

REV 02	DATE 17.09.14	ALTERED : CHD & APPD : R J PETER	S.SHARAN
NOTE ADDED AS INDICATED			

FOR TOLERANCES OF UNTOLERANCED  
DIMENSIONS DURING MANUFACTURE  
REFER PLANT STD. NO TP 023 0299

## PRODUCTION NOTES APPLICABLE FOR PG-08

### MATERIAL SUBSTITUTION

01. IS2062Fe410B MATERIAL SUBSTITUTION IS ACCEPTABLE IN PLACE OF IS2062Fe410A GRADE.
02. ASTM A36 MATERIAL SUBSTITUTION IS ACCEPTABLE IN PLACE OF IS2062Fe410A MATERIAL.
03. ROUND SA105 IS ACCEPTABLE IN PLACE OF IS2062Fe410A MATERIAL.
04. SA387GR22CL2 MATERIAL SUBSTITUTION IS ACCEPTABLE IN PLACE OF SA387GR12CL2 MATERIAL.

### OPTIONAL SHOP JOINTS (FOR ROLLED BEAMS)

OPTIONAL SHOP JOINTS TO SUIT MATERIAL LENGTH AVAILABILITY CAN BE PROVIDED SUBJECT TO THE FOLLOWING CONDITIONS.

FOR MEMBER OF LENGTH 8 Mts. AND LESS, ONE JOINT IN FLANGE AND WEB IS PERMITTED.

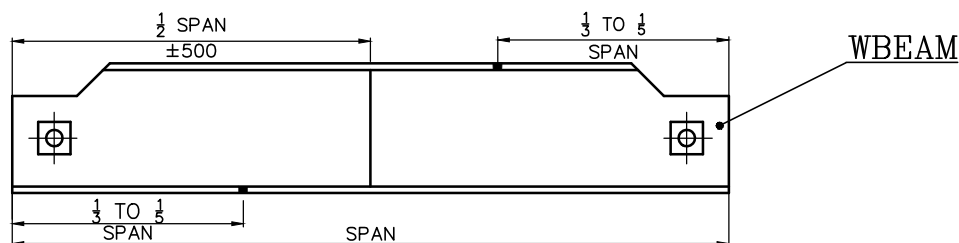
FOR MEMBER OF LENGTH MORE THAN 8 Mts. TWO JOINTS PER FLANGE AND WEB IS PERMITTED.

THE SHOP JOINT FOR ROLLED SECTION CAN BE PROVIDED BETWEEN  $\frac{1}{3}$  OF SPAN TO  $\frac{1}{5}$  OF SPAN. THE SPLICE PLATE SIZE TO BE MAINTAINED AS PER DRG. No.3-35-110-00686.

FOR KEY CHANNELS ONE SPLICE PLATE TO BE PROVIDED TO INSIDE ONLY.


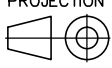
### (C) WELDED BEAMS

FOR WELDED BEAM THE SHOP JOINT IN THE FLANGE PLATE MUST BE PROVIDED BETWEEN  $\frac{1}{3}$  OF SPAN TO  $\frac{1}{5}$  OF SPAN. THE WEB OF THE WELDED BEAM JOINT MUST BE PROVIDED AT CENTER OR  $\pm 500$  FROM THE CENTER. IN CASE OF SPLIT BEAMS  $\frac{1}{3}$  OF SPAN TO  $\frac{1}{5}$  OF SPAN TO BE CONSIDERED FOR COMBINED BEAM.



02 (THIS SKETCH SHOULD BE FOLLOWED FOR BEAMS UPTO THE LENGTH OF 14 METRES)

\* THIS DRAWING IS TO BE READ ALONG WITH DRAWING NO.4-08-000-04056

 355-056		Bharat Heavy Electricals Ltd UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI - 620014		DRN	NAME DHANAJI	SIGNATURE	DATE 09/02/07
				CHD	R.J.PETER		09/02/07
				APPD	J.SOMU		10/02/07
DEPT ST	ALL DIMENSIONS ARE IN MM	PROJECTION 	SCALE N.T.S	WEIGHT (Kg) —	REF TO ASSY / OLD DWG		
CODE 122							
TITLE PRODUCTION NOTES					DRAWING NO : 4-08-000-02900		REV 02