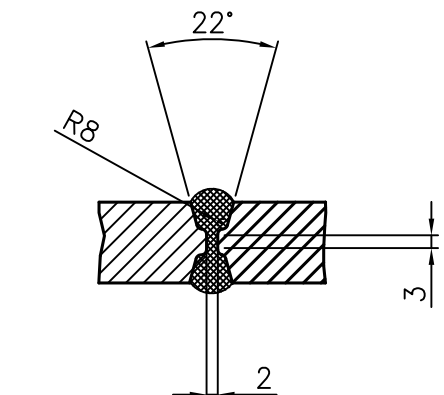
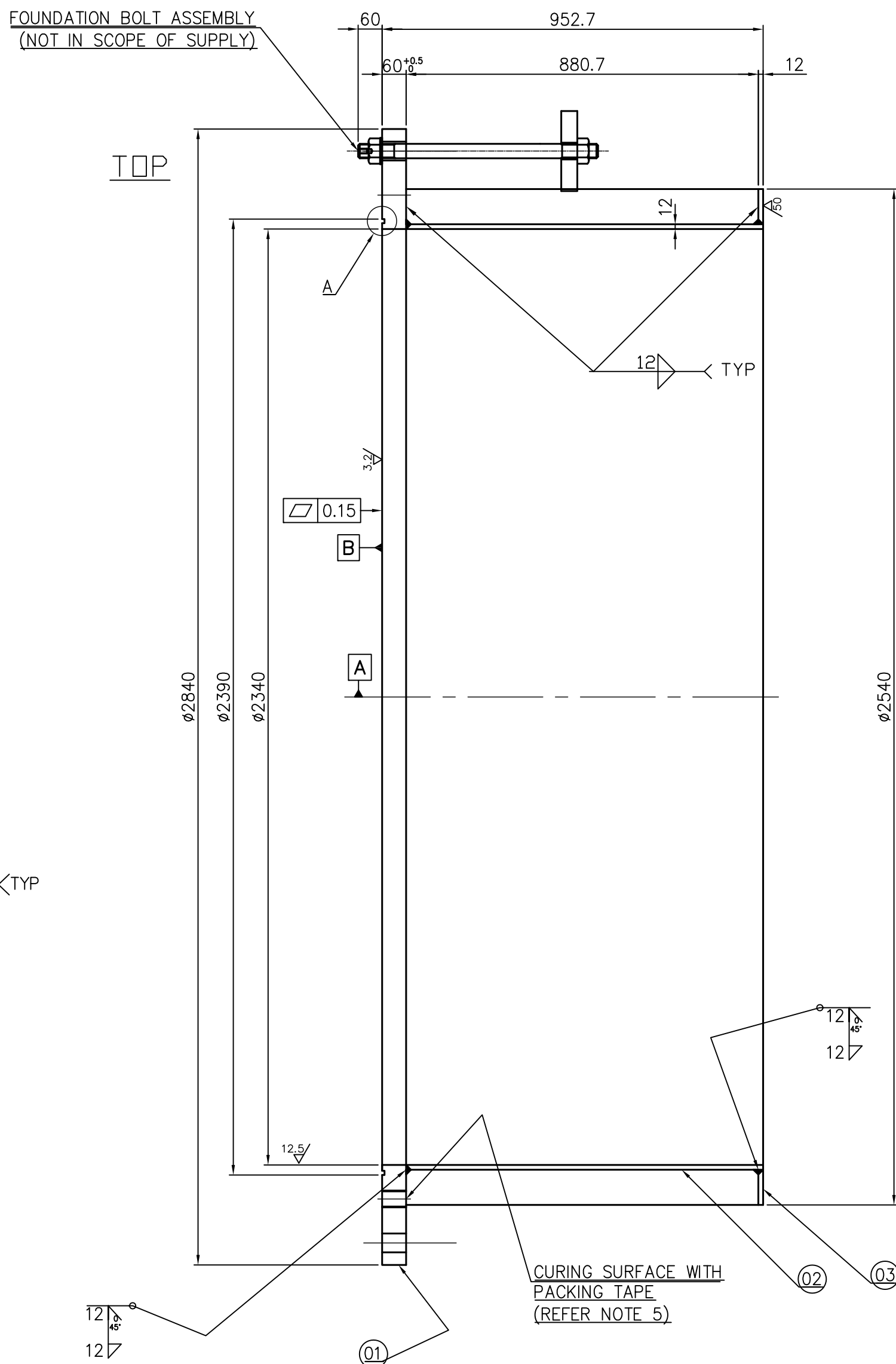
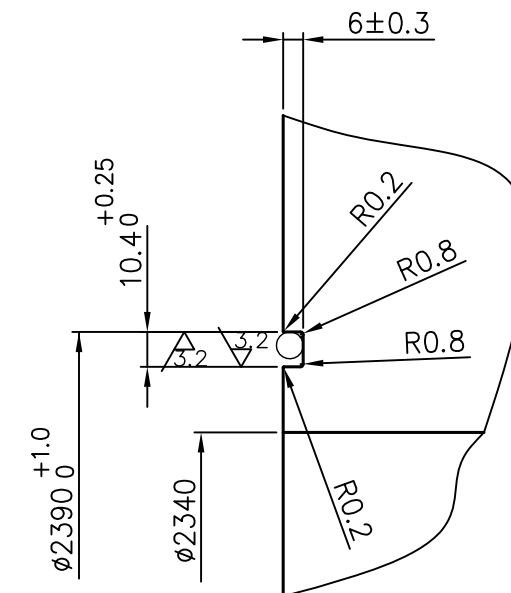


