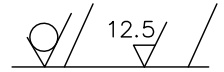
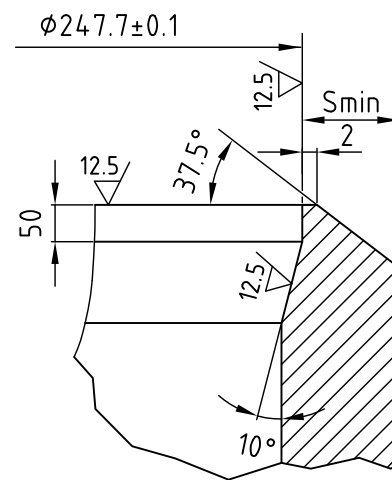
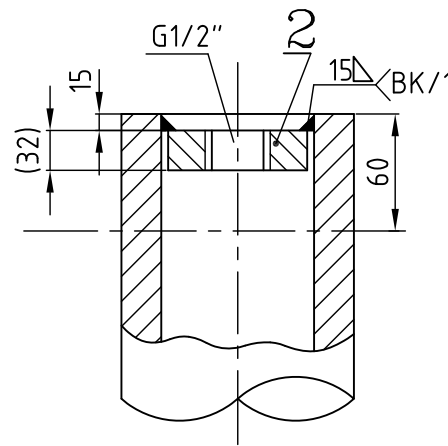


DRG. NO. 3-308-59-00081

SH. 1 OF 1

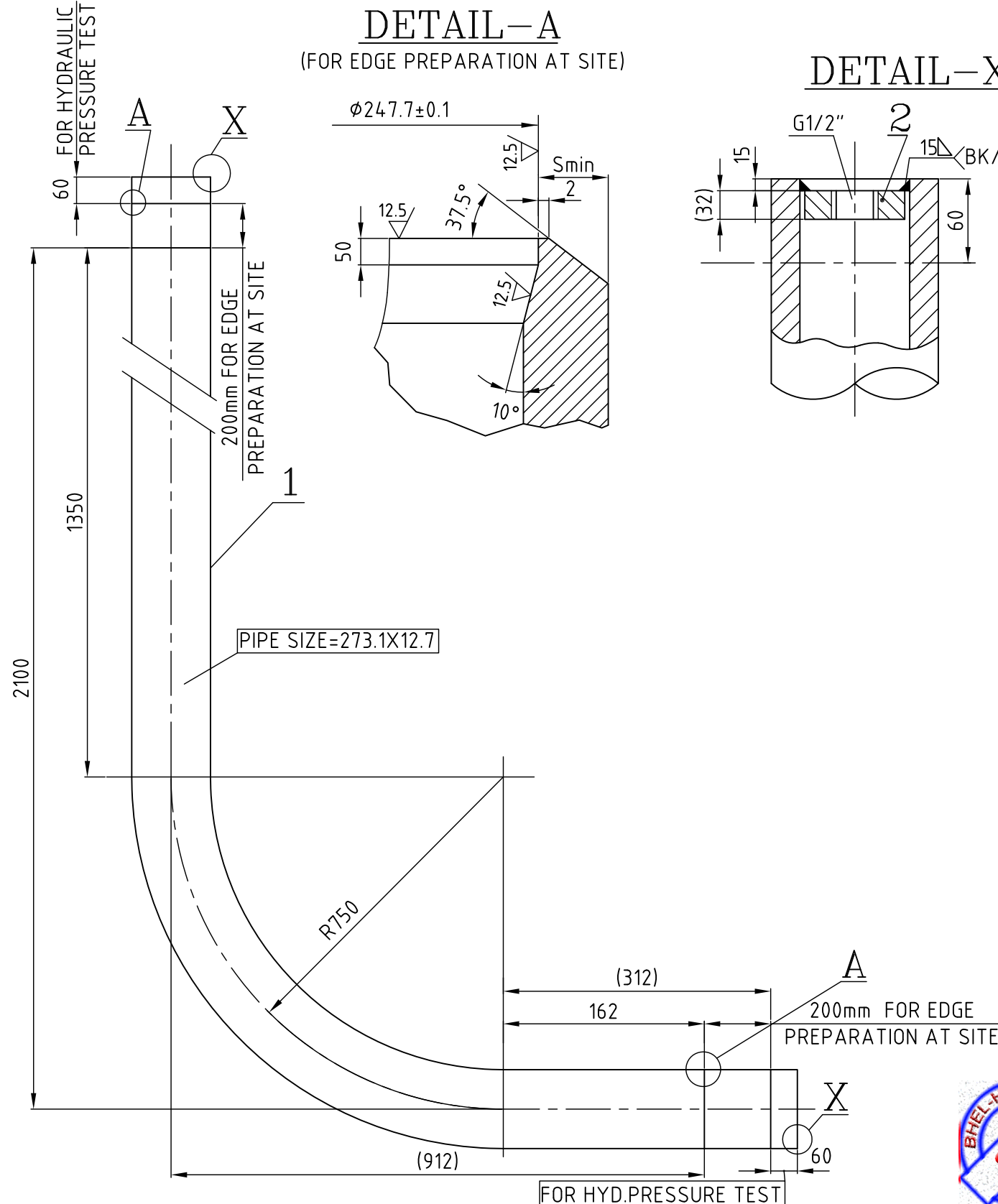
**DETAIL-A**

(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 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. 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 : ± 0.5°
ON DIMENSIONS : ± 10mm

PIPE DEVELOPED LENGTH = 3210



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.
	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) 285.2	REF. TO ASSY. DRG. -N.A.-	ITEM NO. -N.A.-	NO. OF ITEMS -N.A.-
--------------	------------------------	-------------	-------------------	---------------------------	-----------------	---------------------

TITLE PIPE BEND (10") BOTTOM LEFT	CARD CODE N.A.	DRAWING NO. 3-308-59-00081	REV. 00
		SHT. No 1	NO. OF SHT. 1

INVENTORY NO
SIGN. AND DATE
REF. DRG. NO.
COMPUTER FILE NAME
THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY

GENERAL DIMENSIONAL LIMITS, FITS & TOLERANCES AS PER HY0230261

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

Jul Tue 26 08:45 2016

Printed by : G.S.R.REDDY-HM2032 / 1865692 on 19-08-16 09:10:37

This Drawing is printed from Engineering Digital Archive System (EDAS).
Therefore signatures are not essentially required.