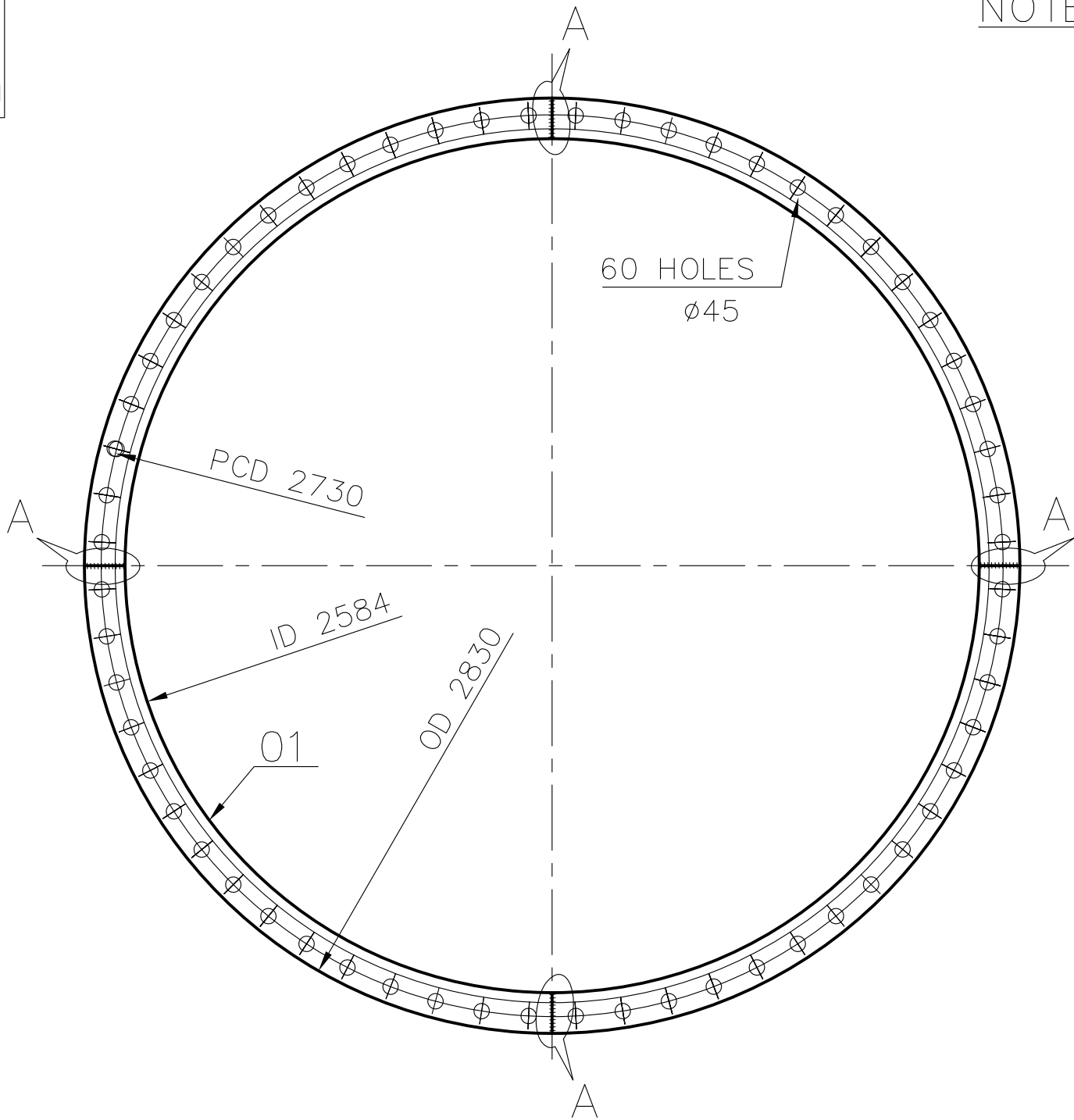
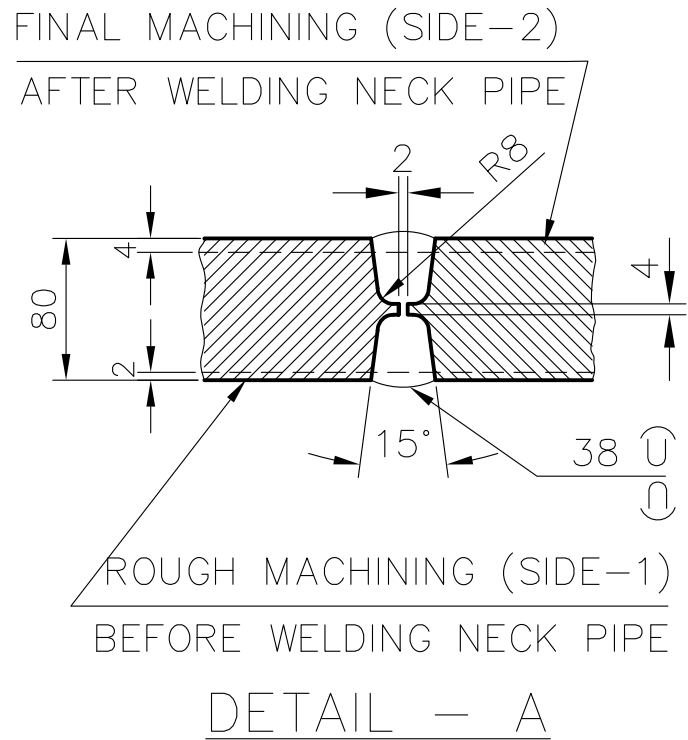


