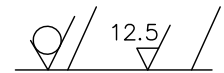
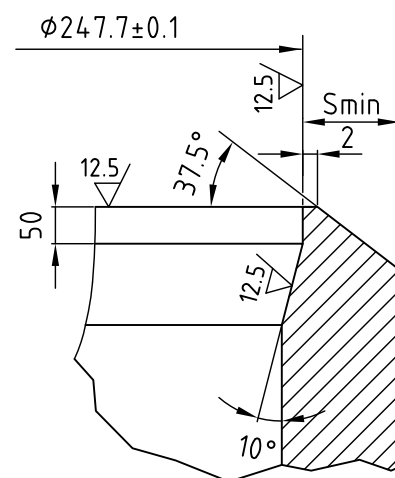
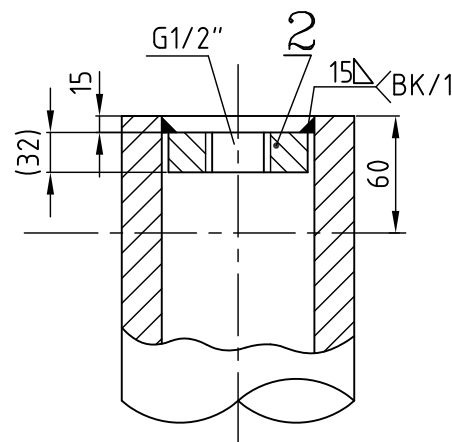


DRG. NO. 3-308-59-00077

SH. 1 OF 1

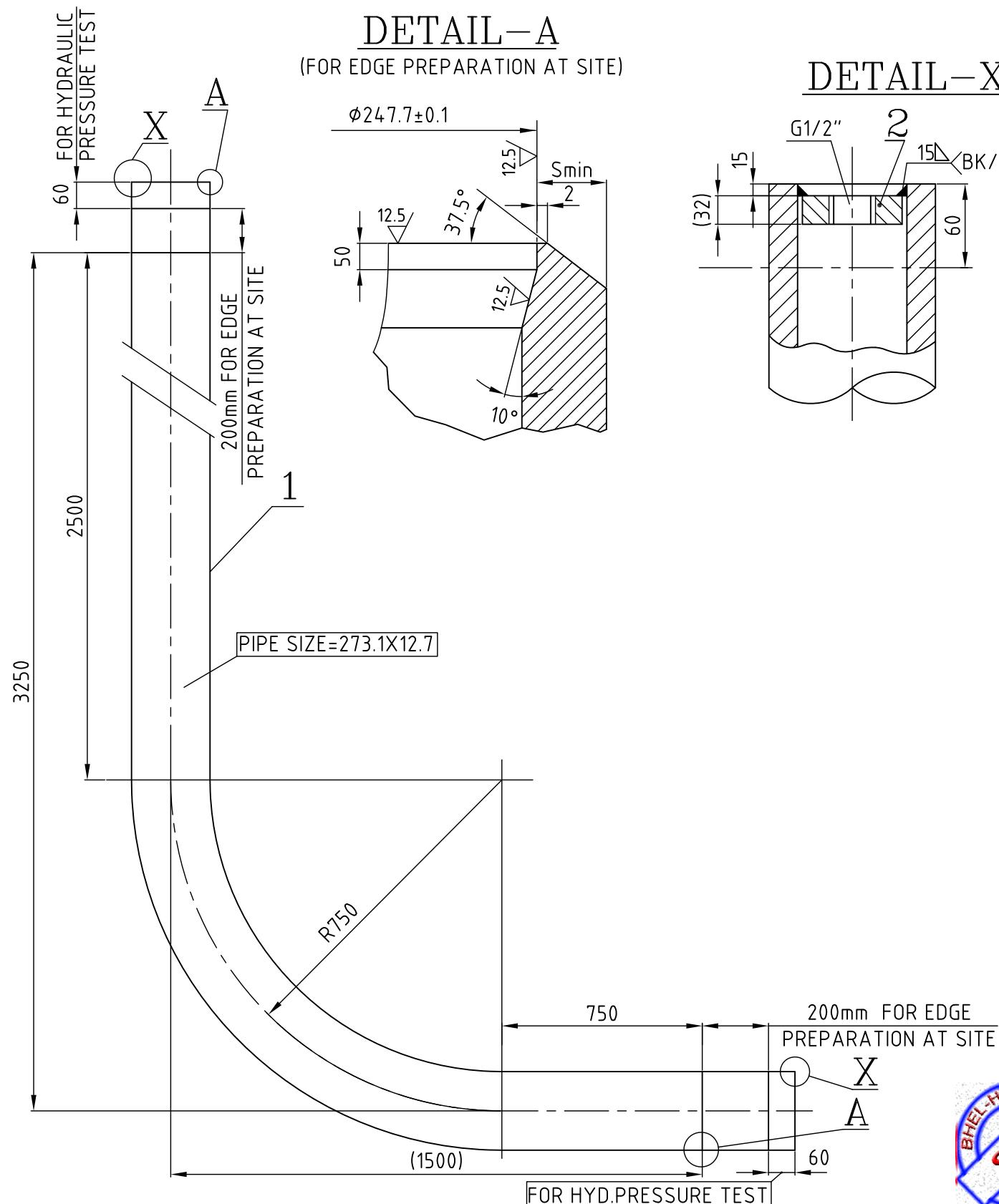
**DETAIL-A**

(FOR EDGE PREPARATION AT SITE)

**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 Smin 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. GEN. QUALITY REQUIREMENTS FOR PIPING AS PRODUCT STD: TC 76001
9. MPI TEST AS PER PLANT STD: HY0850197.
10. CLEANING AND PAINTING OF PIPES SHELL BE AS PER PLANT STD: HY0674162,
PAINTING SCHEME 2V4(ALUMINIUM)
11. TO BE HYDRAULICALLY PRESSURE TESTED AS MENTIONED IN VARIANT TABLE.
12. PIPE MATERIAL: SA 335 GrP91, MATL. SPECIFICATION: AA10634.
13. FOR WELDING DETAILS REFER DRG. NO: 3-31300-00484 (2 SH.)
14. MANUFACTURING TOLERANCES :-
ON BENDING ANGLE : $\pm 0.5^\circ$
ON DIMENSIONS : $\pm 10\text{mm}$

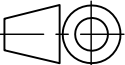
GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261



PIPE DEVELOPED LENGTH = 4950

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

TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

			BHARAT HEAVY ELECTRICALS LTD. HYDERABAD			NAME		SIGN.	DATE	NO. OF VAR.
						DRN.	MEERAVALI		28.04.16	
						CHD.	PATIL		28.04.16	-N.A.-
						APPD.	ASHOK		28.04.16	
DEPT. I.T.D.		UNTOL. DIMS. GR. G/M/F		SCALE N.T.S	WEIGHT (KG) 427.1	REF. TO ASSY. DRG.		ITEM NO.	NO. OF ITEMS	
CODE 415						-N.A.-		-N.A.-	-N.A.-	
TITLE PIPE BEND (10") BOTTOM RIGHT						CARD CODE	DRAWING NO.			REV.
							3-308-59-00077			
						N.A.	SHT. No 1			NO. OF SHT.

SIGN. AND DATE
REF. DRG. NO.
COMPUTER FILE NAME
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