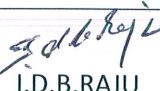
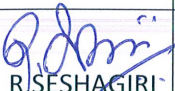
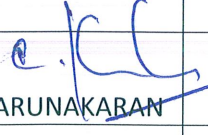


**INFORMATION FOR PROCUREMENT OF LARGE DIA
CARBON STEEL PIPES WITH PU COATING
FOR LP PIPING**

INDEX

1. GENERAL NOTES
2. PIPE SIZE AND QUANTITY
3. PIPE DRAWING WITH DETAILS
4. LIFTING LUG DETAILS
5. EDGE PREPARATION DETAILS
6. PU COATING NEAR BW ENDS
7. SPIDER ARRANGEMENT DETAILS
8. END PROTECTION COVER
9. REFERENCE DOCUMENTS

						BHEL PC DOC NO.
00	05.05.2018	FRESH ISSUE	 I.D.B. RAJU	 R. SESHAGIRI	 C. KARUNAKARAN	PC:E:MAIT:LP:001
REV	DATE	PURPOSE	PREPARED	CHECKED	APPROVED	SHEET 1 OF 10



INFORMATION FOR PROCUREMENT OF LARGE DIA CARBON STEEL PIPES
WITH PU COATING FOR LP PIPING

PROJECT : MAITREE 2x660 MW SUPER THERMAL POWER STATION

CUSTOMER : BIFPCL

UNIT : BHEL-PIPING CENTRE

CUST NO : 7330

SYSTEM: LP PIPING

GENERAL NOTES

1. Quantity indicated is approximate. MM to get confirmation on final quantity before ordering.
2. Pipes (spiral/longitudinal) shall be manufactured and supplied as per TDG 7328:005 (latest revision) / TDG 7328:006 (latest revision)
3. For painting & coating details refer applicable painting scheme for OG (over ground)/UG (under ground)
4. Pipes are coated inside with polyurethane. Refer PU coating specification PC:E:PU:001/Rev 01
5. Pipes are to be supplied with Edge preparation.
6. Spider arrangement has to be provided at the ends
7. Pipes are to be supplied with lifting lug arrangement. Welding of lifting lugs to be done prior to internal PU coating.
8. After coating and painting of each pipe, end protection cover shall be provided at both ends. Protection covers shall be of MS sheet of 2 mm thickness.
9. Weight indicated is bare pip only. It does not include spider arrangement, lifting lug & end protection covers.
10. Vendor should furnish the supplied length details of each pipe while delivery to accommodate the same in Engineering drawing.



INFORMATION FOR PROCUREMENT OF LARGE DIA CARBON STEEL PIPES
WITH PU COATING FOR LP PIPING
PROJECT : MAITREE 2x660 MW SUPER THERMAL POWER STATION
CUSTOMER : BIFPCL
UNIT : BHEL-PIPING CENTRE
CUST NO : 7330
SYSTEM: LP PIPING

**PIPE SIZE AND QUANTITY FOR LARGE DIA PIPES
(NB1200 AND ABOVE) WITH PU COATING**

SL NO	PIPE SIZE	Material Specification	Qty in MR.	WT (Approx) in Tonnes	Supply length	OG/UG*	Tolerance on length	Remarks
1	OD3336 x 18	ASTM A134-A283Gr.D / A515Gr60	800	1177	10 MR	UG	-0.0 & +100 mm	#
2	OD2632 x 16	ASTM A134-A283Gr.D / A515Gr60	480	495	8 MR	UG	-0.0 & +100 mm	#
3	OD1626 x 9.53	ASTM A134-A283Gr.D / A515Gr60	128	49	8 MR	UG	-0.0 & +100 mm	#
4	OD1422 x 9.53	ASTM A134-A283Gr.D / A515Gr60	1472	489	8 MR	UG	-0.0 & +100 mm	#
5	OD1219 x 9.53	ASTM A134-A283Gr.D / A515Gr60	72	20	8 MR	OG	-0.0 & +100 mm	##
6	OD1219 x 9.53	ASTM A134-A283Gr.D / A515Gr60	24	7	8 MR	UG	-0.0 & +100 mm	#
TOTAL				2237				
TOTAL WEIGHT IS 2237 TONNES (Approx.)								

