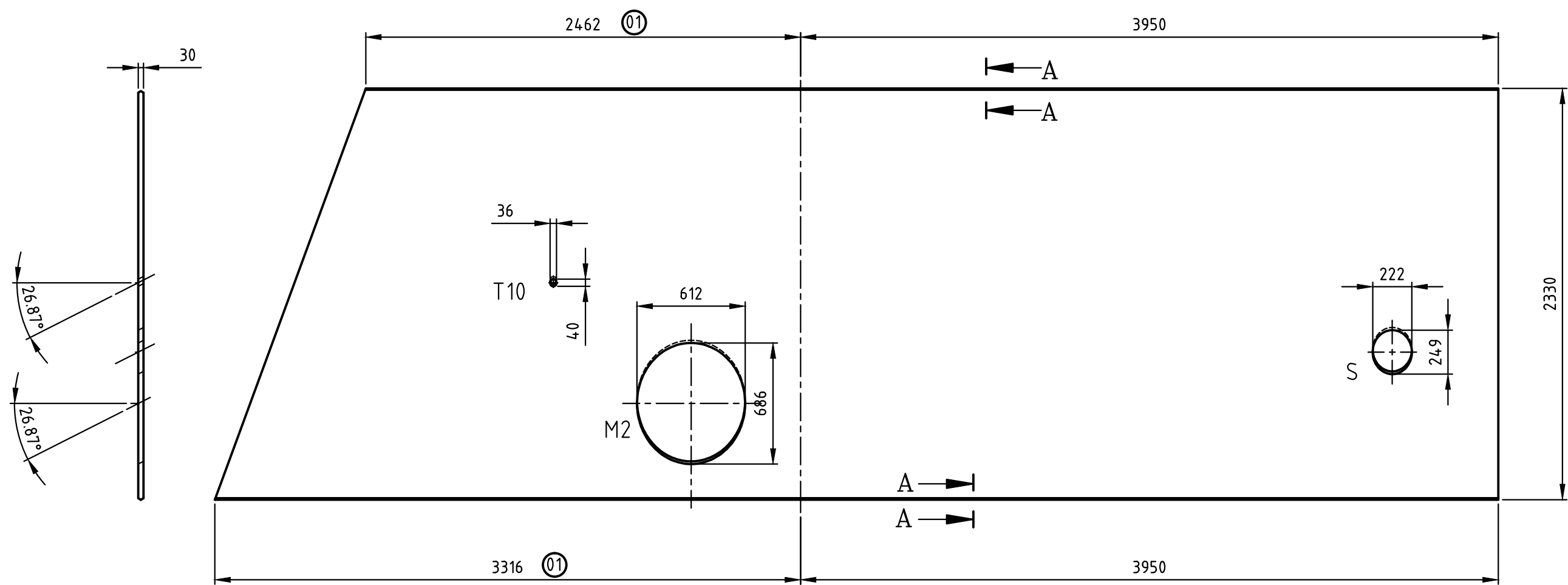
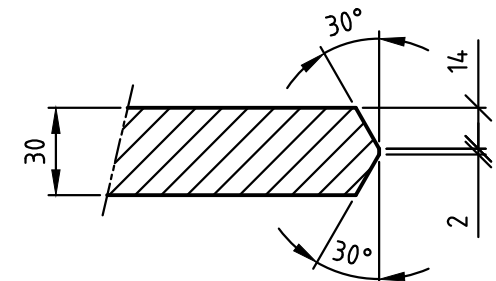
