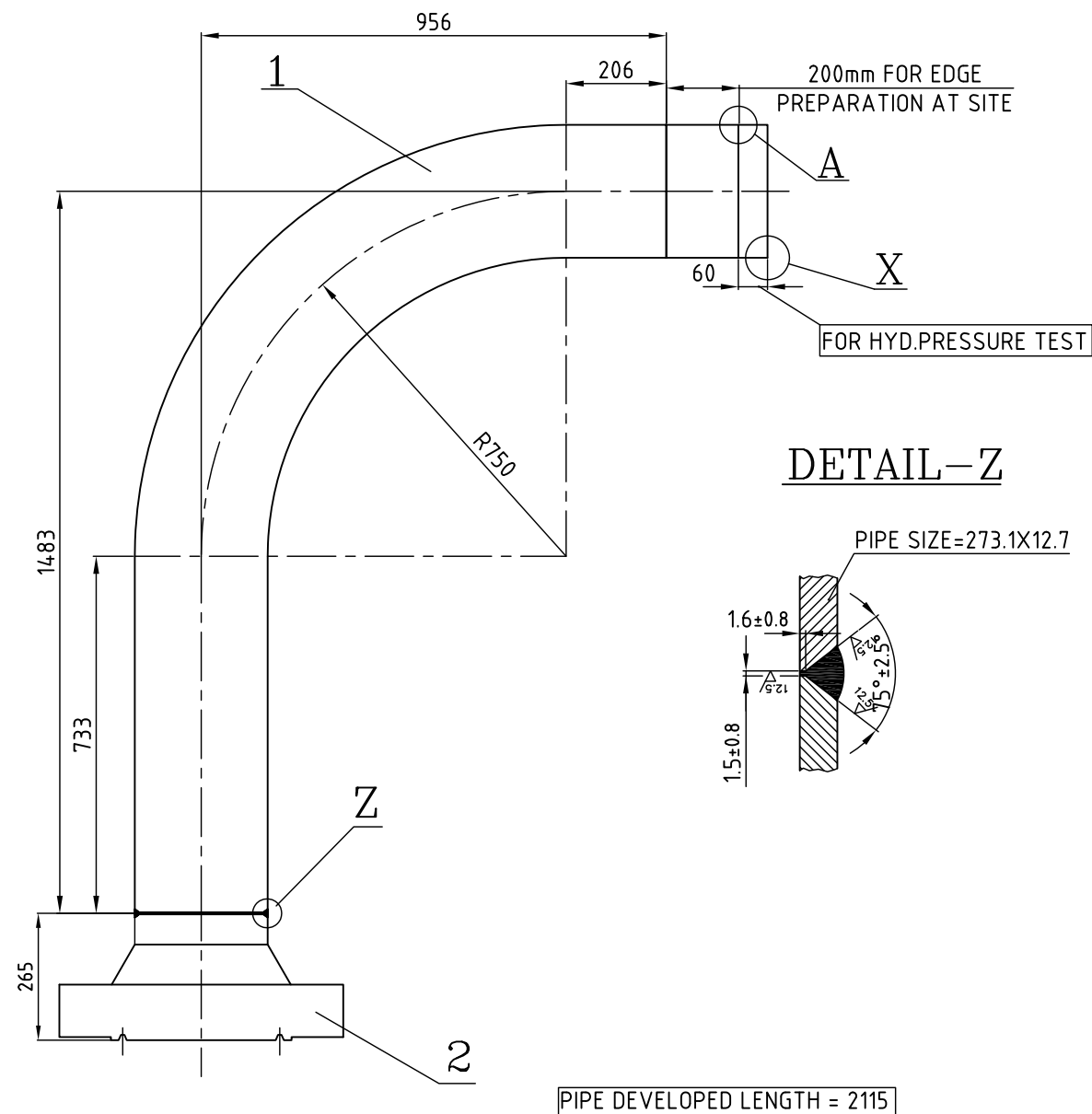
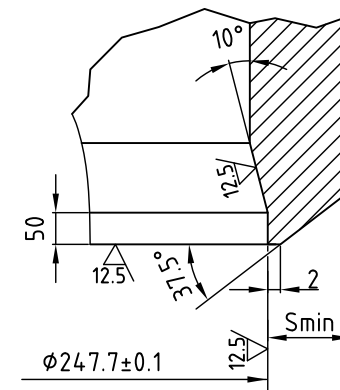


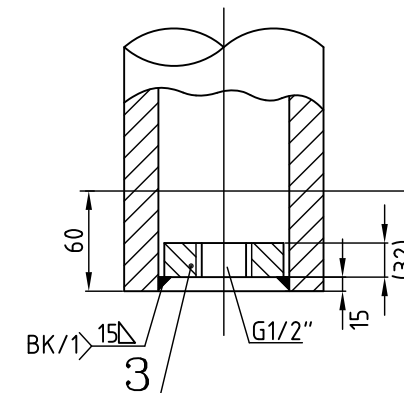
DRG. NO. 3-308-59-00082

SH. 1 OF 1

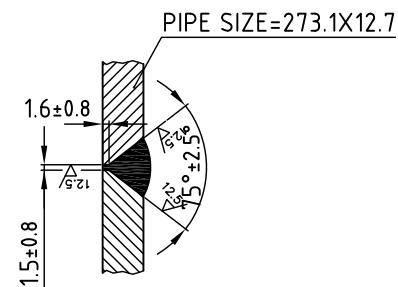
12.5/

DETAIL-A
(FOR EDGE PREPARATION AT SITE)

DETAIL-X



DETAIL-Z



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 DETAILS 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

 BHARAT HEAVY ELECTRICALS LTD. HYDERABAD		NAME	SIGN.	DATE	NO. OF VAR.
		DRN. MEERAVALI		28.04.16	
		CHD. PATIL		28.04.16	
DEPT. I.T.D.		APPD. ASHOK		28.04.16	-N.A.-
CODE 415	UNTOL. DIMS. GR. G/M/F	SCALE N.T.S	WEIGHT (KG) 411	REF. TO ASSY. DRG. -N.A.-	ITEM NO. -N.A.-
TITLE PIPE BEND (10") TOP LEFT			CARD CODE N.A.	DRAWING NO. 3-308-59-00082	REV. 00
			SHT. No 1	NO. OF SHT. 1	

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COMPUTER FILE NAME

REF. DRG. NO.

SIGN. AND DATE

INVENTORY NO

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 08:46 2016

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