Notes:

For sl no. 3,4,5 and 6, thickness 10mm is acceptable in case of plate formed pipes of A515Gr60

* OG - Refers to Over ground piping and UG – Refers to Under ground piping

- Pipes referred as UG shall be coated outside with epoxy for a thickness of 40 microns as sea worthy transportation protection.

- Pipes referred as OG shall be painted outside as per sl no 4 of painting scheme (latest revision)



INFORMATION FOR PROCUREMENT OF LARGE DIA CARBON STEEL PIPES
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PROJECT : MAITREE 2x660 MW SUPER THERMAL POWER STATION

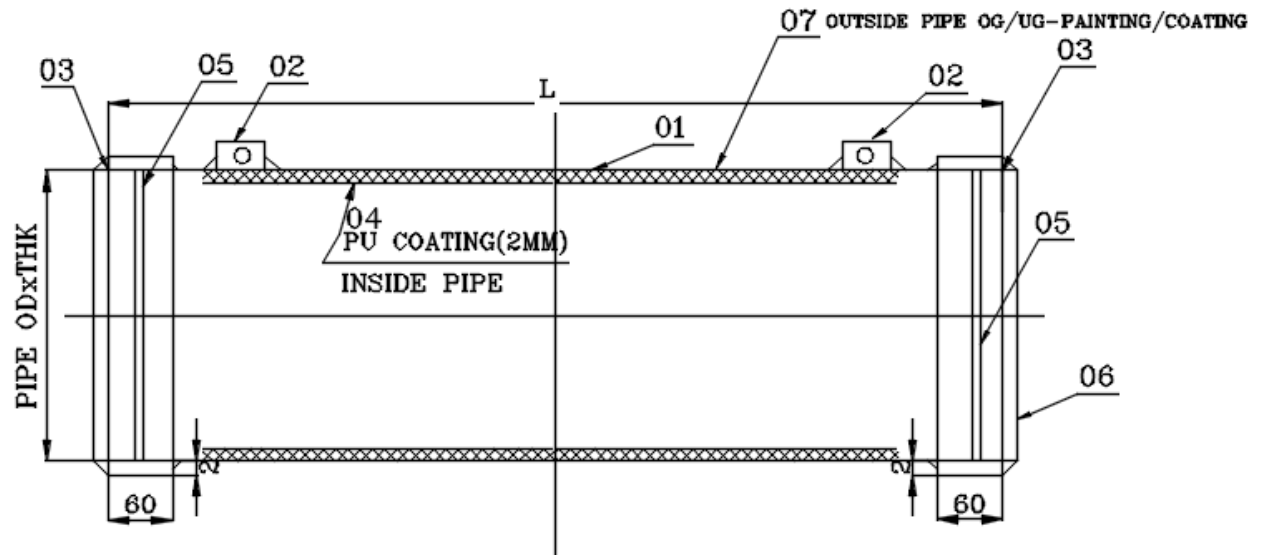
CUSTOMER : BIFPCL

UNIT : BHEL-PIPING CENTRE

CUST NO : 7330

SYSTEM: LP PIPING

PIPE DRAWING WITH DETAILS



1. PIPE OD3336/OD2632/OD1629/OD1422/OD1219
2. LIFTING LUG ARRANGEMENT
3. EDGE PREPARATION
4. INTERNAL PU COATING
5. SPIDER ARRANGEMENT
6. END PROTECTION COVER
7. EXTERNAL PAINTING