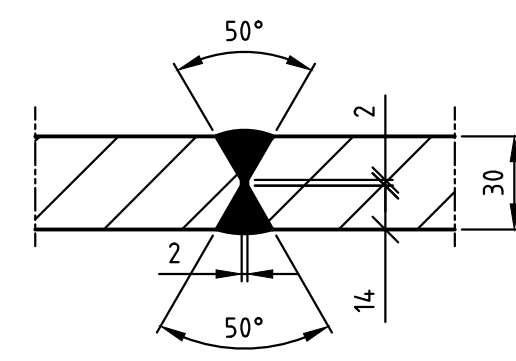
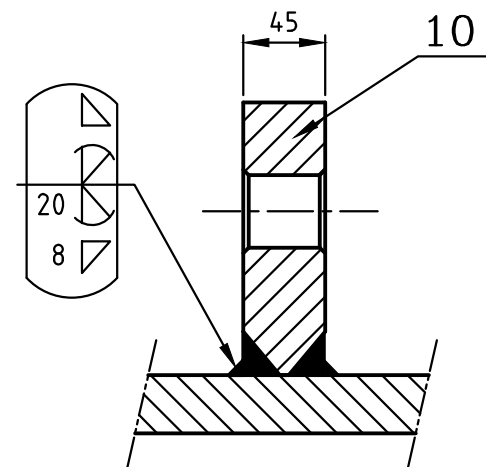
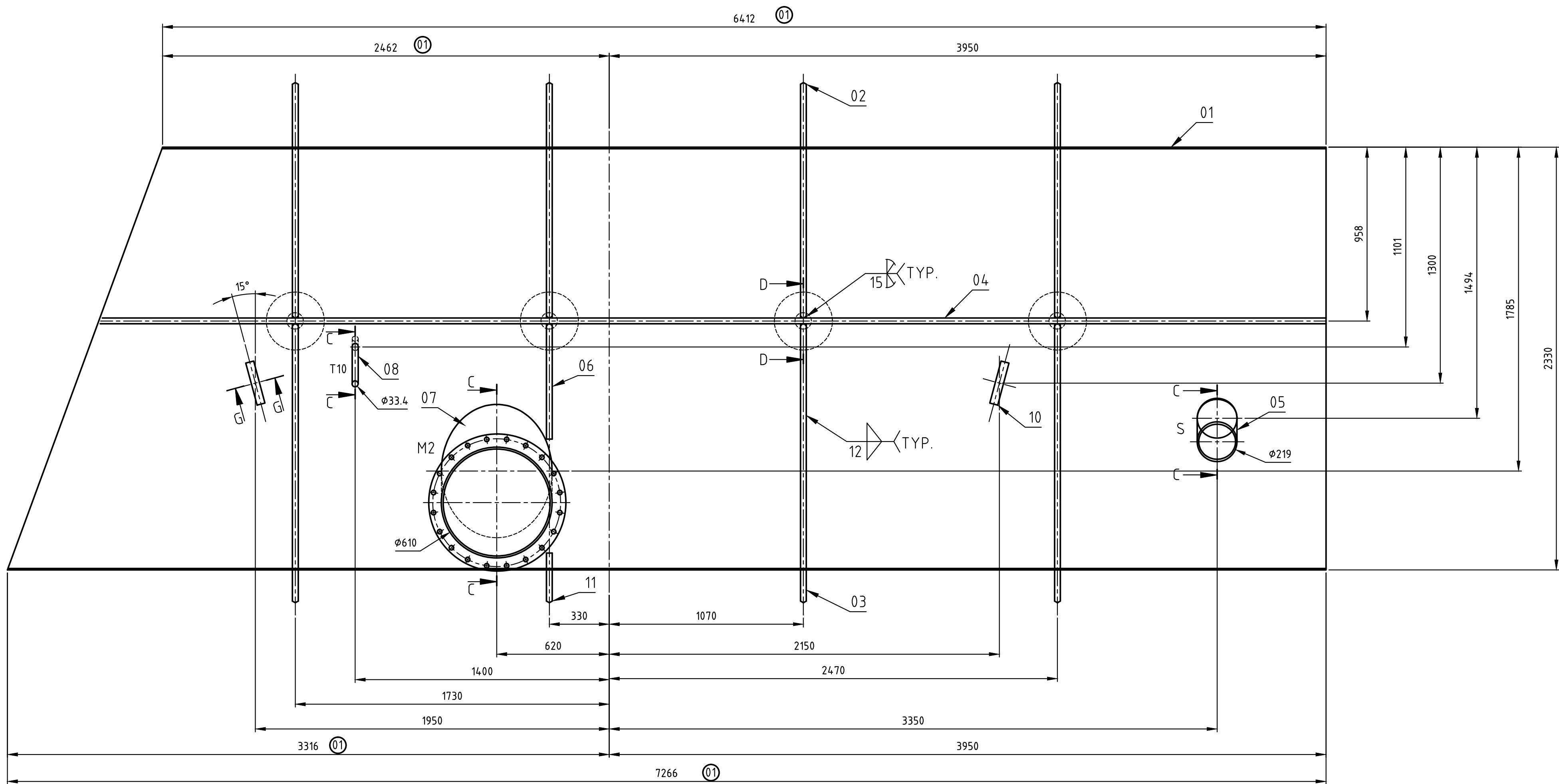
