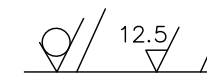


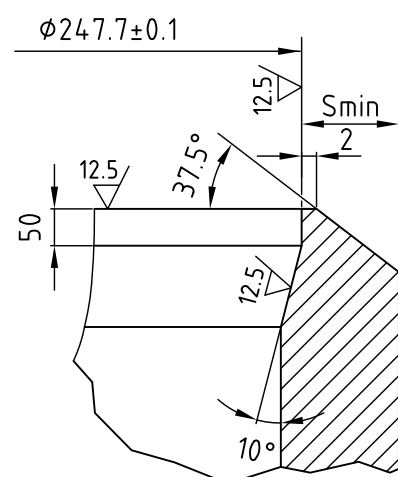
DRG. NO. 3-308-59-00080

SH. 1 OF 1

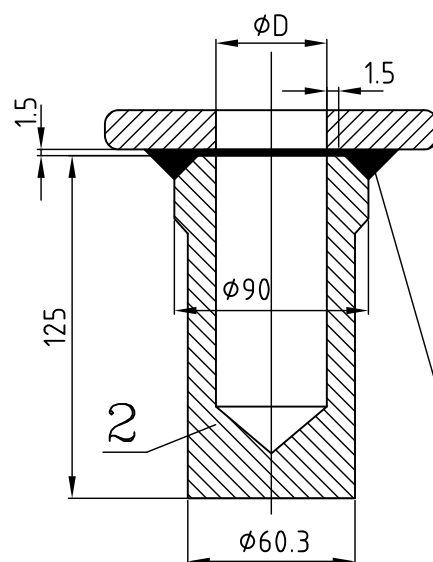


DETAIL-A

(FOR EDGE PREPARATION AT SITE)

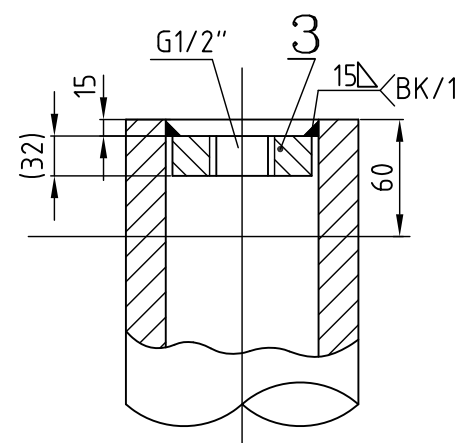


DETAIL-P

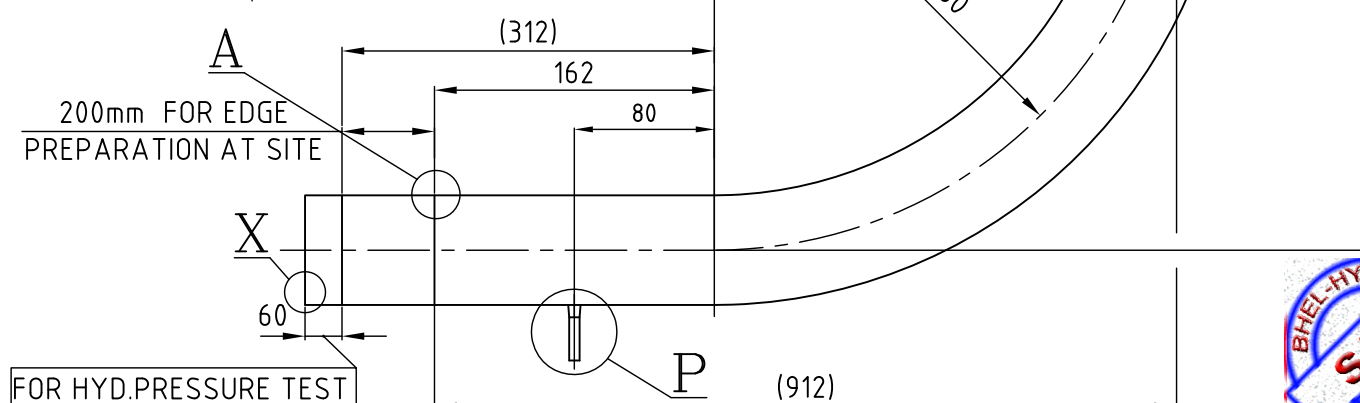


CONN. SIZE	ØD	TYPE OF CONNECTION
2"	39	FOR DRAIN CONNECTION

DETAIL-X



PIPE SIZE=273.1X12.7



NOTES:

- DESIGN PARAMETERS AS PER VARIANT TABLE.
- FLOW MEDIUM : STEAM
- HOT/COLD BENDING TEMP CONTROL SHALL BE AS PLANT STD: HY0640761
- PIPE THICKNESS OF S_{min} 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 DETAILS REFER DRG. NO: 3-31300-00484(2 SH.)
- MANUFACTURING TOLERANCES :-
ON BENDING ANGLE : ± 0.5°
ON DIMENSIONS : ± 10mm

PIPE DEVELOPED LENGTH = 2325

50 ata./540°C	75 ata	12.7	00
DESIGN PARAMETERS.	HYDRAULIC TEST PRESSURE	S _{min}	VAR

TYPE OF PRODUCT OR
NAME OF CUSTOMER/PROJECT

NAME	SIGN.	DATE	NO. OF VAR.
MEERAVALI		28.04.16	
PATIL		28.04.16	-N.A.-
ASHOK		28.04.16	

DEPT. I.T.D.	UNTOL. DIMS. GR. G/M/F	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM NO.	NO. OF ITEMS
CODE 415		N.T.S	215	-N.A.-	-N.A.-	-N.A.-

TITLE	CARD CODE	DRAWING NO.	REV.
PIPE BEND (10°) BOTTOM LEFT	N.A.	3-308-59-00080	00
		SHT. No 1	NO. OF SHT. 1

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

REV.	DATE	ALTERED	REV.	DATE	ALTERED	REV.	DATE	ALTERED
ZONE		CHD/APPD	ZONE		CHD/APPD	ZONE		CHD/APPD

Jul Tue 26 08:45 2016

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