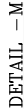


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- 1 PIPE LENGTH INDICATED WITH CUTTING ALLOWANCE TO BE CUT AS PER THE CUTTING PLAN
- 2 WELDED PORTIONS SHALL HAVE A UNIFORMLY SMOOTH TOOL FINISH WITHOUT BURRS, WELD SPATTER, CRACKS ETC.
- 3 FULL PENETRATION OF WELDS TO BE ENSURED
- 4 SPIDER ARRANGEMENT HAS TO BE WELDED AT THE ENDS AFTER EDGE PREPARATION. REFER DWG.NO. 4-80-999-93078
- 5 MITRE BEND TO BE MANUFACTURED BY USING ROLLED & WELDED FROM SA387G12CL2 PLATE.



02	PAD PLATE 12x400x670	2-80-363-16689	15 942 280 0000	SA387/GR12C2	c	25 246
						2
01	PL. FORMED PIPE OD 1626 x16; L=2766	3-80-363-36496	15 942 281 0000	SA387/GR12C2	c	1756 1516
ITEM	DESCRIPTION	DRAWING NO	MATERIAL CODE	MATERIAL SPECN	UNIT	WEIGHT
NO			QTY			QANTITY



	BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, CHENNAI 600 017			SCALE	WEIGHT (Kg.) 1806.995	DRAWING No. 2-80-363-16689	REV 00
	DEPT. CODE	SQUARE UP UN TOL. DIM C / M / P					
TITLES MITRE BEND 90DEG 001626x16 R=1200 WITH PAD PLATE			CARD CODE U 01				



PAD PLATE

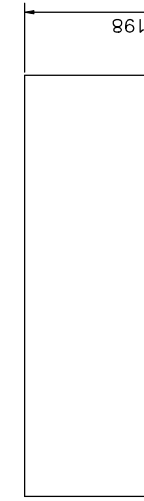
~~533282/2021/FSIP-FP PRDN~~

3-80-468-36746

DRAWING No

EP AS PER DWG.NO
4-80-999-93079
FIG "A"; d1=2272

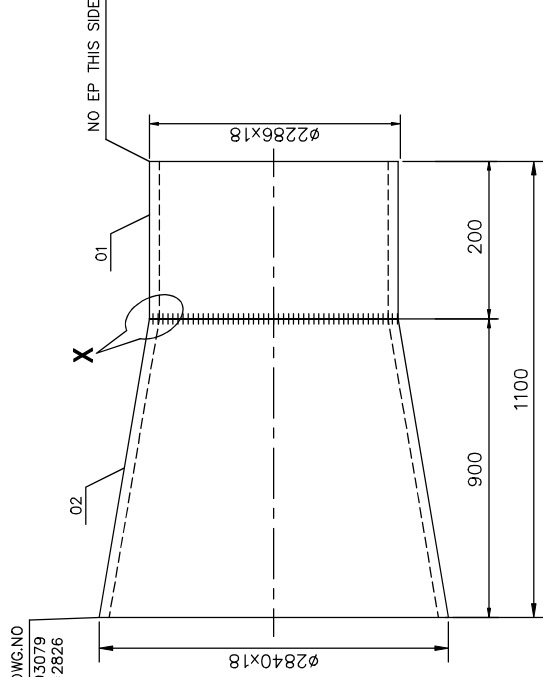
01 NO EP THIS SIDE



NOTES:—

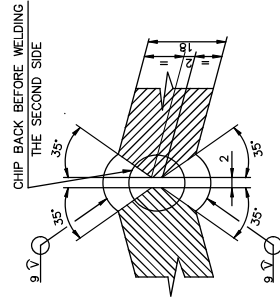
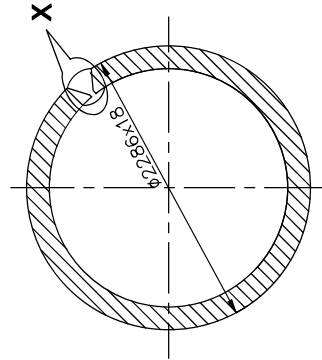
- 1 WELDED PORTIONS SHALL HAVE A UNIFORMLY SMOOTH SURFACE FINISH WITHOUT BURRS, WELD SPATTER, CRACKS ETC.
- 2 FULL PENETRATION OF WELDS TO BE ENSURED

EP AS PER DWG.NO
4-80-999-93079
FIG "A": d1=2826



RAW MATERIAL PLATE

PLATE FORMED PIPE



EP ONE
SIDE ONLY

VIEW-P

DETAIL -X

REV 01	DATE	ALTERED :
		APPROVED :
ZONE		

[illegible]

