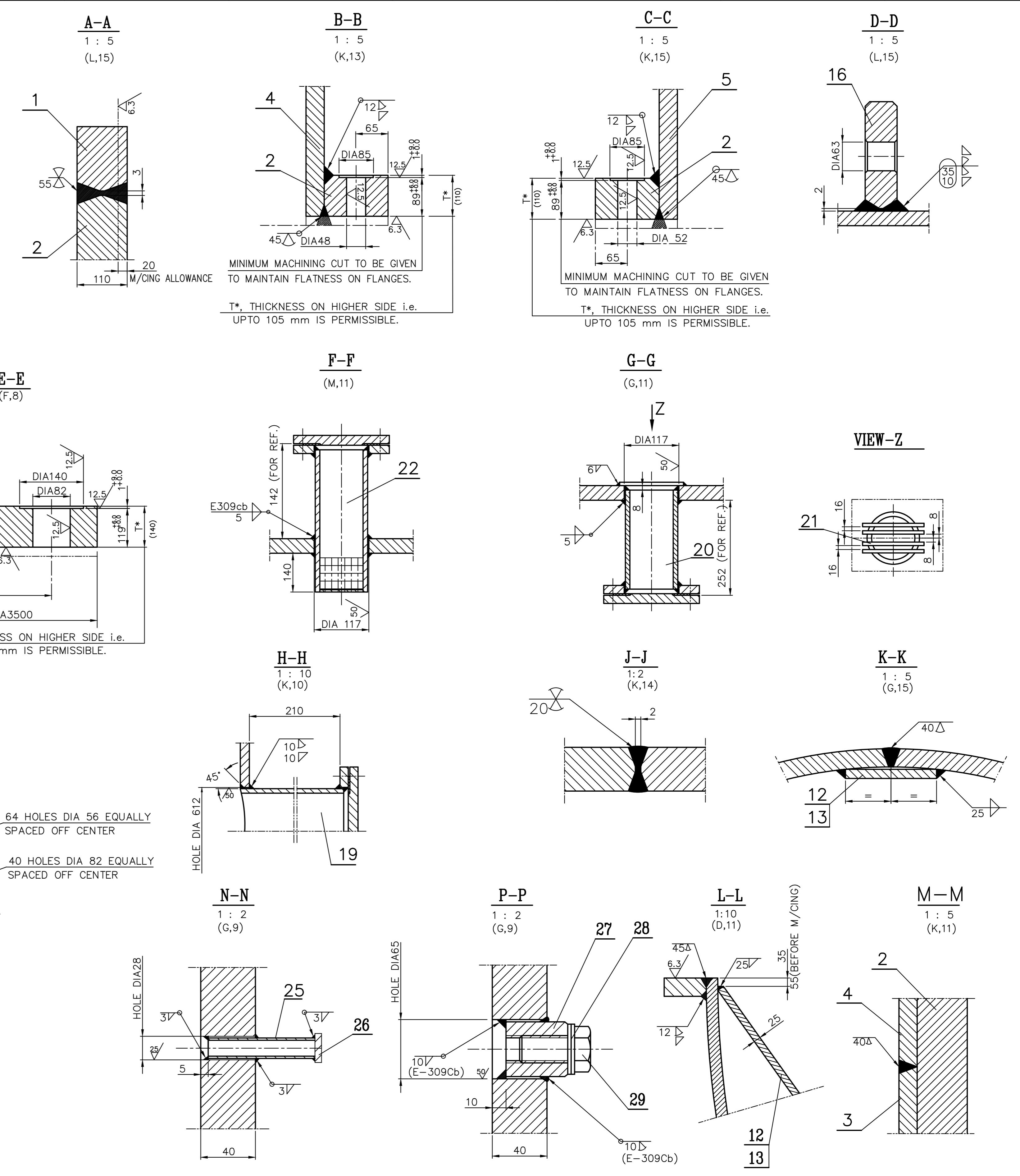
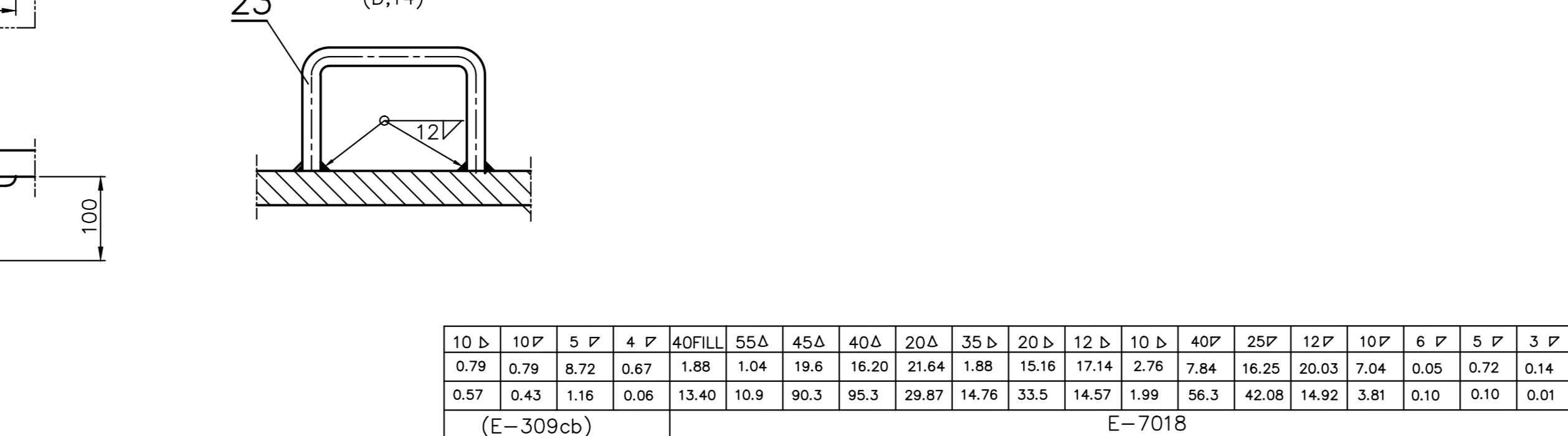