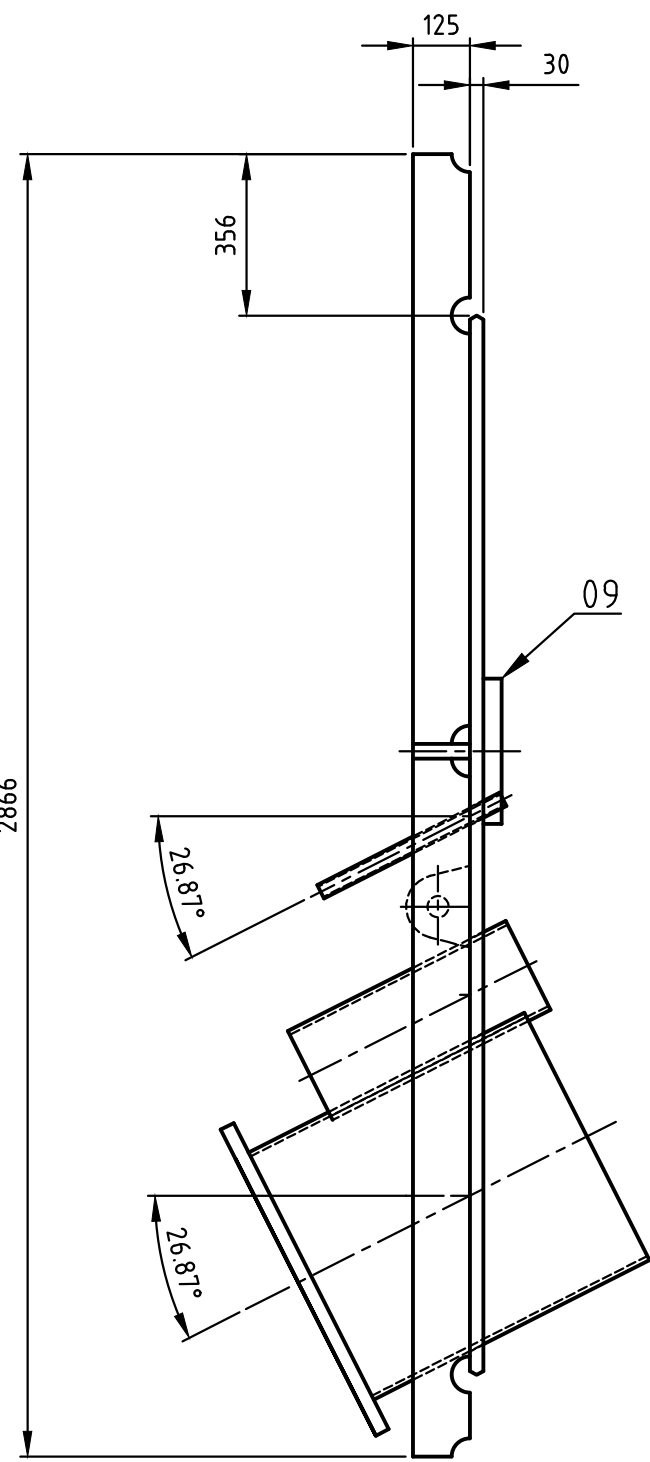
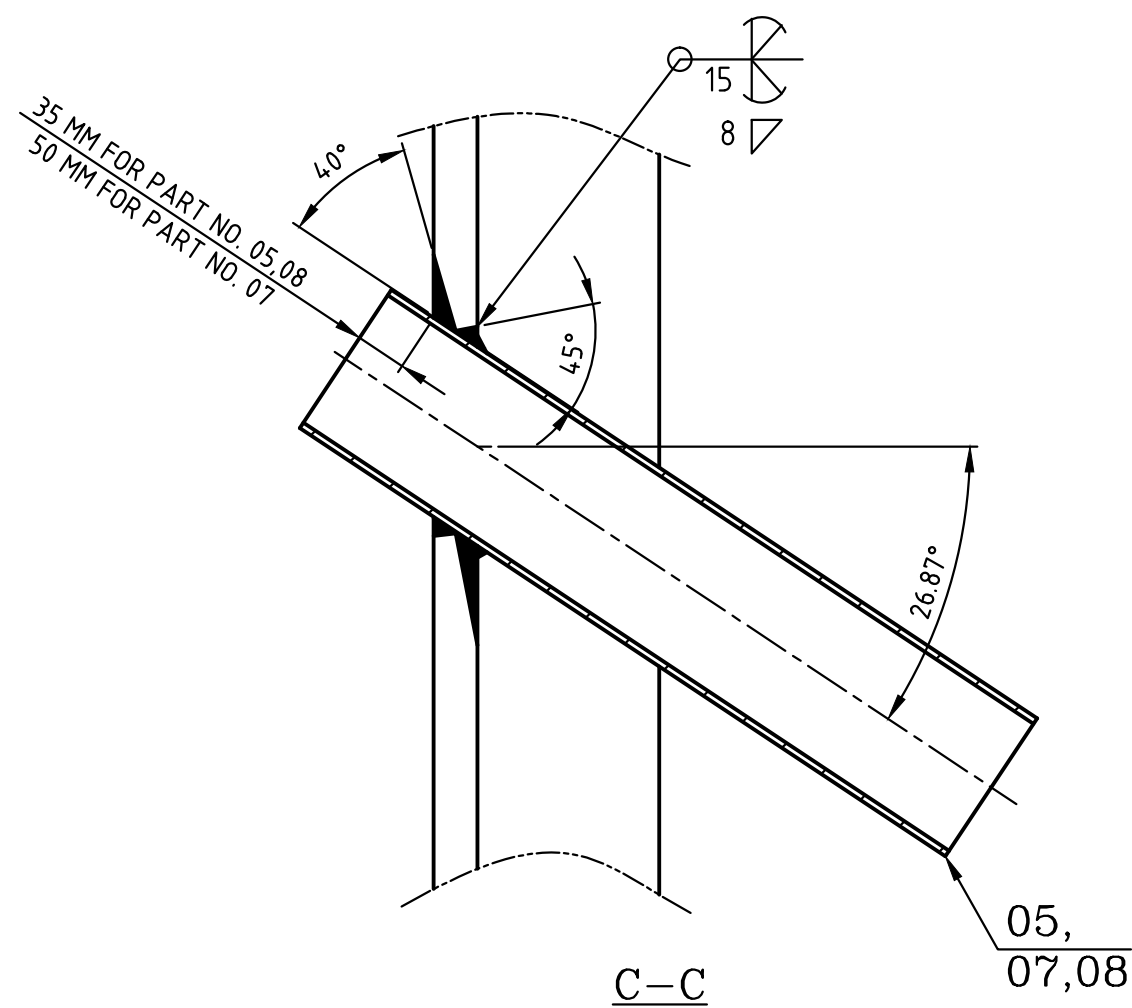