L refers to supply length



INFORMATION FOR PROCUREMENT OF LARGE DIA CARBON STEEL PIPES
WITH PU COATING FOR LP PIPING

PROJECT : MAITREE 2x660 MW SUPER THERMAL POWER STATION

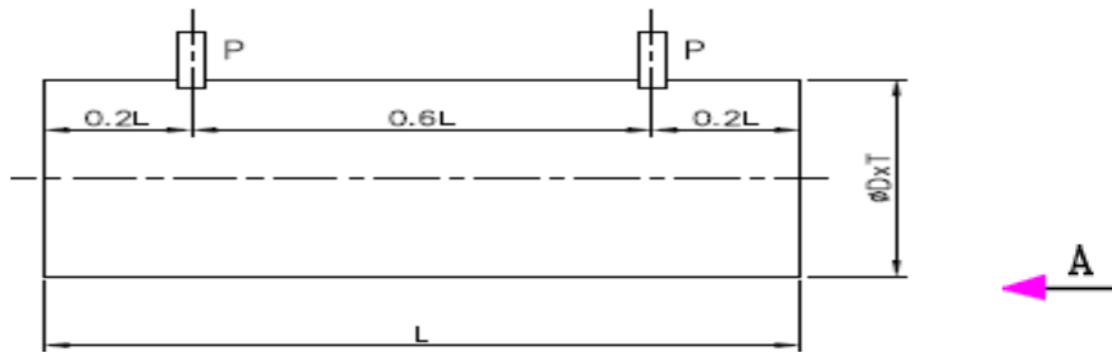
CUSTOMER : BIFPCL

CUST NO : 7330

UNIT : BHEL-PIPING CENTRE

SYSTEM: LP PIPING

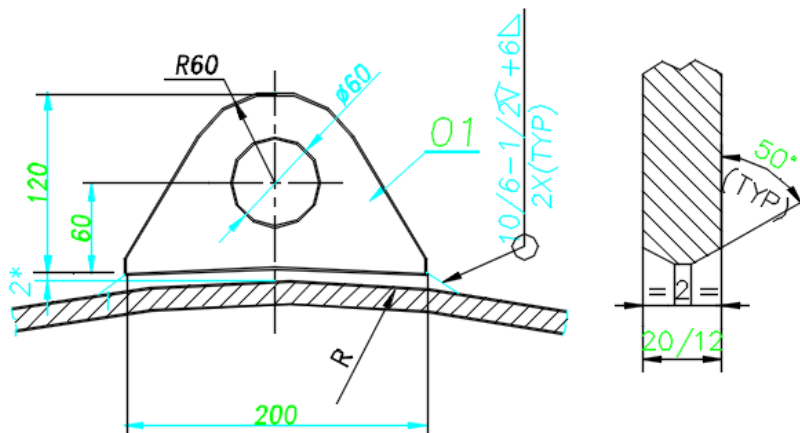
LIFTING LUG DETAILS FOR PIPE > NB1500



STRAIGHT PIPE

VIEW - A

* LIFTING LUG SHALL BE CUT TO SUIT THE OUTER SURFACE OF THE MAIN PIPE SUCH THAT A UNIFORM GAP OF 2MM IS MAINTAINED GAP THROUGHOUT



DETAIL - P

NOTES:-

1. MATERIAL FOR LIFTING LUG IS TEMPORARY MATERIAL WHICH WILL BE CUT AND REMOVED AT SITE.HENCE THIS MATERIAL IS NOT COVERED IN GMS AND HAS TO BE PROVIDED BY SUB CONTRACTOR.
2. LIFTING LUG THICKNESS SHALL BE 20MM FOR PIPE THK>15MM AND 12MM FOR PIPE THK <15MM