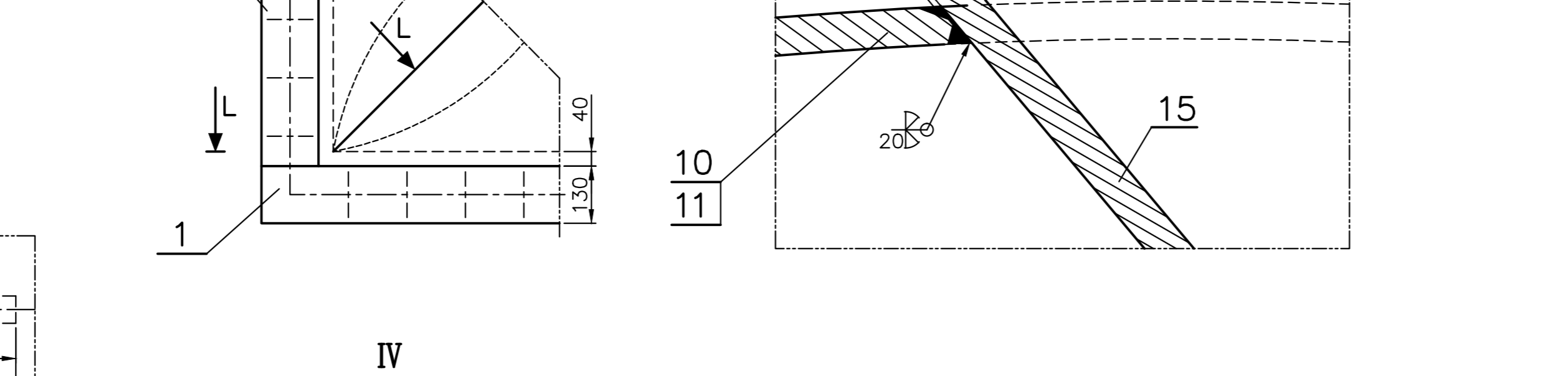
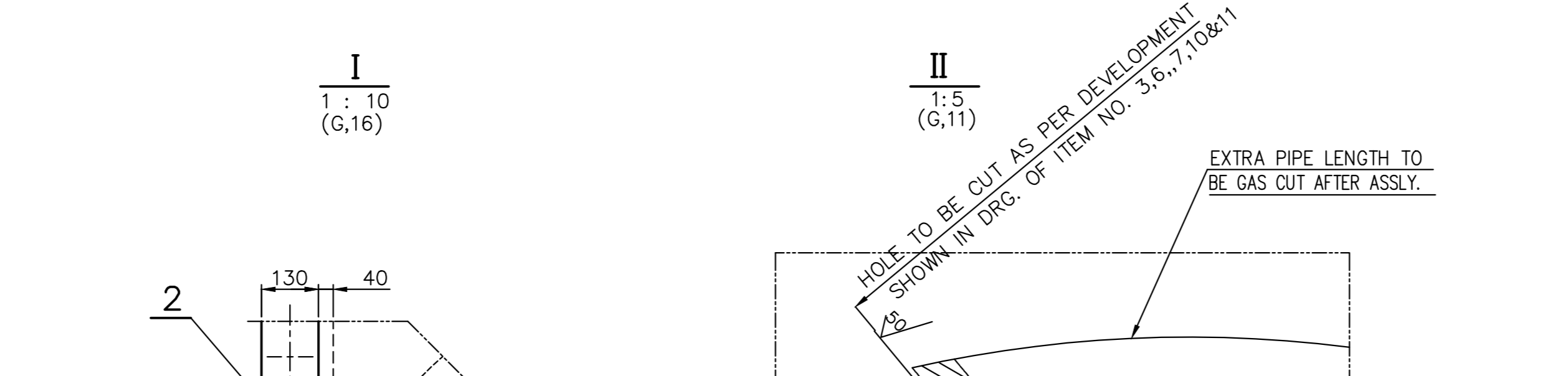
