

CAUTION THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY

3-80-300-19825

DRWING NO

01

SA 355 P91

40°

01

SA 355 P22

02

EP AS PER DRG NO.

3-80-300-19825

STY-D, d<sub>1</sub>=130

OD219.1X50.3

OD210X40

EP: AS PER DRG.

3-80-300-19825

FIGURE 'X' d1=140

02

02

100

02

230

2

02

128

EP: AS PER DRG.

3-80-300-19825

FIGURE 'X' d1=140

02

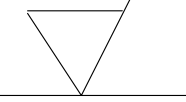
NOTES :-

01.ELECTRODE FOR WELDING.

a) Root run = RT: 2 1/4 Cr 1Mo

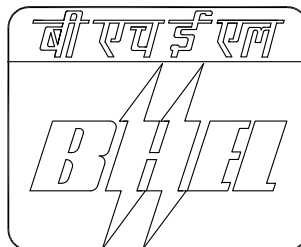
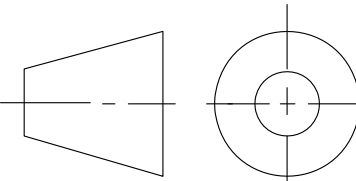
b) Further run = E9018B3

12.5



03

03

|                                                                                       |                               |                                                                                       |                                                                     |                               |                               |               |               |                  |                |
|---------------------------------------------------------------------------------------|-------------------------------|---------------------------------------------------------------------------------------|---------------------------------------------------------------------|-------------------------------|-------------------------------|---------------|---------------|------------------|----------------|
|                                                                                       |                               |                                                                                       |                                                                     |                               |                               |               |               |                  |                |
|                                                                                       |                               |                                                                                       |                                                                     |                               |                               |               |               |                  |                |
|                                                                                       |                               |                                                                                       |                                                                     |                               |                               |               |               |                  |                |
| 02                                                                                    | FORGSTUB OD210/ID130<br>L=128 | 3-80-399-30214                                                                        |                                                                     | 92 516 621 0000<br>SA 182 F22 | C                             | 21            | 465           | 1                |                |
| 01                                                                                    | FORGSTUB OD220/ID140<br>L=100 | 3-80-399-30214                                                                        |                                                                     | 92 516 656 0000<br>SA 182 F91 | C                             | 17            | 756           | 1                |                |
| VAR NO.                                                                               | DESCRIPTION                   | DRAWING NO.                                                                           | ITEM NO.                                                            | MATERIAL CODE                 | A                             | UNIT WT.      |               |                  |                |
|                                                                                       |                               |                                                                                       | VAR NO.                                                             | MATERIAL SPEC.                | C                             | QTY.          |               |                  |                |
| TYPE OF PRODUCT<br>OR NAME OF<br>CUSTOMER/PROJECT                                     |                               |                                                                                       |                                                                     |                               |                               |               |               |                  |                |
|  |                               |                                                                                       | BHARAT HEAVY ELECTRICALS LTD.,<br>PIPING CENTRE,<br>CHENNAI 600 017 |                               | DRN                           | NAME<br>LALIT | SIGN<br>-SD.- | DATE<br>11.12.12 | NO OF<br>ITEMS |
|                                                                                       |                               |                                                                                       |                                                                     |                               | CHD                           | LALIT         | -SD.-         | 11.12.12         |                |
|                                                                                       |                               |                                                                                       |                                                                     |                               | APPD                          | C.SARAVANAN   | -SD.-         | 11.12.12         |                |
| DEPT.                                                                                 | GRADE OF<br>UN TOL. DIM       |  | SCALE<br>N.T.S                                                      | WEIGHT (Kg).<br>47.37         | REF TO ASSY / OLD DRG         |               |               |                  | ITEM<br>No.    |
| CODE                                                                                  | C/M/F                         |                                                                                       |                                                                     |                               |                               |               |               |                  |                |
| TITLE<br>MATCHING PIECE<br>OD219.1X50.3(P91)/OD219.1X50.3(P22)                        |                               |                                                                                       |                                                                     | CARD<br>CODE<br>U 01          | DRAWING No.<br>3-80-399-30214 |               |               |                  | REV<br>03      |

|           |                                                       |                              |
|-----------|-------------------------------------------------------|------------------------------|
| REV<br>03 | DATE<br>14.06.13                                      | ALTERED<br>MANOJ -Sd-        |
|           |                                                       | APPROVED<br>S.PANDA -Sd-     |
| ZONE      | REVISIONS ARE MARKED AS 03                            |                              |
| REV<br>02 | DATE<br>21.12.2012                                    | ALTERED<br>LALIT -Sd-        |
|           |                                                       | APPROVED<br>C.SARAVANAN -Sd- |
| ZONE      | STUB LENGTH REVISED AS PER OS COMMENT                 |                              |
|           | REVISIONS ARE MARKED AS 02                            |                              |
| REV<br>01 | DATE<br>17.12.2012                                    | ALTERED<br>K.BOOPALAN -Sd-   |
|           |                                                       | APPROVED<br>C.SARAVANAN -Sd- |
| ZONE      | DRG ITEM NO.01 & 02-SHOP WELD<br>REVISED TO SITE WELD |                              |
|           | REVISIONS ARE MARKED AS 01                            |                              |