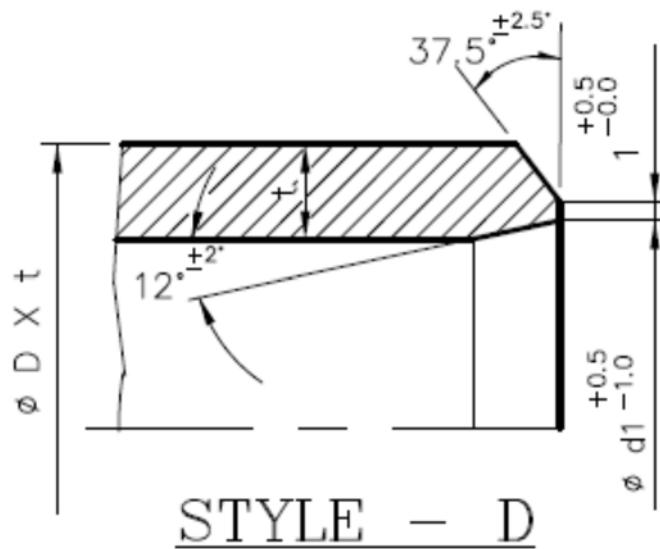


INFORMATION FOR PROCUREMENT OF LARGE DIA CARBON STEEL PIPES
WITH PU COATING FOR LP PIPING

PROJECT : MAITREE 2x660 MW SUPER THERMAL POWER STATION
CUSTOMER : BIFPCL
UNIT : BHEL-PIPING CENTRE

CUST NO : 7330
SYSTEM: LP PIPING

EDGE PREPARATION DETAILS

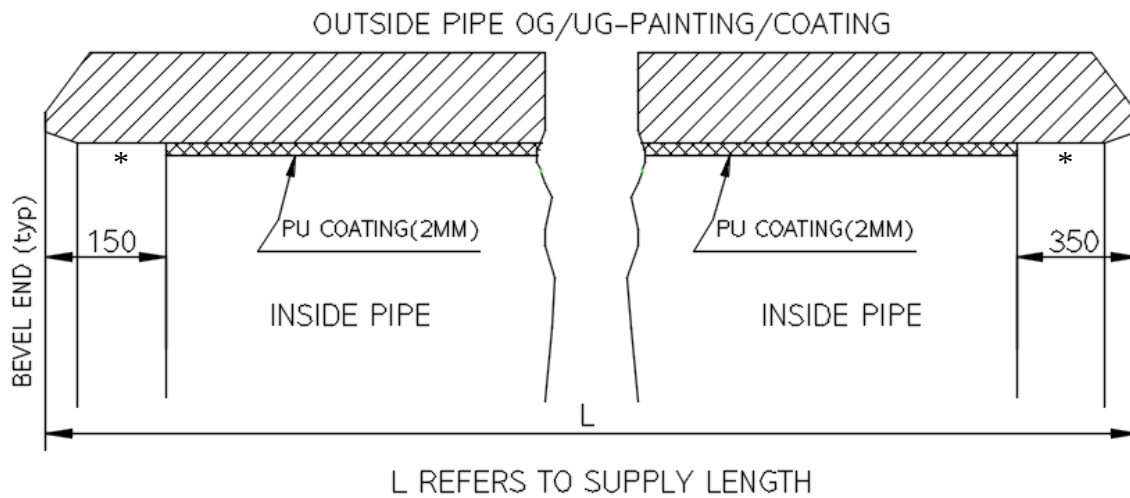


Sl no	D x t	d1 in mm
1	OD 3336 X 18	3302
2	OD 2632 X 16	2602
3	OD 1626 X 9.53	1609
4	OD 1422 X 9.53	1405
5	OD 1219 X 9.53	1202