INVENTORY NO	SIGN. AND DATE	REF. DRG. NO.	COMPUTER FILE NAME :
			11826510033 S00 R00



1. THE MANUFACTURER SHALL ADOPT WELDING PROCEDURE SUITABLE FOR SPECIFIED MATERIAL ASTM A105/ A516 Gr.70 AS APPLICABLE.
2. ITEM NO. ⑪ SHALL BE MANUFACTURED EITHER FROM ANNULAR RING OR RING SEGMENTS (MAX. NO. 4) AS PER WELD DETAIL—C SHOWN. CARE SHALL BE TAKEN WHILE WELDING SUCH THAT JOINTS DO NOT INTERFERE WITH BOLT AND TAP HOLES.
3. ALL WELDING AREAS SHALL BE VISUALLY INSPECTED.
4. PAINTING PROCEDURE SHALL BE REFERRED TO FP13627.
5. M42 SCREW HOLES SHALL BE CURED WITH TAPE AT THE TIME DELIVERY, TO PREVENT INTRUSION OF CEMENT INTO THESE HOLES.

04	RIB	ASTM A516 Gr.70	32
03	BOTTOM FLANGE	ASTM A516 Gr.70	1
02	SHELL	ASTM A516 Gr.70	1
01	TOP FLANGE	ASTM A105	1
ITEM No.	DESCRIPTION	MATERIAL SPECIFICATION	QTY.



DETAIL - C

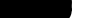
FP9715671020	1860	
ASTM A516Gr.70 + ASTM A105	1	
MATERIAL CODE	NET WT.	GROSS WT.
MATERIAL SPECN.	QUANTITY	

ITEM NO.	DESCRIPTION	DRAWING NO.	VAR. NO.	RAW MATERIAL SIZE OR CASTING DRG.NO. OR FORGING DRG.NO.	MATERIAL CODE	NET WT.	GROSS WT.
					MATERIAL SPECN.	QUANTITY	

THE FOLLOWING CONDITIONS APPLY
EXCEPT OTHERWISE STATED

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.

TYPE OF PRODUCT	MKSV 220C
OR	
NAME OF CUSTOMER/PROJECT	CONCRETE VOLUTE PUMP


भारत हेवी इलेक्ट्रिकल्स लिमिटेड
HYDRABAD
BHARAT HEAVY ELECTRICALS LTD.
HYDRABAD

	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	SUDHEER	-sd-	30.11.19	
CHD.	MSRAM	-sd-	30.11.19	
APPD.	K.H.R.K	-sd-	30.11.19	

DEPT. PUMPS		SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO. OF ITEMS
CODE 410		N.T.S	1860	-NA-	-NA-	-NA-
TITLE PUMP SOLE PLATE: CV-CWP				DRAWING NO.		REV.
				1 182 65 1 0033		00
		SHEET NO. 01		NO OF SHEETS 01		

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.
ZONE				ZONE				ZONE				ZONE				ZONE			

[illegible]