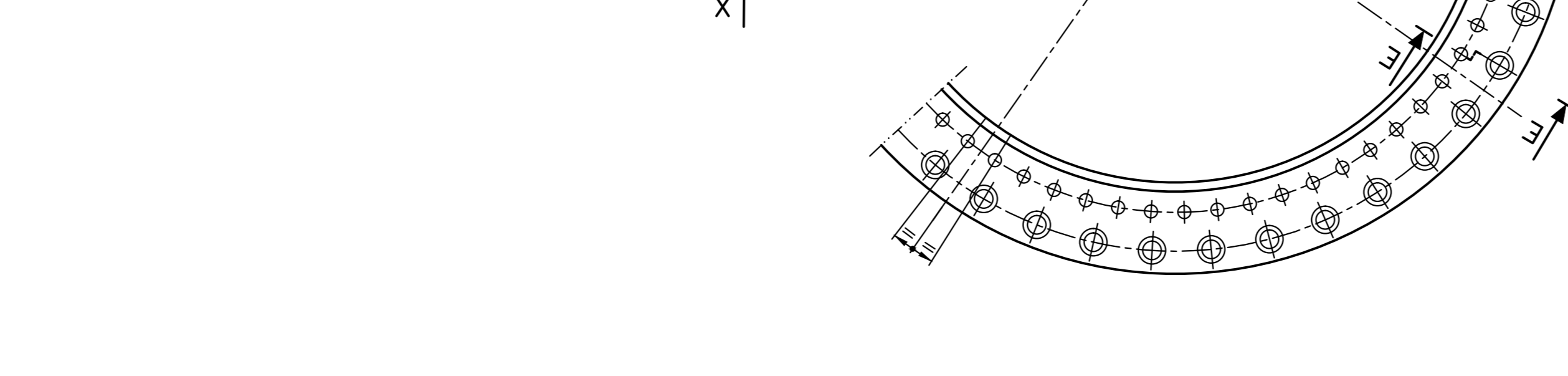
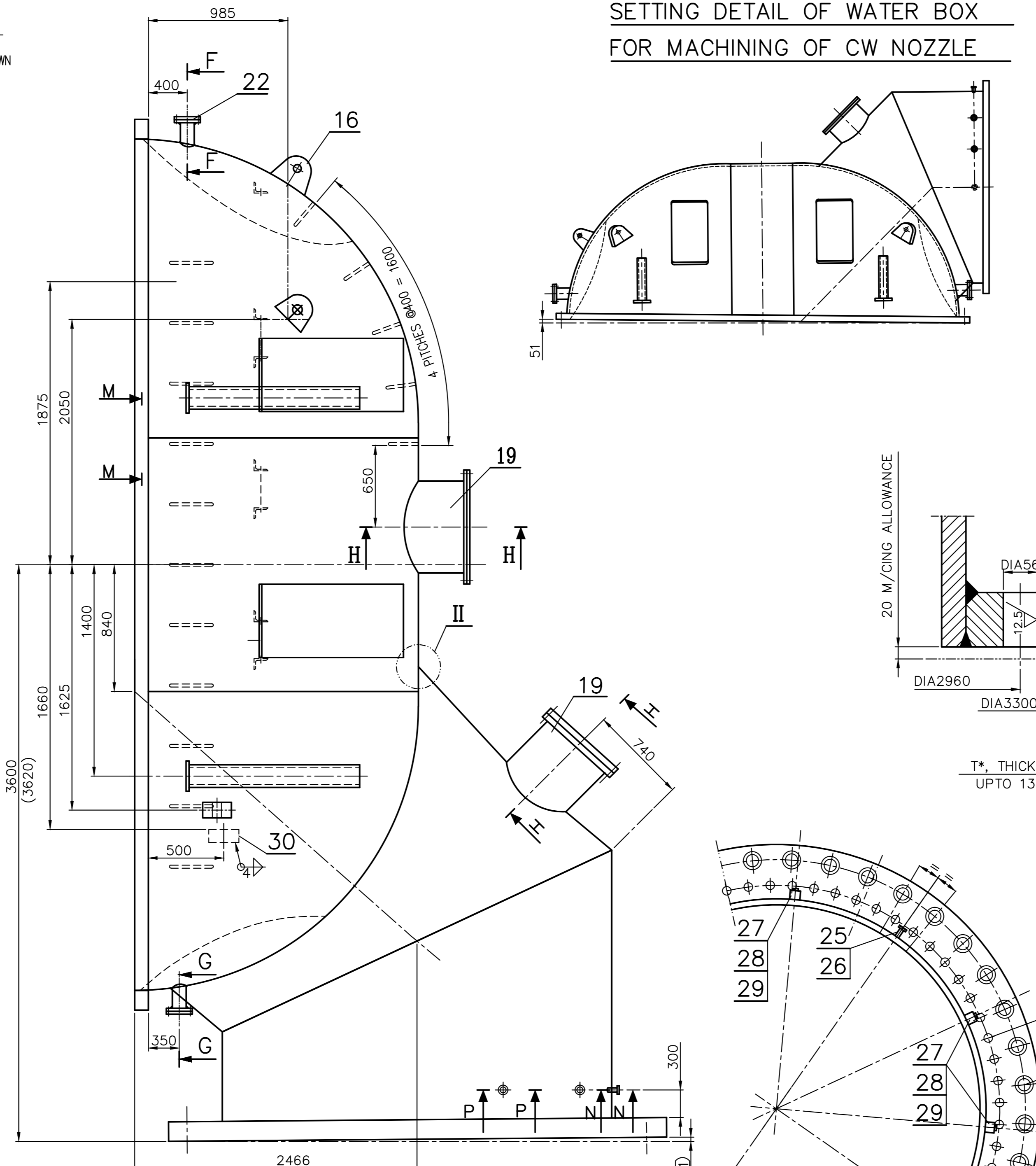
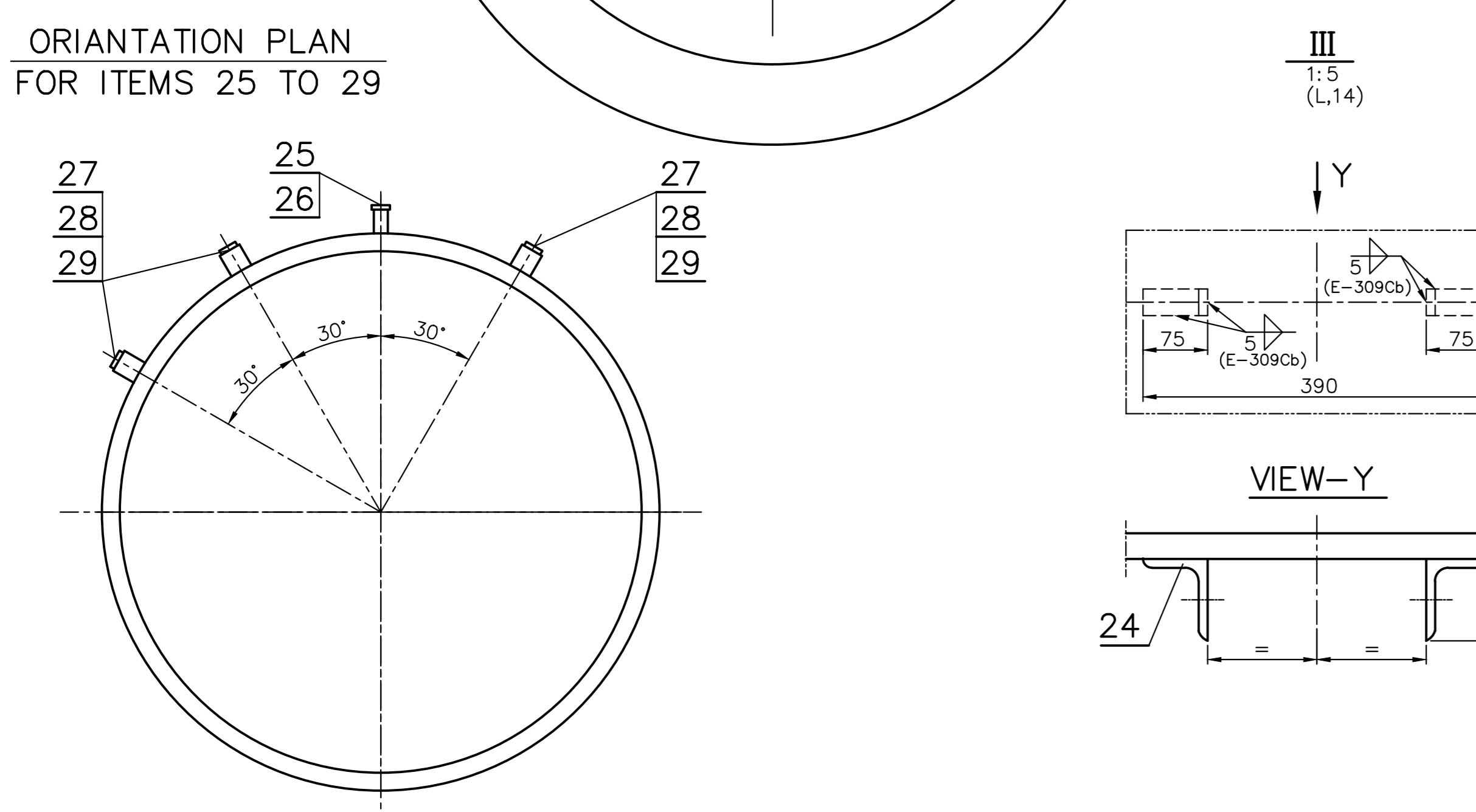