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UNIT : BHEL-PIPING CENTRE
CUST NO : 7330
SYSTEM: LP PIPING

PU COATING NEAR BW ENDS



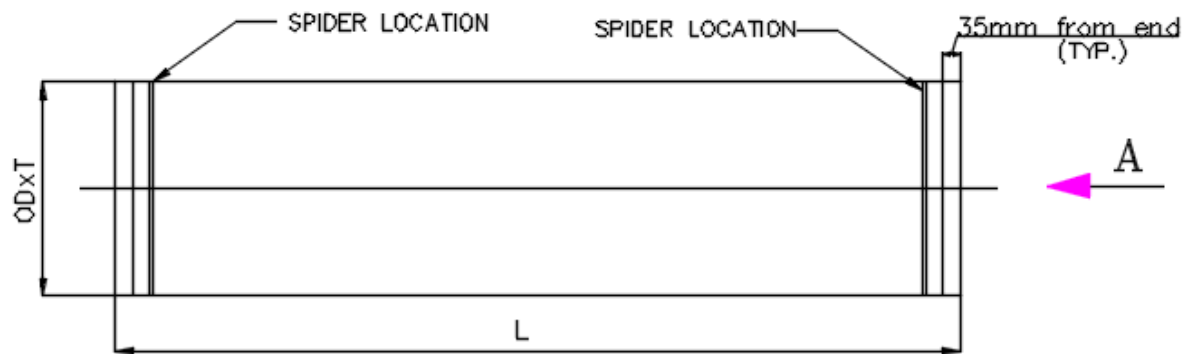
* Area to be protected with tape for final coating at site



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PROJECT : MAITREE 2x660 MW SUPER THERMAL POWER STATION
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UNIT : BHEL-PIPING CENTRE
CUST NO : 7330
SYSTEM: LP PIPING

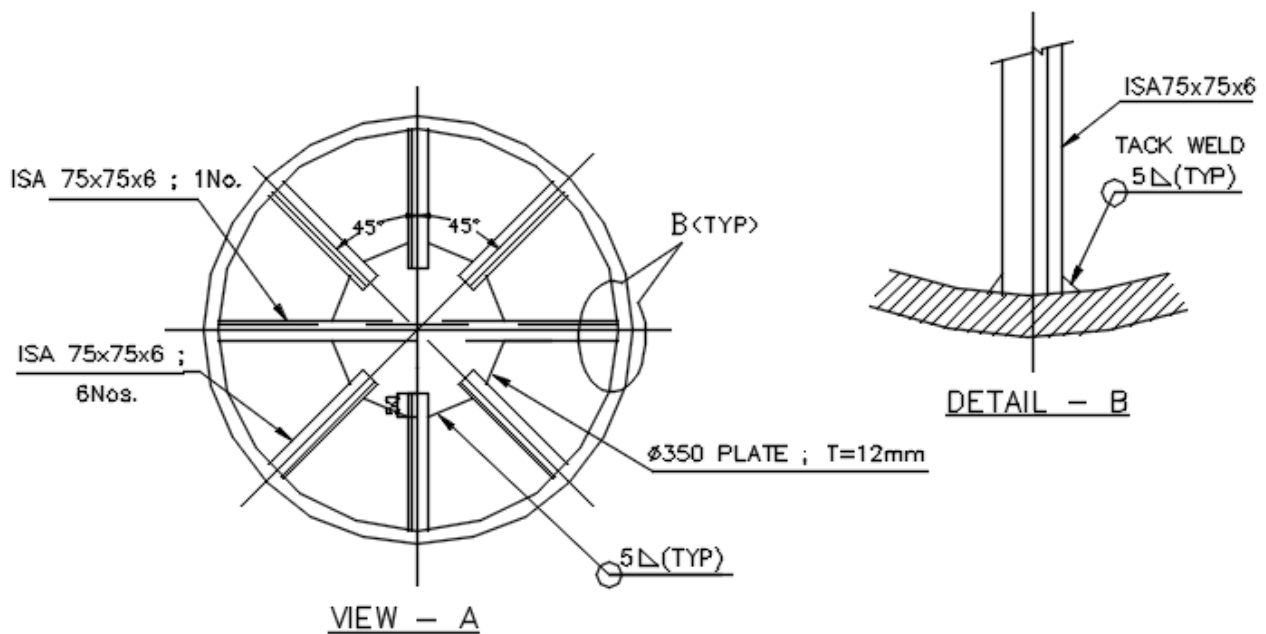
SPIDER ARRANGEMENT DETAILS

SPIDER ARRANGEMENT FOR PIPES > NB1000



PIPE WITH SPIDER ARRANGEMENT

(2 LOCATIONS IN A PIPE)