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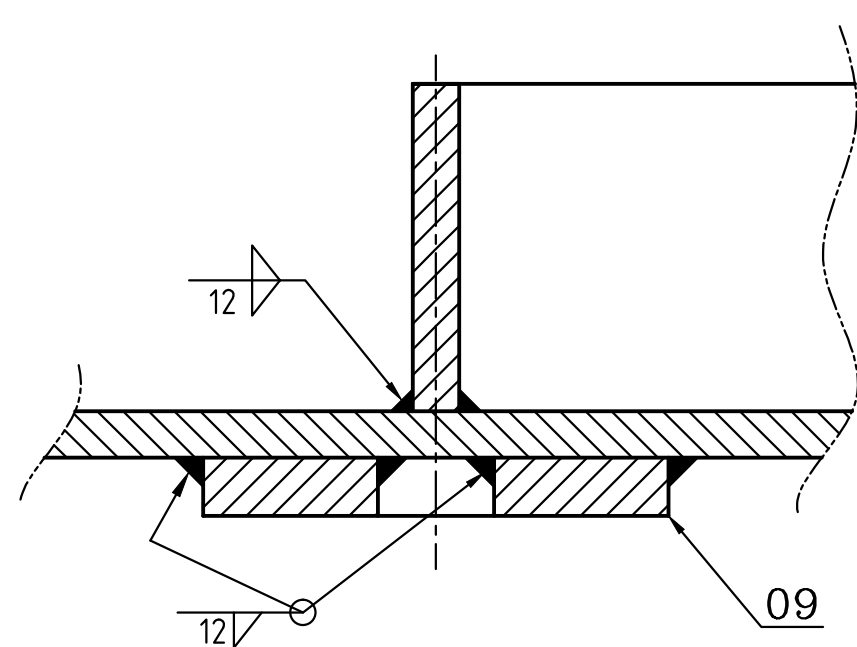
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THE RESTCOPYRIGHT AND CONFIDENTIALITY
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यह दस्तावेज़ केवल प्रयोजन के लिए है। इसका उपयोग अन्य किसी भी उद्देश्य के लिए नहीं किया जाना चाहिए।
अनुमति प्राप्त है कि इस दस्तावेज़ को भंडारित किया जा सके।संशोधित और मंजूर
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अनुमति प्राप्त है कि इस दस्तावेज़ को भंडारित किया जा सके।

