



△06 6. ENSURE ENGAGEMENT OF MINIMUM 7 THREADS

(7) (a) WHEN $t_n > 22.5$ mm, THE DETAIL-'Y' TO BE FOLLOWED.

 (b) WHEN $t_n = 22.5$ mm, THE DETAIL-'U' TO BE FOLLOWED
NO WELD BUILD UP REQUIRED.

 (c) WHEN $t_n < 22.5$ mm, SEE SHOP GUIDE LINES.
WHERE t_n IS THE MINIMUM WALL THICKNESS OF HEADER/PIPE

SHOP GUIDELINES IN CONTINUATION OF DESIGN GUIDELINES-7(C)

SHOP SHOULD MEASURE THE ACTUAL WALL THICKNESS OF THE
HEADER/PIPE. IF THE ACTUAL WALL THICKNESS IS LESS THAN
22.5 mm ADDITIONAL MATERIAL SHALL BE ADDED BY SHOP
AS PER DETAIL-'Z'.

8. AFTER RADIOGRAPHY, SCREW UP PLUG TIGHTLY PRIOR TO SEAL WELDING

9. AFTER THE SHOP RADIOGRAPHIC TEST OVER, THIS SEAL WELD IS TO BE
DONE WITH MINIMUM TWO PASSES.

10. AFTER THE SITE RADIOGRAPHIC TEST OVER, THIS SEAL WELD IS TO BE
DONE WITH MINIMUM TWO PASSES.

- SHOP GUIDELINES IN CONTINUATION OF DESIGN GUIDELINES-7(C)

SHOP SHOULD MEASURE THE ACTUAL WALL THICKNESS OF THE HEADER/PIPE. IF THE ACTUAL WALL THICKNESS IS LESS THAN 22.5 mm ADDITIONAL MATERIAL SHALL BE ADDED BY SHOP AS PER DETAIL-'Z'.

8. AFTER RADIOGRAPHY, SCREW UP PLUG TIGHTLY PRIOR TO SEAL WELDING
9. AFTER THE SHOP RADIOGRAPHIC TEST OVER, THIS SEAL WELD IS TO BE DONE WITH MINIMUM TWO PASSES.
10. AFTER THE SITE RADIOGRAPHIC TEST OVER, THIS SEAL WELD IS TO BE DONE WITH MINIMUM TWO PASSES.

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		 Bharat Heavy Electricals Ltd UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI – 620014		DRN	NAME S.K.	SIGNATURE	DATE 05/84
				CHD	G.U.		05/84
				APPD	S.V.		05/84
355-054 DEPT PP ALL DIMENSIONS ARE IN MM PROJECTION SCALE WEIGHT (Kg) REFER UNIT WT		REF TO ASSY / OLD DWG 6108-0022-02					
CODE 121				N.T.S			
TITLE PLUG FOR RADIOGRAPHIC TEST ACCESS HOLE					DRAWING NO : 6108-0022	REV 08	

1. THREADS ON PLUG AND HEADER/PIPE SHOULD CONFORM TO COARSE SERIES OF CORPORATE STD AA 0230202 (BPS-412513)
2. TOLERANCE CLASS FOR EXTERNAL THREADS ON PLUG SHOULD BE AS PER 89 OF CORPORATE STD AA 0231816 (BPS-412515)
3. THE VARIATION IN THREAD SIZE IS TO IDENTIFY CARBON AND ALLOY STEEL PLUGS SEPERATELY.
4. MARK THE BPS CODE AND MATERIAL CODE
5. CE REF. INDEX No. 12.9, 3.8, STD No. 23-63-22, DRG No. D980-0103-4
6. FOR DESIGN PRESSURE AND DESIGN TEMPERATURE REFER RELEVANT PRODUCT DRAWINGS.
7. DESIGN, MANUFACTURING AND INSPECTION AS PER IBR-1950
8. R.G. PLUG IS TO BE PROVIDED AT ANY CIRCUMFERENTIAL LOCATION AND AT ANY DISTANCE IN BETWEEN 90 MM AND 150 MM FROM PIPE CIRCUMFERENTIAL JOINT.

[illegible]

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TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT



355-054

Bharat Heavy Electricals Ltd
UNIT: HIGH PRESSURE BOILER PLANT
TIRUCHIRAPALLI - 620014

DRN	NAME S.K.	SIGNATURE	DATE 05/84
CHD	G.U.		05/84
APPD	S.V.		05/84

DEPT PP
CODE 121

PROJECTION



SCALE

N.T.S

WEIGHT (Kg)	REF TO ASSY / OLD DWG
REFER UNIT	6108-0022-02

TITLE PLUG FOR RADIOGRAPHIC
TEST ACCESS HOLE

DRAWING NO :	REV
6108-0022	08