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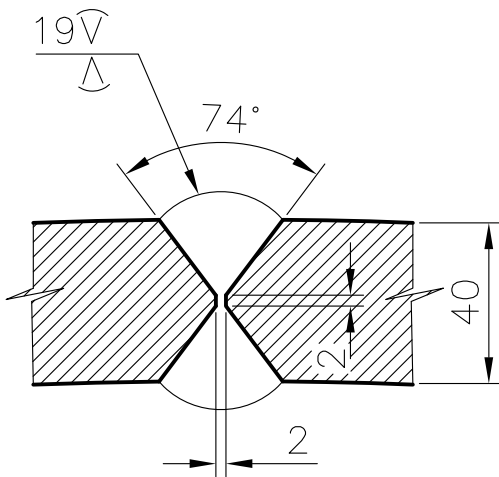
3-80-468-31251

DRAWING No

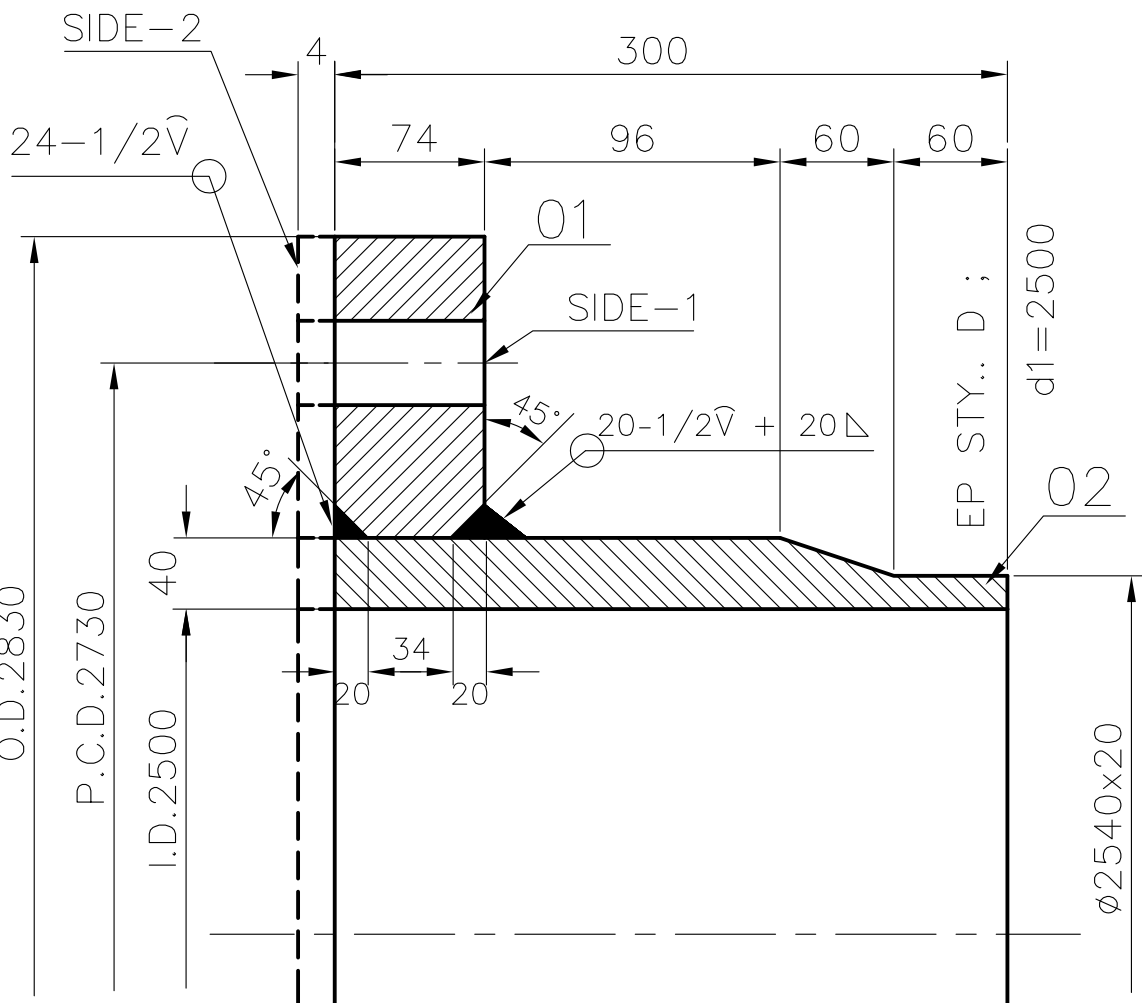
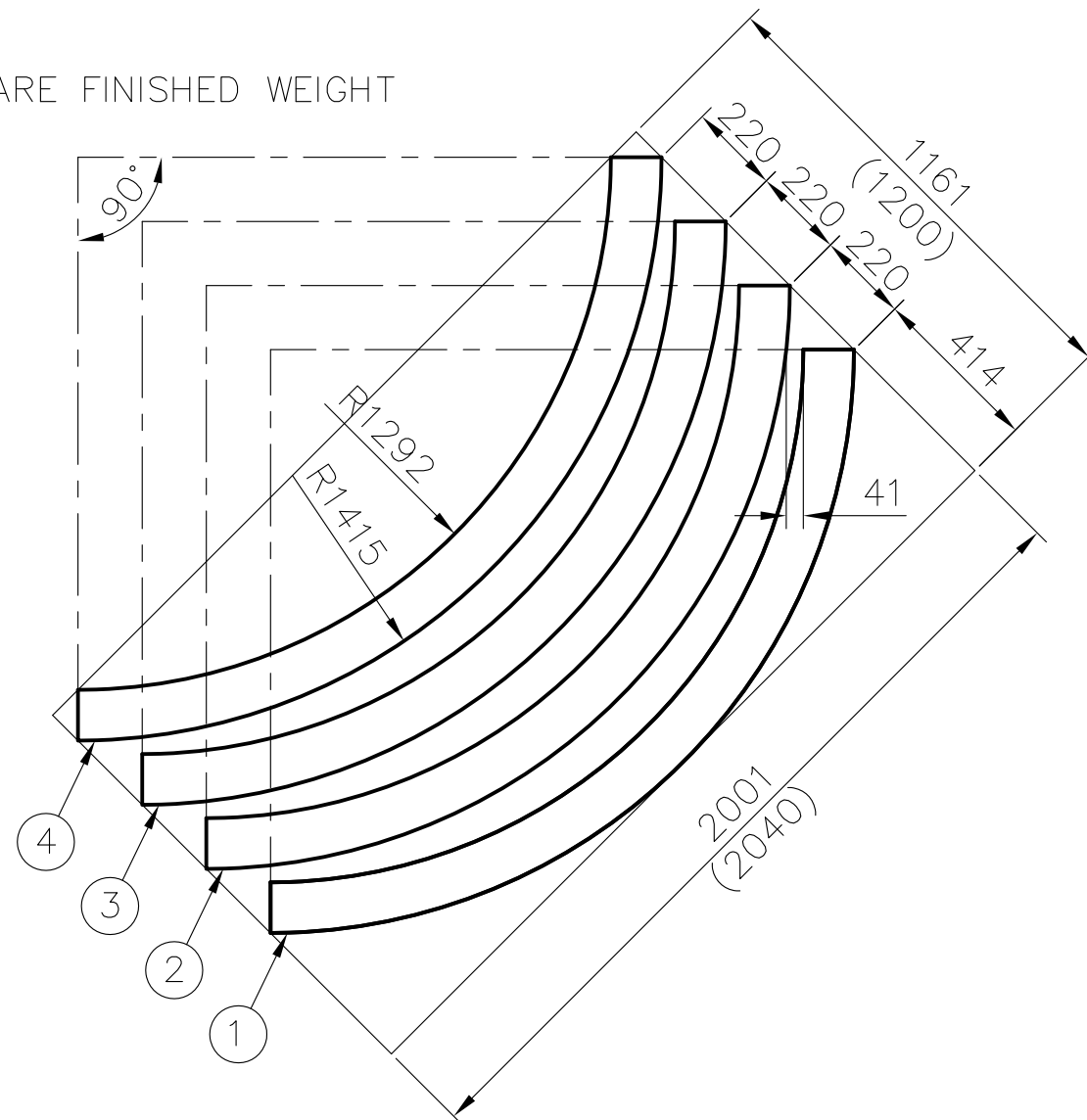


