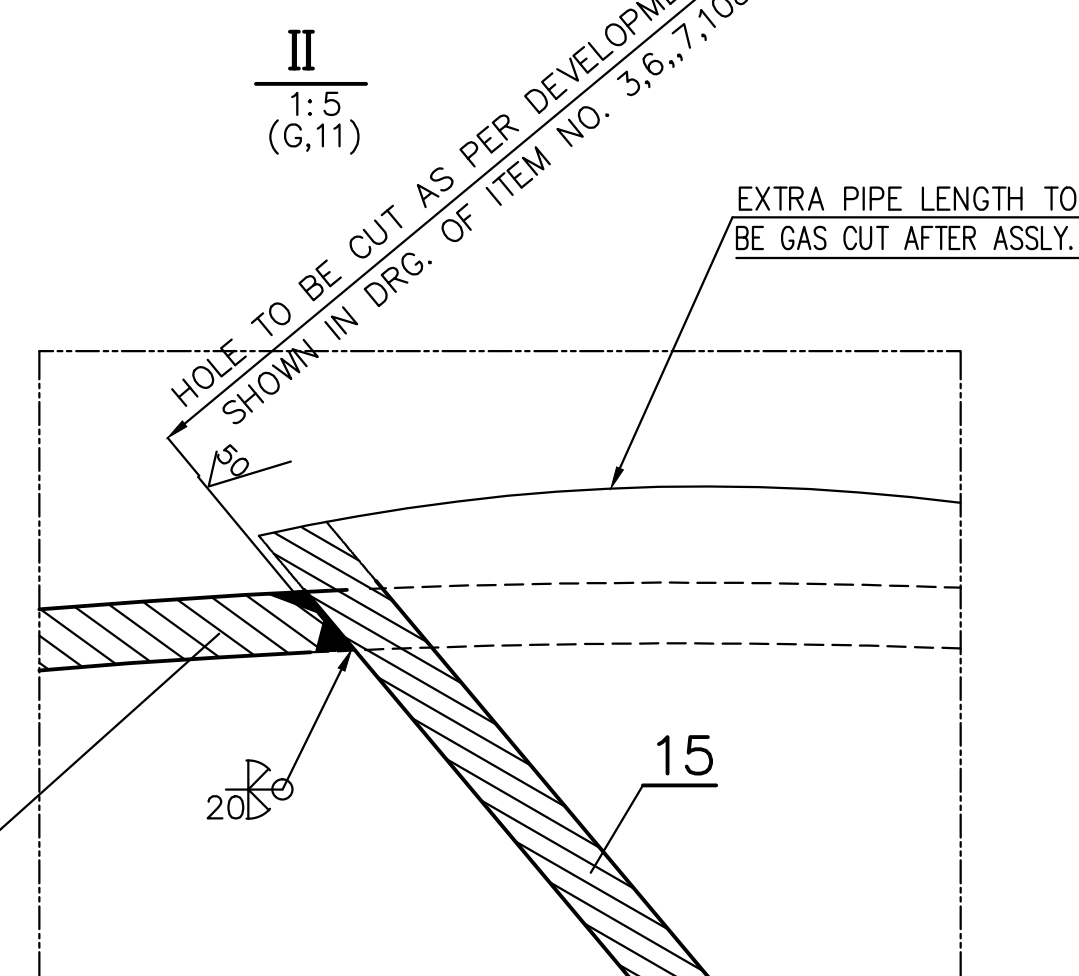
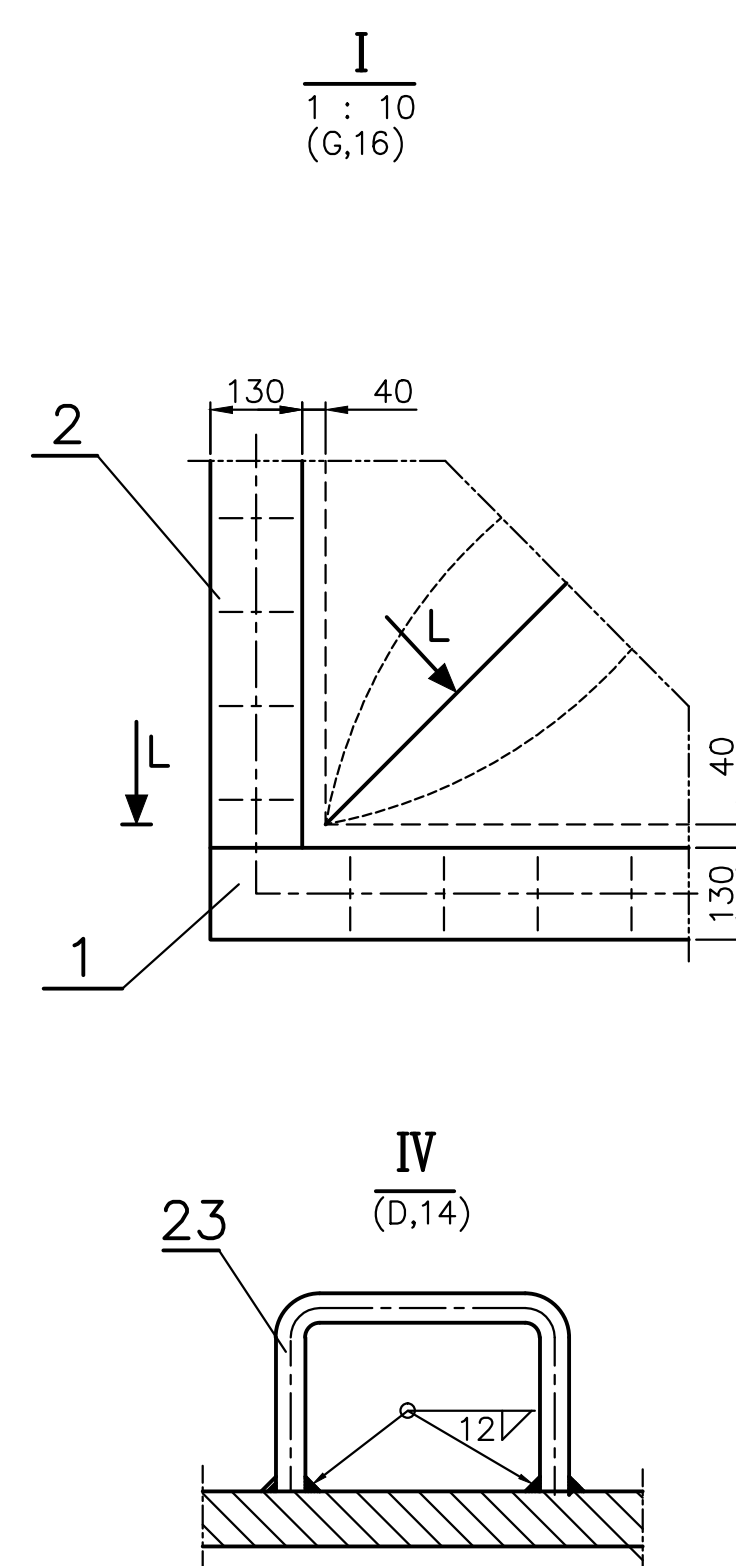
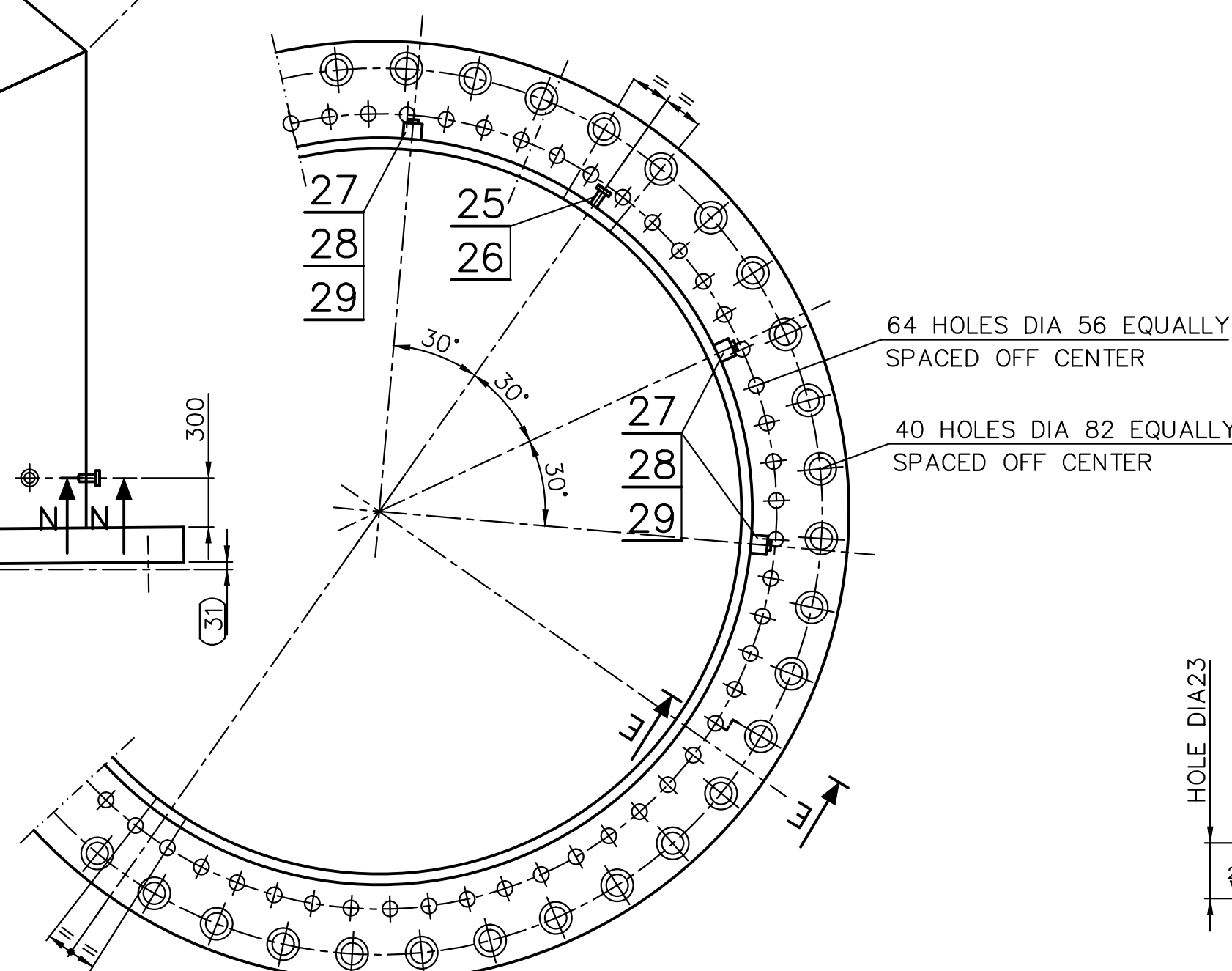
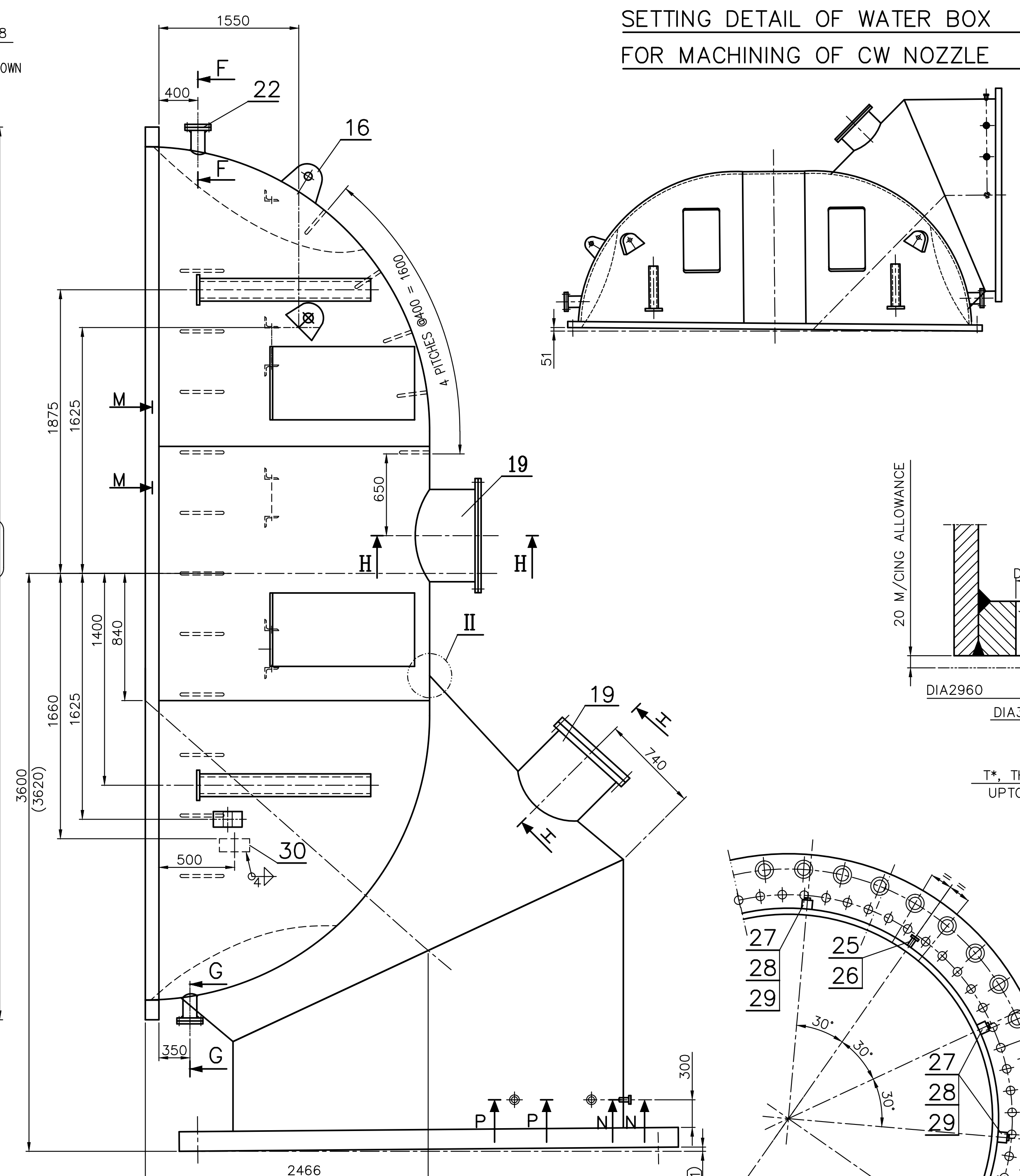
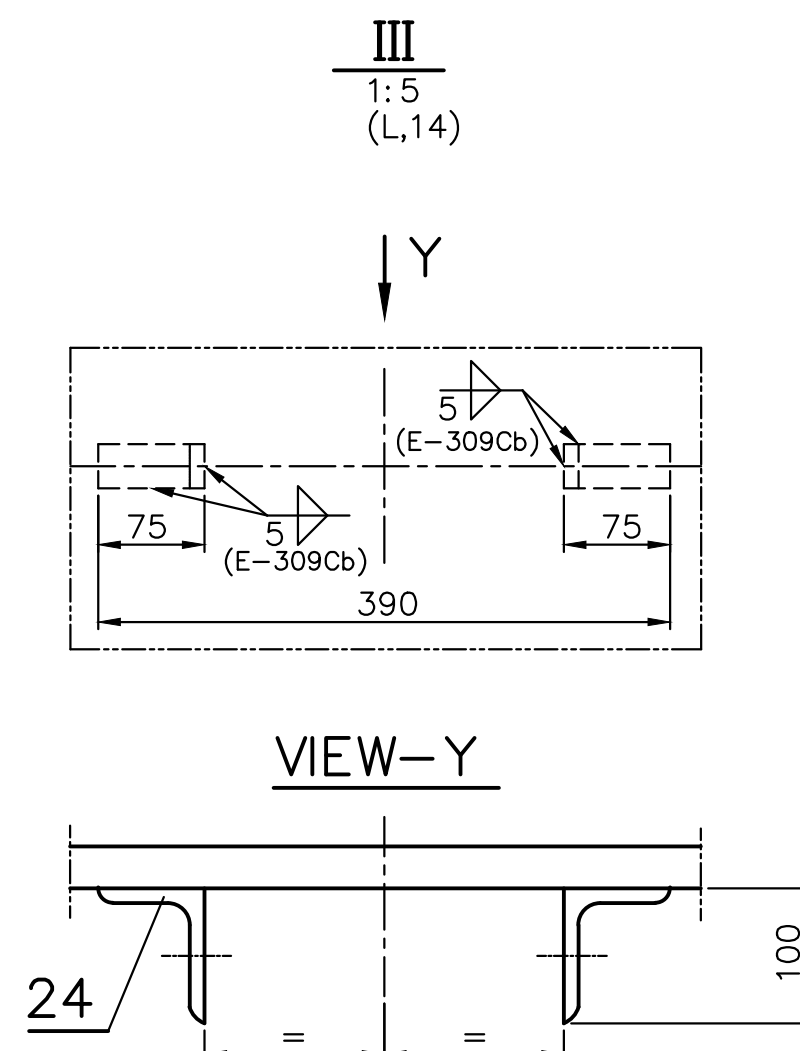
