

PSGSG/13 -14/18	Product Specifications For DISH ENDS	Drawing No.	RD DG 4 35 0617 0940A
		Date	17.02.15
		Product	GSM245
1.0	Application: The Dish End assembly; Drawing. No. RD DG 4 35 0617 0940A is used for gas filled applications. The gas pressure in this Dish end is to be maintained at 0.5 MPa. The Dish end shall meet the following Specifications.		
2.0	Drawings: : Main Assembly Drawing 1) Dish End-IV : RD DG 4 35 0617 0940A Component / part drawings: Flange :RD DG 435 0617 0941A Dish :RD DG 4 35 0617 0942A		
3.0	Specifications:		
3.1	Material: Low Carbon Austenitic Stainless Steel confirming to AISI-304.		
3.2	Standard seamless or ERW (straight/ spiral) tubular sections shall be used for construction, where ever applicable in design. Fabricated / drawn sections can be used for other areas not confirming to standard pipe schedules.		
1/3	PSGSG/13-14/18.doc		Signature

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3.3	Dish should not be made by rolling and welding process. Dish shall be made with die and to be welded with the flanges. No smithy is allowed for formation/ matching of profiles in view of defect inception. Pipe and flanges shall be TIG / MIG welded with suitable SS electrode.		
3.4	Die shall be made for manufacturing dish and same shall be produced at the time of inspection.		
3.5	The welded sections shall be sized as per drawing and verified /tested using Dye Penetration (D.P.) technique or x-ray at all stages of welding. Inside edges/weld shall be fused to obtain near smooth weld surface.		
3.6	The flanges shall be manufactured to drawings and welded as per instructions to the shells maintaining parallelism of faces and perpendicularity as prescribed. Machining shall be done after welding only. Job will not be accepted in case there is any parallelity/perpendicularity error of PCDs of flanges.		
3.7	The flange sealing surfaces shall be polished to RA 0.8 or better and the bolting holes shall be machined fine, using jig borer/ CNC milling, and shall have uniform chamfer. The tolerances, wherever not mentioned in the drawing, shall be within 0.1°. Any sharp corners shall be removed as per the drawing. Wherever not specified in the drawing, a chamfer of 0.5x45° shall be provided at the sharp corners and edges.		
3.8	Weld splatter, if any, shall be removed by chipping or grinding on completion of the weld.		
3.9	Dye penetration report shall be generated and submitted to BHEL.		
3.10	The tested assembly should be cleaned, degreased and prepared for pressure test. The assembly shall be tested at 8.5 bar pressure for 4 hours and pressure drop shall be recorded and communicated to BHEL. In case of pressure drop a course leak check shall be performed. The leak shall be rectified and the test repeated to satisfaction.		
2/3	PSGSG / 13-14 / 18.doc		Signature

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3.11	Components indicating drop in pressure during this test will not be accepted. The arrangement shall be kept at 13 bar for 15 minutes prior to this test to verify pressure withstanding capabilities specified in drawing.		
3.12	The assemblies further shall be powder coated (> 50 Micron) on the outer surfaces to Siemen's grey shade as specified on drawing .During this operation all flanges shall be masked at the sealing surfaces and at the rim.		
3.13	The dimensional checks and the leak test shall be carried out in presence of BHEL inspector. It is preferable to have first stage inspection after manufacturing of components (Before full welding).		
3.14	The accepted component shall be packed in wooden boxes with suitable covers on the flanges to prevent transit damages. A thick polyethylene cover shall be used to seal to component from ingress of moisture and water. For transit time higher than a week, adequate quantity of moisture absorbent shall also be placed with the component.		
3.15	Following certificates shall be furnished for acceptance of the component: 1. Material certificate. 2. Material test certificate. 3. Stage wise DP / X-ray tests. 4. Pressure withstand test report.		
3.16	A certified copy of above documents shall be sent along with the delivery note.		
3.17	Components / fittings required for pressure test shall be arranged by supplier only.		
4.0	The components shall be guaranteed against all manufacturing defects.		
5.0	Warranty Certificate: All supplied items to be provided with warranty for 12 months from date of receipt and acceptance.		
3/3	PSGSG / 13-14 / 18.doc		Signature