NOTES: -

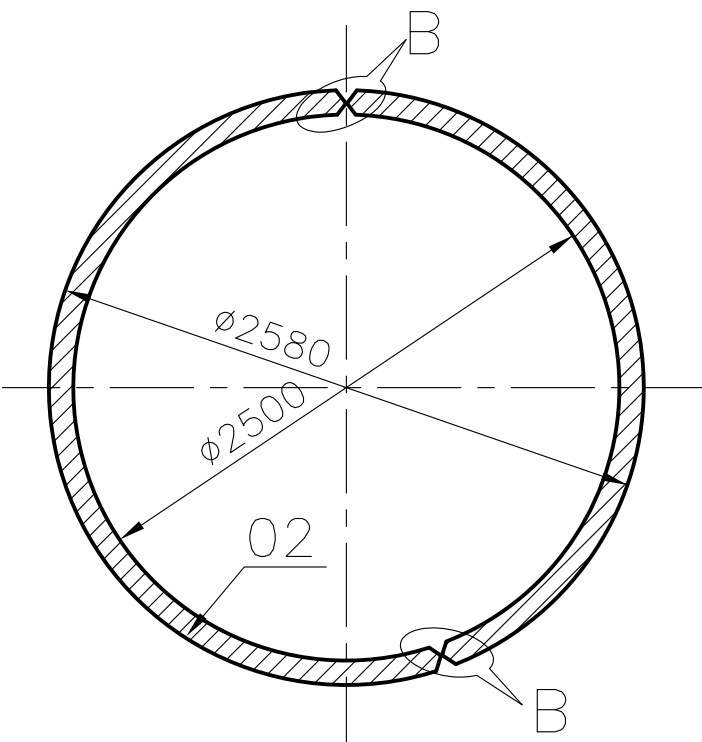
01. WELDS ARE TO BE GROUND FLUSH WITH THE SURFACE ON BOTH SIDES
02. ANGLE 90° IS TENTATIVE ONLY. HOWEVER NO.OFF JOINTS DONOT EXCEED 4
03. HOLES SHOULD NOT FALL ON WELD JOINTS
04. WHILE WELDING THE BACKSIDE, ENSURE BACK CHIPPING TO SOUND METAL BEFORE PROCEEDING WITH WELDING. FOLLOW SUITABLE SEQUENCE TO AVOID DISTORTIONS
05. WELD TO BE 100% RADIOGRAPHED AND STRESS RELIEVED
06. PLATE FORMED PIPE (ITEM No.02) TO BE MANUFACTURED BY USING ROLLED & WELDED FROM IS:2062 PLATE. RAW MATERIAL PLATE SIZE 40x7978x304mm.
07. DIMENSION INDICATES WITHIN BRACKETS ARE RAW MATERIAL PLATE SIZE WITH CUTTING ALLOWANCE.
08. WEIGHTS INDICATED ARE FINISHED WEIGHT



DETAIL - B

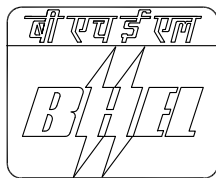


NECK FLANGE ASSY.



02	PLATE FORMED PIPE ø2580 x 40 ; L=304	3-80-468-31251		15 011 184 0000	C	760	000
				IS 2062 Fe410 B		1	
01	FLANGE NB2500 PLATE 80x1200x2040	3-80-468-31251		15 942 125 0000	C	600	000
				SA 515 GR.70		1	
ITEM NO.	DESCRIPTION	DRAWING NO.	ITEM NO. VAR NO.	MATERIAL CODE	A C	UNIT WT.	
				MATERIAL SPEC.		QTY.	

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT



BHARAT HEAVY ELECTRICALS LTD.,
PIPING CENTRE,
CHENNAI 600 017

DRN	NAME C.KUMAR	SIGN -Sd-	DATE 04.02.14	NO OF ITEMS
CHD	R.SESHAGIRI	-Sd-	12.02.14	
APPD	K.V.RAMANI	-Sd-	12.02.14	

DEPT.	GRADE OF UN TOL. DIM		SCALE	WEIGHT (Kg).	REF TO ASSY / OLD DRG	ITEM No.
CODE	C/M/F		NTS	1360.000		
TITLE				CARD CODE	DRAWING No.	REV
NECK FLANGE ASSEMBLY NB 2500				U 01	3-80-468-31251	00