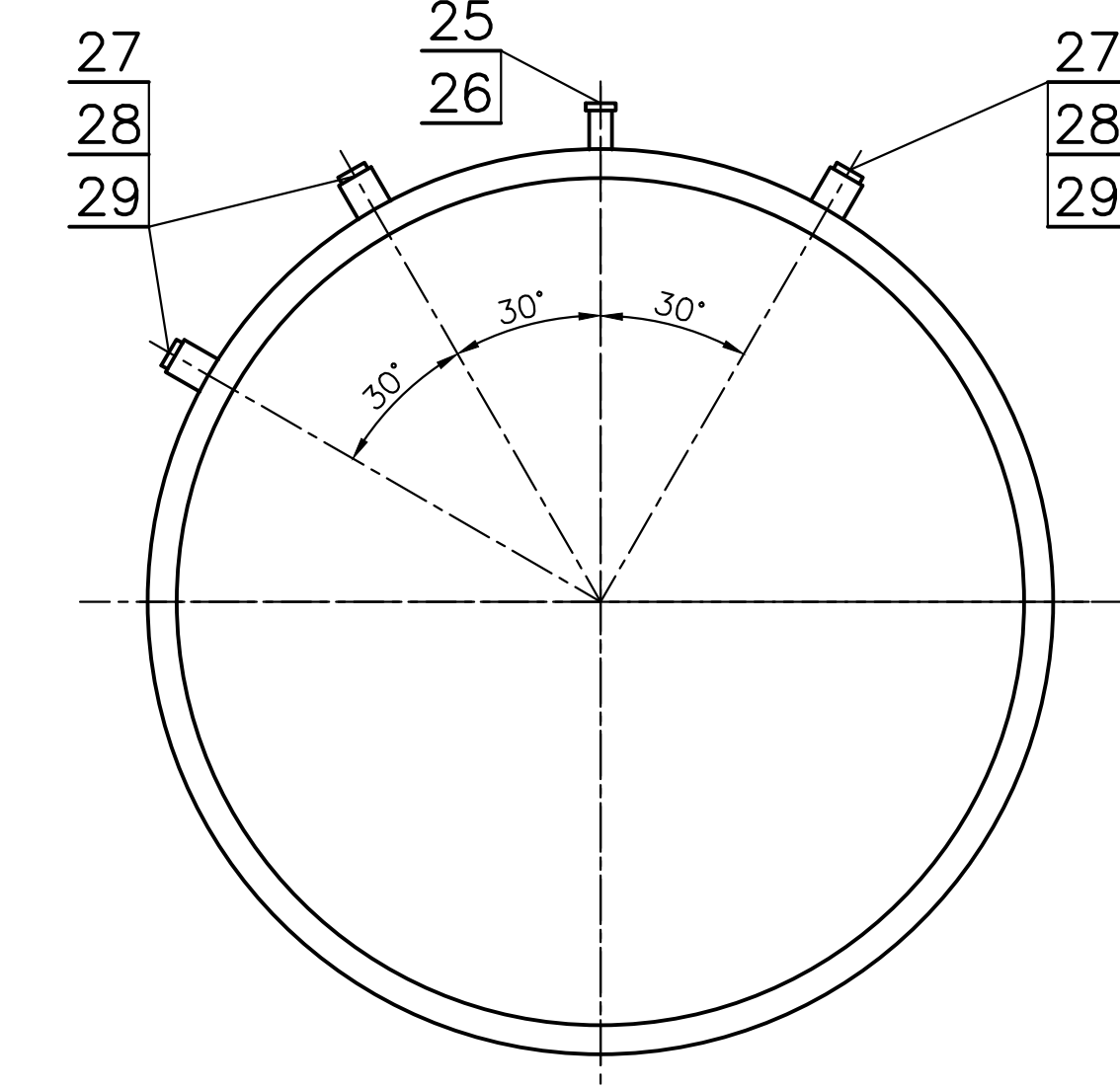
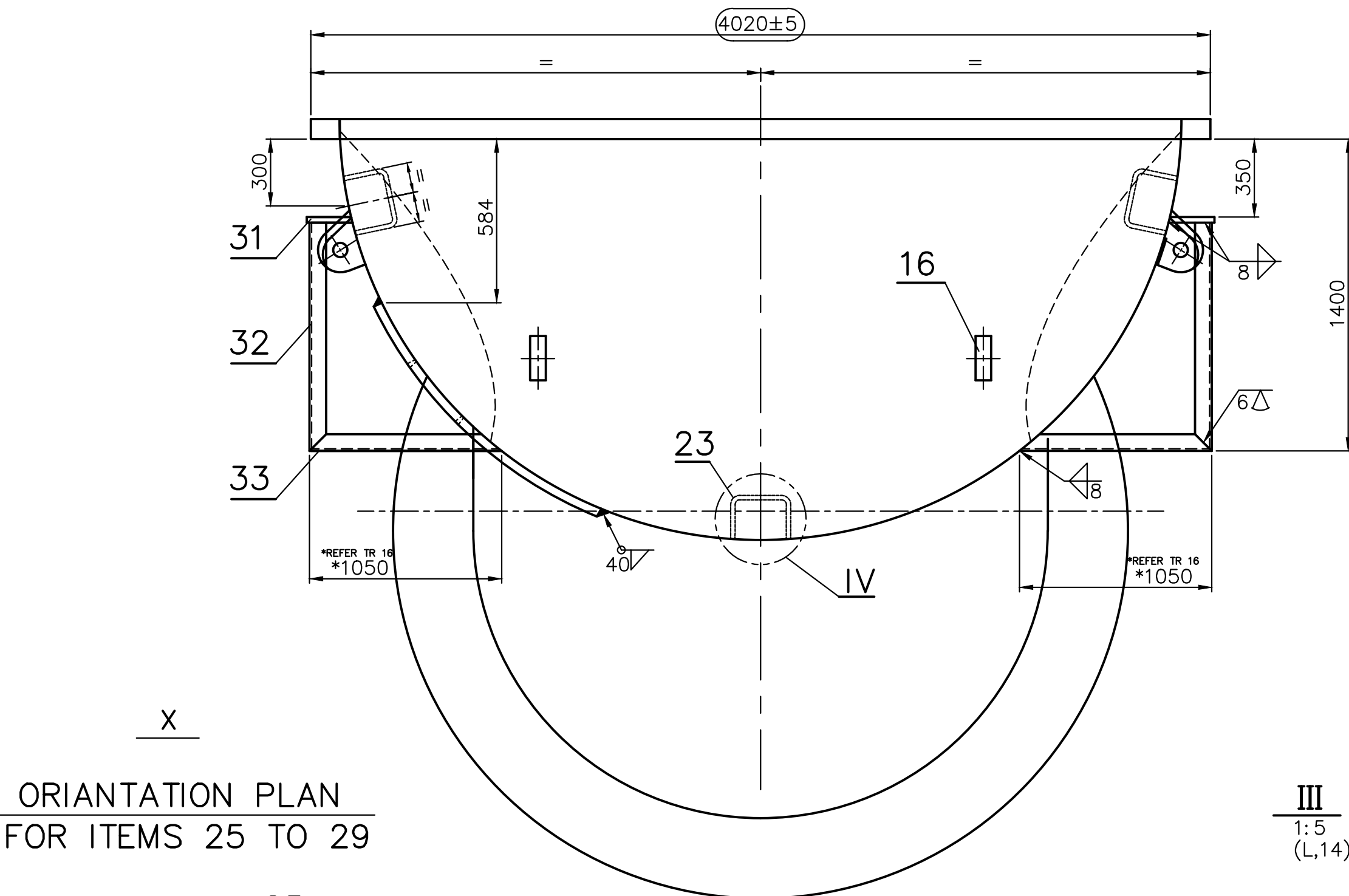
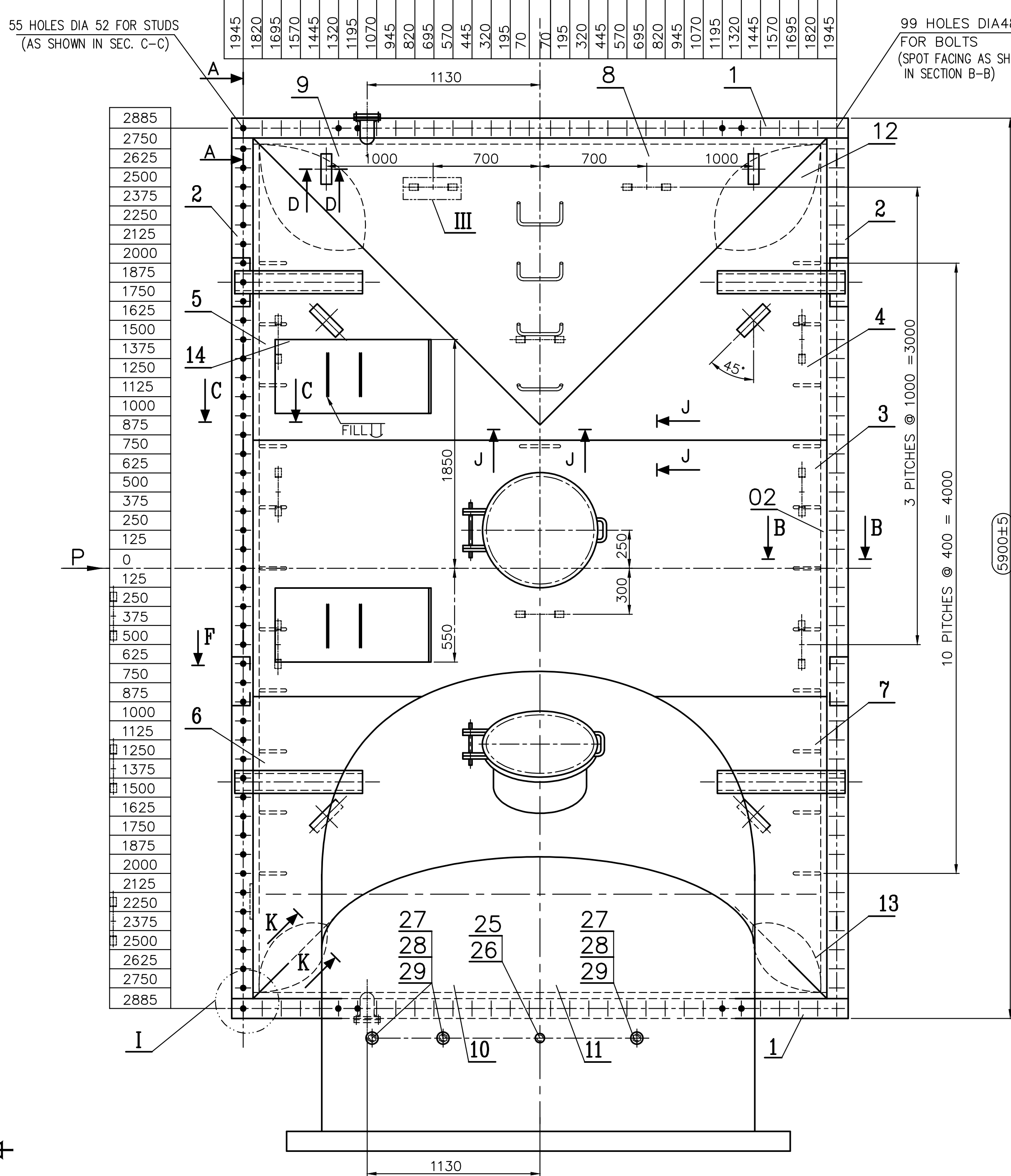


DRAWING NO. 01603470048



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

TECHNICAL REQUIREMENTS:-