INFORMATION FOR PROCUREMENT OF LARGE DIA CARBON STEEL PIPES
WITH PU COATING FOR LP PIPING

PROJECT : MAITREE 2x660 MW SUPER THERMAL POWER STATION

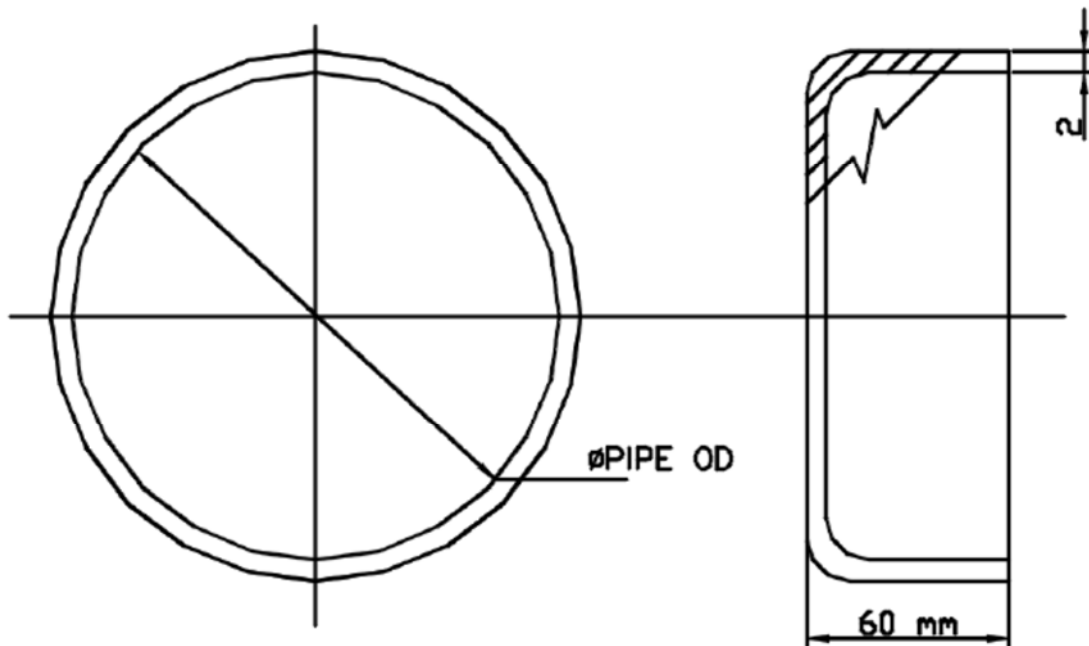
CUSTOMER : BIFPCL

UNIT : BHEL-PIPING CENTRE

CUST NO : 7330

SYSTEM: LP PIPING

END PROTECTION COVER



1. End protection cover shall be from MS plate of 2mm thickness (min)
2. End protection cover shall be fixed after coating and painting of pipes
3. The end protection cover shall be tack welded on both ends of the pipe at 0°, 90 °, 180 ° and 360 ° positions



INFORMATION FOR PROCUREMENT OF LARGE DIA CARBON STEEL PIPES
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PROJECT : MAITREE 2x660 MW SUPER THERMAL POWER STATION

CUSTOMER : BIFPCL

CUST NO : 7330

UNIT : BHEL-PIPING CENTRE

SYSTEM: LP PIPING

REFERENCE DOCUMENTS

- Applicable TDG (TDG 7328:005/Latest revision and TDG 7328:006/Latest revision)
for the pipes
- Approved painting scheme (7328:QPC:12/Latest revision)
- Specification for PU coating (PC:E:PU:001/Rev 01)
- Applicable packing & shipping details (PC:CML:MAITREE:DI:001)