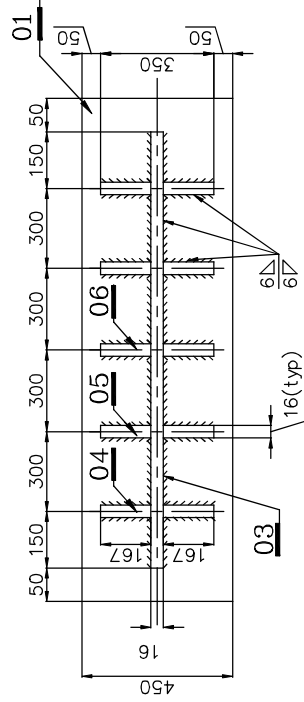
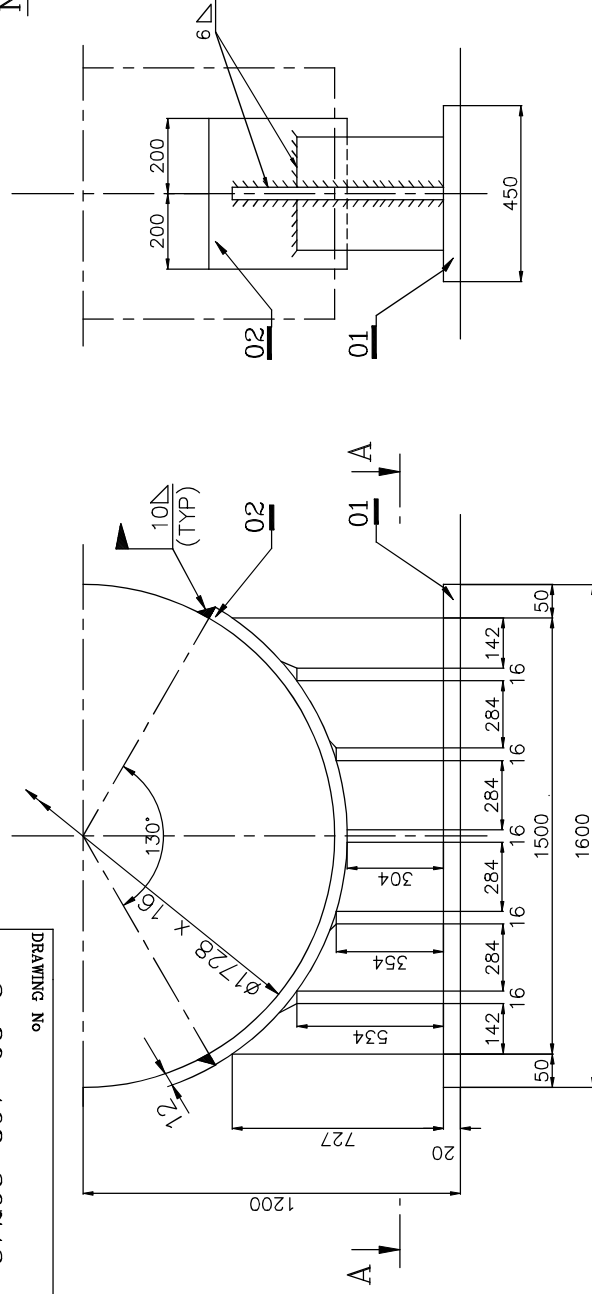
SIZE A3

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CAUTION

NOTES: —

01. ALL WELDS ARE 6 FILLET UNLESS OTHERWISE NOTED.



SECTION – AA

ITEM NO.	DESCRIPTION	DRAWING NO.	ITEM NO. VAR	MATERIAL SPEC.	UNIT WT. QTY.
06	STIFFNER PLATE-3 16 x 167 x 304	3-80-468-36743		15 011 026 0000 IS2062E250GRA	6 376
05	STIFFNER PLATE-2 16 x 167 x 354	3-80-468-36743		15 011 026 0000 IS2062E250GRA	2 7 425
04	STIFFNER PLATE-1 16 x 167 x 534	3-80-468-36743		15 011 026 0000 IS2062E250GRA	4 11 200
03	MIDDLE PLATE 16 x 727 x 1500	3-80-468-36743		15 011 026 0000 IS2062E250GRA	4 80 612
02	PAD PLATE 12x 400 x 1974	3-80-468-36743		15 011 132 0000 IS2062E250GRA	1 74 381
01	BOTTOM PLATE 20x 450 x 1600	3-80-468-36743		15 011 150 0000 IS2062E250GRA	1 113 040

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT

	BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, CHENNAI 600 017							
	DRN	NAME	SIGN	DATE	NO OF			
	CHD	SAI BABU		14.05.21	ITEMS			
	APPD	VENKAT		14.05.21				

REV 01	DATE	ALTERED APPROVED	DEPT.		GRADE OF UN TOL DIM		SCALE	WEIGHT (Kg.)	REF TO ASSY / OLD DRG	ITEM No.
ZONE			CODE	C / M / F		NTS	355.285			
			TITLE		SADDLE SUPPORT			CARD CODE	DRAWING No.	REV
					NB1700			U 01	3-80-468-36743	00