- VISUAL INSPECTION OF WELD SEAMS AS PER HW0620099. CLASSIFICATION GROUPS :-
 - FOR ITEM NOS. 14 & 16 BS/BK.
 - 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.
- PAINING 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 SURFACES DURING MATCHING SHOULD BE WITHIN 3 mm.
- EXTRA LENGTH OF ITEM NO. 33 MAY BE CUT TO SUIT PROPER FITTING.

10 b	10 p	5 p	4 p	10 p	55 b	45 b	40 b	20 b	35 b	20 b	12 b	10 b	40 p	25 p	12 p	10 p	6 p	5 p	3 p	SIZE & SYMBOL OF WELD
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	SEAM LENGTH IN M.
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	WT. OF DEPOSITED METAL
																				TYPE OF ELECTRODE

REV.	DATE	ALTERED	CHECKED	REV.	DATE	ALTERED	CHECKED	REV.	DATE	ALTERED	CHECKED	REV.	DATE	ALTERED	CHECKED
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CBOM NO. 01603470048	STATUS APPROVED	TYPE OF PRODUCT OR NAME OF CUSTOMER/ PROJECT	800 MW WANAKBORI				
W.T.	BL	NAME	SIGN	DATE	29.5.15		
BHARAT HEAVY ELECTRICALS LTD. HARDWAR				DRN	T.BANSAL	Sd.	06.05.15
				CHD	R.BANSAL	Sd.	06.05.15
				APD	S.KANT	Sd.	30.05.15
DEPT. HXE				SCALE	1:20	WEIGHT(Kg.)	REF. TO ASSY. DRG.
CODE 4222				SEE TABLE			
TITLE				DRAWING NO.			
REAR WATER BOX (GEN.SIDE)				01603470048			
SHEET NO. 01				NO. OF SHEETS 01			
				SIZE A0			