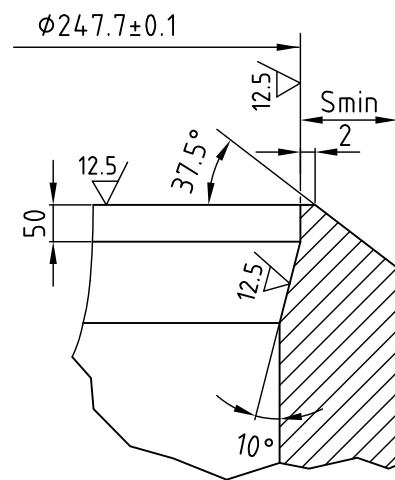


DRG. NO. 3-308-59-00026

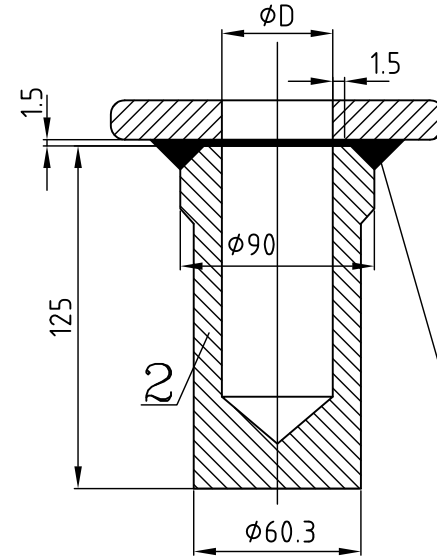
SH.1 OF 1

DETAIL-A

(FOR EDGE PREPARATION AT SITE)

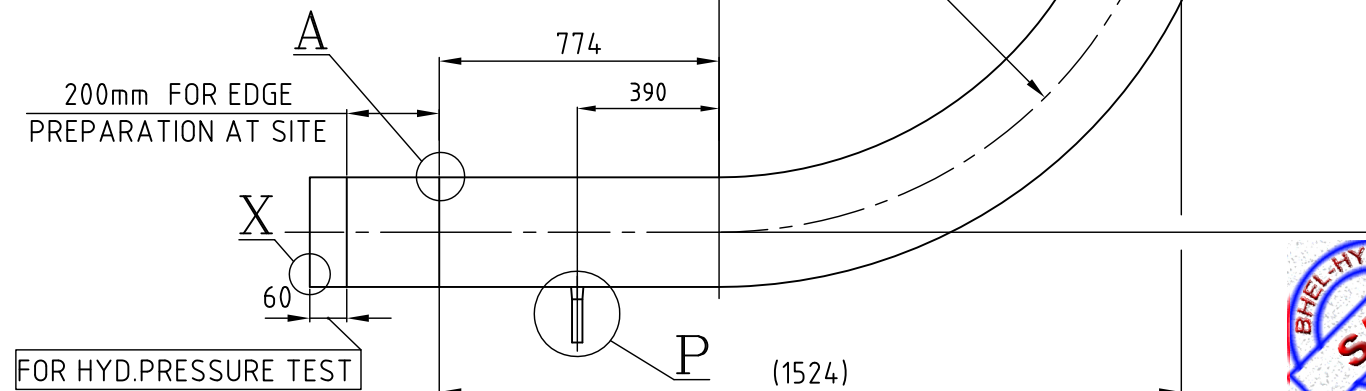
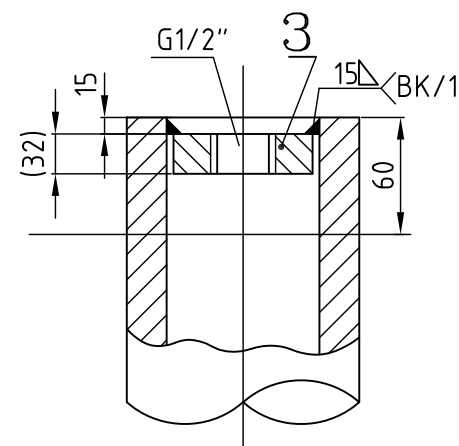


DETAIL-P



CONN. SIZE	ØD	TYPE OF CONNECTION
2"	39	FOR DRAIN CONNECTION

DETAIL-X



NOTES:

1. DESIGN PARAMETERS AS PER VARIANT TABLE.
2. FLOW MEDIUM : STEAM
3. HOT/COLD BENDING TEMP CONTROL SHALL BE AS PLANT STD: HY0640761
4. PIPE THICKNESS OF S_{min} MENTIONED IN VARIANT TABLE TO BE MAINTAINED.
ULTRA SONIC TEST TO BE CONDUCTED AT BENT PORTION.
5. HEAT TREATMENT OF BENDS AS PER PLANT STD: HY0640761.
6. FUSION FACES (EDGE PREPARATION) AS PER PLANT STD: HY0620599
7. 100% DP TEST TO BE CARRIED OUT FOR ALL FILLET WELDS
8. WPS NOS. FOR WELD: WE 145
9. GEN. QUALITY REQUIREMENTS FOR PIPING AS PRODUCT STD: TC 76001
10. MPI TEST AS PER PLANT STD: HY0850197.
11. CLEANING AND PAINTING OF PIPES SHALL BE AS PER PLANT STD: HY0674162,
PAINTING SCHEME 2V4(ALUMINIUM)
12. TO BE HYDRAULICALLY PRESSURE TESTED AS MENTIONED IN VARIANT TABLE.
13. PIPE MATERIAL: SA 335 GrP91, MATL. SPECIFICATION: AA10634.
14. FOR WELDING DETAILS REFER DRG. NO: 3-31300-00484(2 SH.)
15. MANUFACTURING TOLERANCES :-
ON BENDING ANGLE : $\pm 0.5^\circ$
ON DIMENSIONS : $\pm 10\text{mm}$

PIPE DEVELOPED LENGTH = 5473

50 ata./540°C	75 ata	12.7	00
DESIGN PARAMETERS.	HYDRAULIC TEST PRESSURE	Smin	VAR

[illegible]

BHARAT HEAVY ELECTRICALS LTD
HYDERABAD

TD.	NAME	SIGN.	DATE	NO.OF VAR.
DRN.	MEERAVALI		28.04.16	-N.A.-
CHD.	PATIL		28.04.16	
APPD.	ASHOK		28.04.16	

DEPT. I.T.D.	UNTOL. DIMS. GR.		SCALE N.T.S	WEIGHT (KG) 471.8	REF. TO ASSY. DRG. -N.A.-	ITEM NO. -N.A.-	NO.OF ITEMS -N.A.-
CODE 415	C/M/F						
TITLE PIPE BEND (10") BOTTOM RIGHT					CARD CODE N.A.	DRAWING NO. 3-308-59-00076 REV. 00	
					SHT. No 1	NO. OF SHT. 1	