ITEM NO. 1



TECHNICAL REQUIREMENTS:-

- WELDING CLASSIFICATION GROUPS ACCORDING TO HW 0620099 CS/BK. TEST SCOPE ACCORDING TO HW0850199 PART 10.
- STIFFENER MAY BE CUT LOCALLY AND WELDED TO THE NOZZLE USING , IF INTERFERING WITH THE SAME.
- EDGE PREPARATIONS FOR THE WELDING OF INCLINED IN CONNECTIONS ARE TO BE MADE DURING ASSY AS INDICATED IN SECTIONS.
- PAINTING IS TO BE DONE AS PER HXE PRODUCT STD. HE 77001
- IF REQUIRED, PLATES (IT.1) MAY BE MADE IN TWO PARTS WITH ONE JOINT AND WELDED AS PER DETAIL H-H SO THAT JOINT DOES NOT FOUL WITH AND IS AT LEAST 100 MM AWAY FROM ANY OTHER WELD SEAM/HOLE/ NOZZLE/ PAD AND SIZE (MIN. DIM.) OF ANY ONE PLATE IS AT LEAST 1000 MM. WELDING CLASSIFICATION GROUPS & TEST SCOPE AS PER T.R 1.
- ①
- SIZES OF HOLES ARE INDICATIVE ONLY, HOLES MAY BE MADE SO THAT REQUIRED INCLINATION OF NOZZLE MAY BE ACHIEVED.
- NON DESTRUCTIVE EXAMINATION OF WELD SEAM TO BE DONE AS PER HW 0850199 PART 10.
- THE GENERAL TOLERANCE ON STRAIGHTNESS, FLATNESS AND PARALLELISM SHALL BE MAINTAINED AS PER AA0621105 GRADE-F.
- FOR LIFTING THE ASSEMBLY, ALL LIFTING LUGS (ITEM NO. 8) SHALL BE USED SIMULTANEOUSLY WITH D-SHACKLES AS PER CORP. STD NO. AA7248105.
- UNLESS OTHERWISE STATED, EDGE PREPARATION OF WELD JOINTS SHALL BE AS PER AA0620502.
- A SEMI CIRCULAR/QUARTER CIRCULAR GROOVE OF RADIUS 20 mm MAY BE PROVIDED IN THE STIFFENER AT THE LOCATION WHERE STIFFENER CROSSES A WELD SEAM TO MAINTAIN CONTACT BETWEEN STIFFENER
- THIS INDICATES CRITICAL TO QUALITY (CTQ).



D-D TYP.

20	16	16	16	12	8	8	SIZE & SYMBOL OF SEAM
0.96	00	00	9.42	35.7	6.78	00	WELD LENGTH (M)
2.12	-	-	14.4	26.6	2.3	-	WT. OF WELD METAL
E-7018							TYPE OF ELECTRODE

REV.	DATE	BY	DATE	BY
01	22.8.18	S.JOSHI	01	22.8.18
02	22.8.18	D.K.Y.	02	22.8.18

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01	22.8.18	S.JOSHI	01	22.8.18
02	22.8.18	D.K.Y.	02	22.8.18

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02	22.8.18	D.K.Y.	02	22.8.18

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01	22.8.18	S.JOSHI	01	22.8.18
02	22.8.18	D.K.Y.	02	22.8.18

660 MW (SERIES)

BHARAT HEAVY ELECTRICALS LIMITED
RANIPUR, HARDWARLOWER DOME WALL
FWB COND.-1REV. 01
NO. OF ITEMS - 23