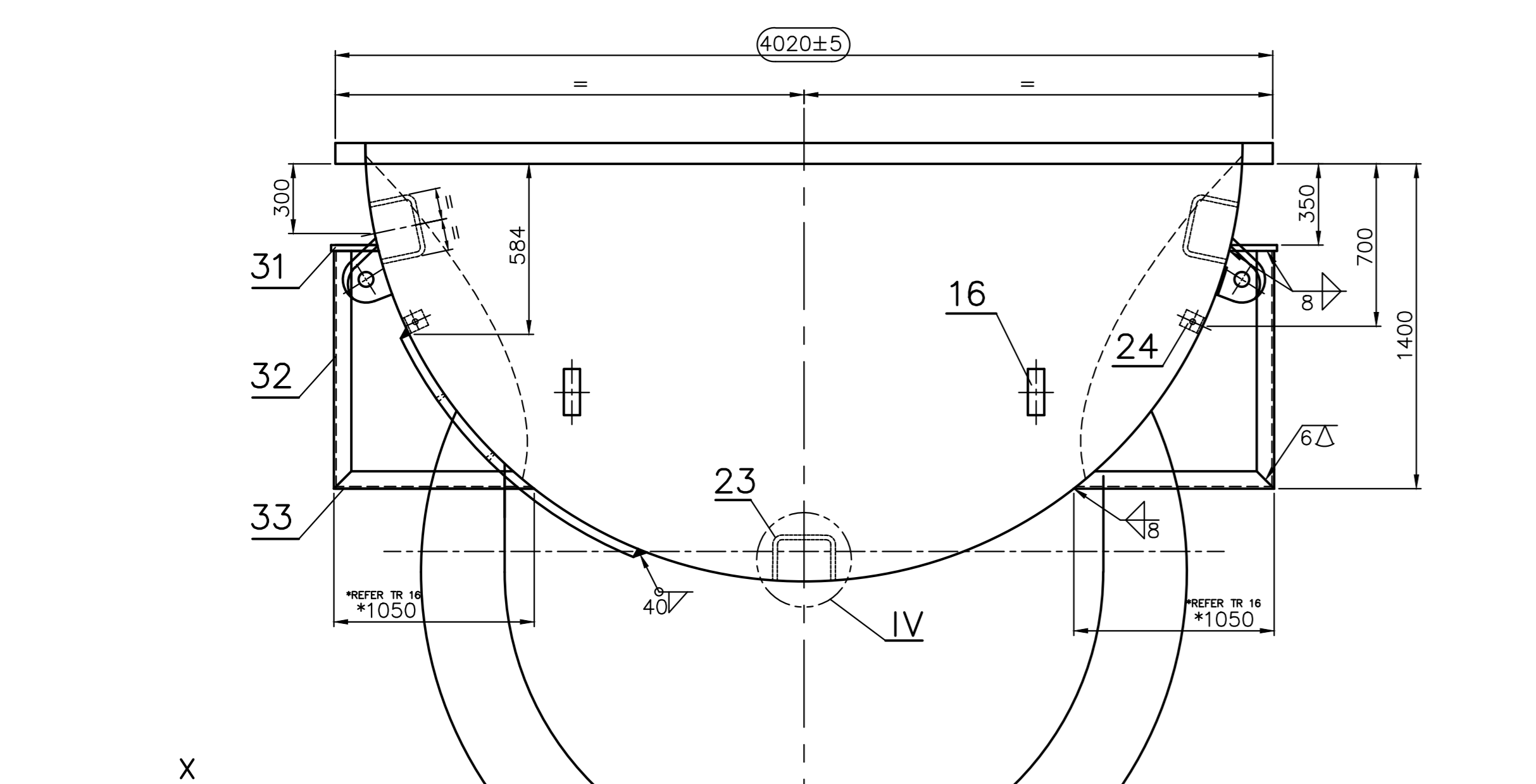
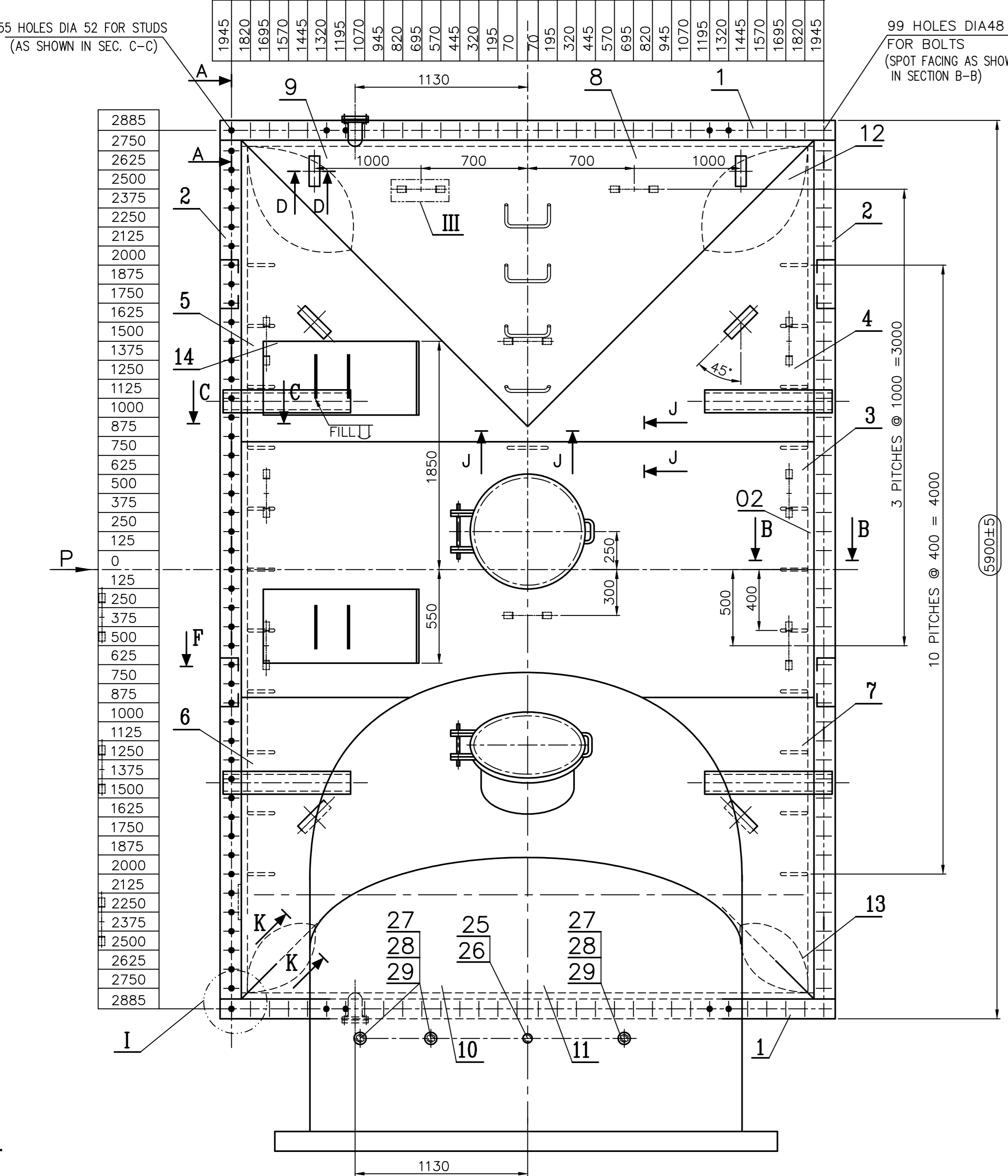


19002#80910



1. FABRICATED WEIGHT WITH WELD DEPOSIT	WT. (kg.)
	24837
2. FINISHED WEIGHT AFTER MACHINING	23148

- TECHNICAL REQUIREMENTS:-**
- VISUAL INSPECTION OF WELD SEAMS AS PER HW0620099. CLASSIFICATION GROUPS :-
 I) FOR ITEM NOS. 14 & 16 BS/BK.
