

REV 01	DATE 22.02.08.	ALTERED : S.C.BABU CHD & APPD : R.JEYAKUMAR	REV 02	DATE 06.11.08.	ALTERED : A.VAITHEGI CHD & APPD : R.JEYAKUMAR	FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER PLANT STD. NO TP 023 0299
01. NOTE NO 04 ADDED IN MATERIAL SUBSTITUTION.			01. NOTE NO 04 ADDED IN MATERIAL SUBSTITUTION.			

PRODUCTION NOTES

APPLICABLE FOR PG 35,36,38 & 39

MATERIAL SUBSTITUTION

01. IS2062Fe410B MATERIAL SUBSTITUTION IS ACCEPTABLE IN PLACE OF IS2062Fe410A GRADE.
02. ASTM A36 MATERIAL SUBSTITUTION IS ACCEPTABLE IN PLACE OF IS2062 MATERIAL.
03. ROUND SA105 IS ACCEPTABLE IN PLACE OF IS2062.
04. SUBSTITUTION OF PARALLEL FLANGE(H) BEAMS ARE ACCEPTABLE IN PLACE OF ISMB SECTIONS. UB203=ISMB200, UB254=ISMB250, UB305=ISMB300, HB356=ISMB350, UB406=ISMB400, NPB450=ISMB450, NPB500=ISMB500 & NPB600=ISMB600. 01 02

OPTIONAL SHOP JOINTS (EXCEPT CEILING GIRDER JOINTS)

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.

(A) COLUMNS

THE OPTIONAL JOINT CAN BE PROVIDED IN THE SHOP, FOR ANY PIECE OF COLUMN, IT MUST CLEAR 500 m.m ABOVE AND 1000 m.m BELOW THE MENTIONED FLOOR LEVELS. FLOOR LEVELS FOR INDIVIDUAL CONTRACT ARE SHOWN IN THE COLUMN DRAWING. THE SHOP JOINTS FOR FLANGE AND WEB IN ANY PIECE OF THE COLUMN SHOULD NOT COME IN THE SAME ELEVATION AND AN OFFSET OF MINIMUM 300 mm IS TO BE MAINTAINED.

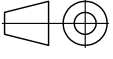
(B) ROLLED BEAMS

IN 35-4XX SERIES (HORIZONTAL BEAMS) NO JOINT IS PERMITTED BELOW 10 METERS.

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

(C) WELDED BEAMS/WELDED BRACING

FOR WELDED BEAM THE SHOP JOINT IN THE FLANGE PLATE MUST BE PROVIDED BETWEEN 1/3 OF SPAN TO 1/5 OF SPAN. THE WEB OF THE WELDED BEAM JOINT MUST BE PROVIDED AT CENTER OR ± 500 FROM THE CENTER. IN CASE OF BRACING JOINTS CAN BE PROVIDED WITHOUT ANY RESTRICTION OF LOCATION.

 355-056	Bharat Heavy Electricals Ltd UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI - 620014			DRN	NAME S.C.BABU	SIGNATURE	DATE 07.11.03
				CHD	M.P.R		07.11.03
				APPD	R.JEYAKUMAR		07.11.03
DEPT ST	ALL DIMENSIONS ARE IN MM		SCALE N.T.S	WEIGHT (Kg)	REF TO ASSY / OLD DWG		
CODE 122							
TITLE PRODUCTION NOTES					DRAWING NO : 4-35-110-00347		REV 02