

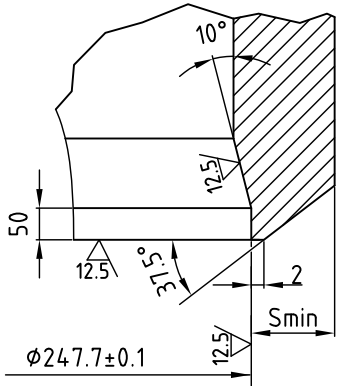
INVENTORY NO
SIGN. AND DATE
REF. DRG. NO.
COMPUTER FILE NAME
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GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261

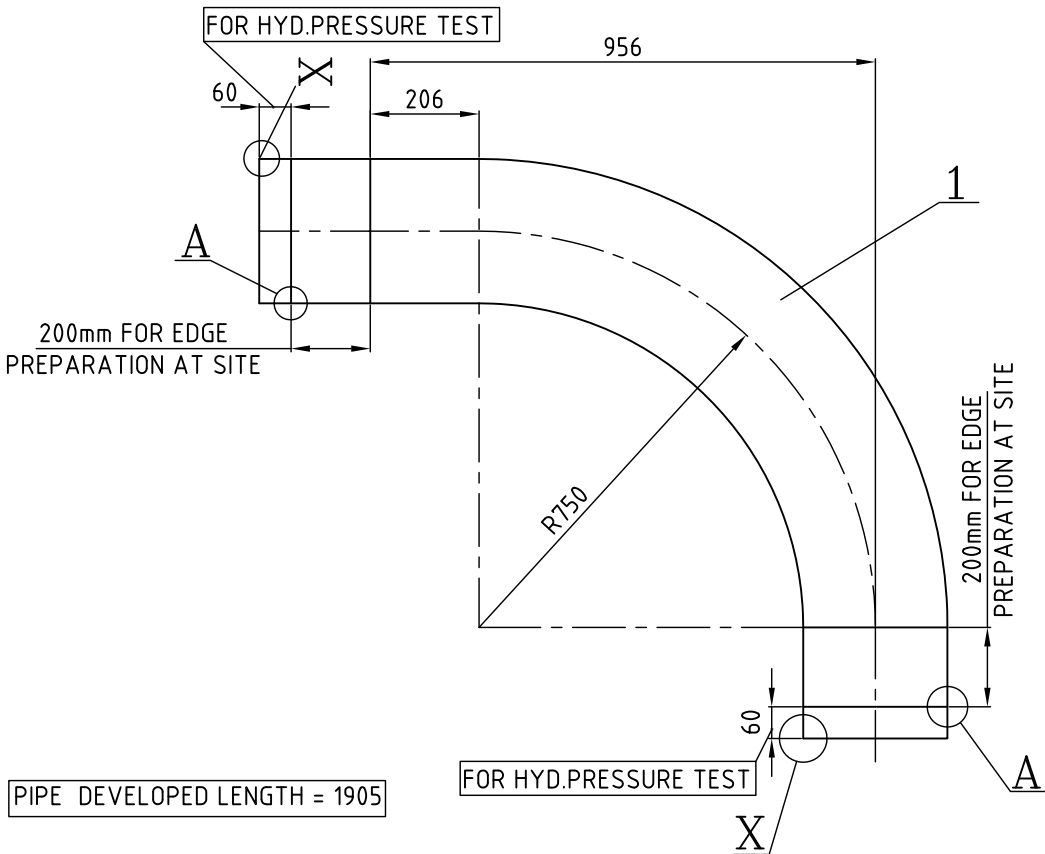
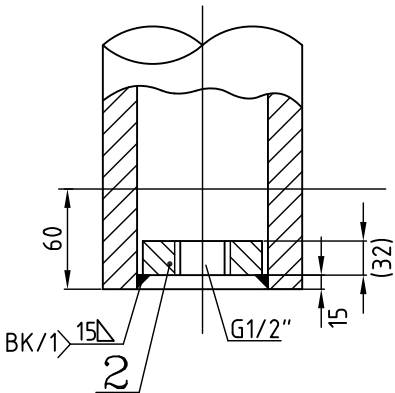
DRG. NO. 3-308-59-00078
SH. 1 OF 1

12.5/

DETAIL-A
(FOR EDGE PREPARATION AT SITE)



DETAIL-X



NOTES:

- DESIGN PARAMETERS AS PER VARIANT TABLE.
- FLOW MEDIUM : STEAM
- HOT/COLD BENDING TEMP CONTROL SHALL BE AS PLANT STD: HY0640761
- PIPE THICKNESS OF Smin MENTIONED IN VARIANT TABLE TO BE MAINTAINED.
ULTRA SONIC TEST TO BE CONDUCTED AT BENT PORTION.
- HEAT TREATMENT OF BENDS AS PER PLANT STD: HY0640761.
- FUSION FACES (EDGE PREPARATION) AS PER PLANT STD: HY0620599
- 100% DP TEST TO BE CARRIED OUT FOR ALL FILLET WELDS
- WPS NOS. FOR WELD: WE 145
- GEN. QUALITY REQUIREMENTS FOR PIPING AS PRODUCT STD: TC 76001
- MPI TEST AS PER PLANT STD: HY0850197.
- CLEANING AND PAINTING OF PIPES SHELL BE AS PER PLANT STD: HY0674162, PAINTING SCHEME 2V4(ALUMINIUM)
- TO BE HYDRAULICALLY PRESSURE TESTED AS MENTIONED IN VARIANT TABLE.
- PIPE MATERIAL:SA 335 GrP91,MATL.SPECIFICATION:AA10634.
- FOR WELDING DETALS REFER DRG.NO:3-31300-00484(2 SH.)
- MANUFACTURING TOLERANCES :-
ON BENDING ANGLE : ± 0.5°
ON DIMENSIONS : ± 10mm

50 ata./540°C	75 ata	12.7	1	00
DESIGN PARAMETERS.	HYDRAULIC TEST PRESSURE	Smin	POS.	VAR

TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

BHEL	BHARAT HEAVY ELECTRICALS LTD.		NAME	SIGN.	DATE	NO.OF VAR.
	HYDERABAD		DRN.	MEERAVALI	28.04.16	
			CHD.	PATIL	28.04.16	
			APPD.	ASHOK	28.04.16	-N.A.-
DEPT. I.T.D.	UNTOL. DIMS. GR. G/M/F	SCALE N.T.S	WEIGHT (KG) 178.7	REF. TO ASSY. DRG. -N.A.-		ITEM NO. -N.A.-
CODE 415						NO.OF ITEMS -N.A.-
TITLE PIPE BEND (10") TOP RIGHT			CARD CODE N.A.	DRAWING NO. 3-308-59-00078		REV. 00
				SHT. No 1	NO. OF SHT.	1