 II) CS/BK FOR OTHER ITEMS.
 - NON DESTRUCTIVE EXAMINATION OF WELD SEAMS AS PER HW 0850199 PART 10.
 - WELD EDGE PREPARATION AS PER AA0620502.
 - THE GENERAL TOLERANCES OF STRAIGHTNESS, FLATNESS AND PARALLELISM SHALL BE MAINTAINED AS PER AA0621105 GRADE-F.
 - PAINTING IS TO BE DONE AS PER HE77001.
 - ITEM NO. 31, 32 & 33 ARE TO BE REMOVED PRIOR TO FINAL DESPATCH.
 - LIFTING TO BE DONE USING ALL THE FOUR LIFTING LUGS.
 - DIMENSIONS GIVEN IN BRACKET ARE BEFORE MACHINING.
 - DIMENSIONS GIVEN FROM MACHINED FACE OF FLANGES ARE THEORETICAL. ACTUAL DIMENSION SHALL BE AS PER MACHINING CARRIED OUT ON FLANGE (SEC. B-B, C-C & E-E).
 - IDENTIFICATION PLATE ITEM NO. 30 MAY BE SUITABLE BENT MANUALLY BEFORE WELDING WITH WATER BOX.
 - THE WORD 'REAR WATER BOX (GEN. SIDE)' SHOULD BE PAINTED ATLEAST TWO PLACES ON OPPOSITE SIDES.
 - THIS INDICATES CRITICAL TO QUALITY (CTQ).
 - OUT OF FLATNESS OF MACHINED SURFACE OF RECTANGULAR FLANGE SHOULD BE WITHIN 1.5 mm IN FREE CONDITION.
 - WATER BOX IS TO BE MATCHED WITH WATER CHAMBER IN FREE STATE BEFORE DISPATCH. GAP BETWEEN WATERBOX AND WATER CHAMBER MACHINED FLANGE SURFACES DURING MATCHING SHOULD BE WITHIN 3 mm.
 - EXTRA LENGTH OF ITEM NO. 33 MAY BE CUT TO SUIT PROPER FITTING.

10 b	10P	5 P	4 P	40FILL	55A	45A	40A	20A	35 b	20 b	12 b	10 b	40P	25P	12P	10P	5 P	3 P	SIZE & SYMBOL OF WELD SEAM LENGTH IN M.	GRADE OF UNTOL. DIM:-	GRADE OF UNTOL. DIM:-				
0.79	0.79	8.72	0.67	1.88	1.04	19.6	16.20	21.64	1.88	15.16	17.14	2.76	7.84	16.25	20.03	7.04	0.05	0.72	0.14	M/CC- $\chi/\beta/\eta/\theta$ AA 0230208	M/CC- $\chi/\beta/\eta/\theta$ AA 0230208				
0.57	0.43	1.16	0.06	13.40	10.9	90.3	95.3	29.87	14.76	33.5	14.57	1.99	56.3	42.08	14.92	3.81	0.10	0.10	0.01	WELDING- $\chi/\beta/\eta/\theta$ -AA621104	WELDING- $\chi/\beta/\eta/\theta$ -AA621104				
																				TYPE OF ELECTRODE		GAS CUTTING-T3-AA621101		GAS CUTTING-T3-AA621101	

OBOM NO. 01603470051	DATE 02.05.16	TYPE OF PRODUCT OR NAME OF CUSTOMER/ PROJECT	800 MW
APPROVED BY: [Signature]	DATE: [Date]	SCALE	NTS
BHARAT HEAVY ELECTRICALS LTD. HARDWAR		DEPT. HXE	CODE 4222
TITLE: REAR WATER BOX (GEN.SIDE)		WEIGHT(Kg.)	SEE TABLE
DRAWING NO. 01603470051		NO. OF SHEETS	01

INVENTORY NO. / SIGN & DATE REF. DRG NO.