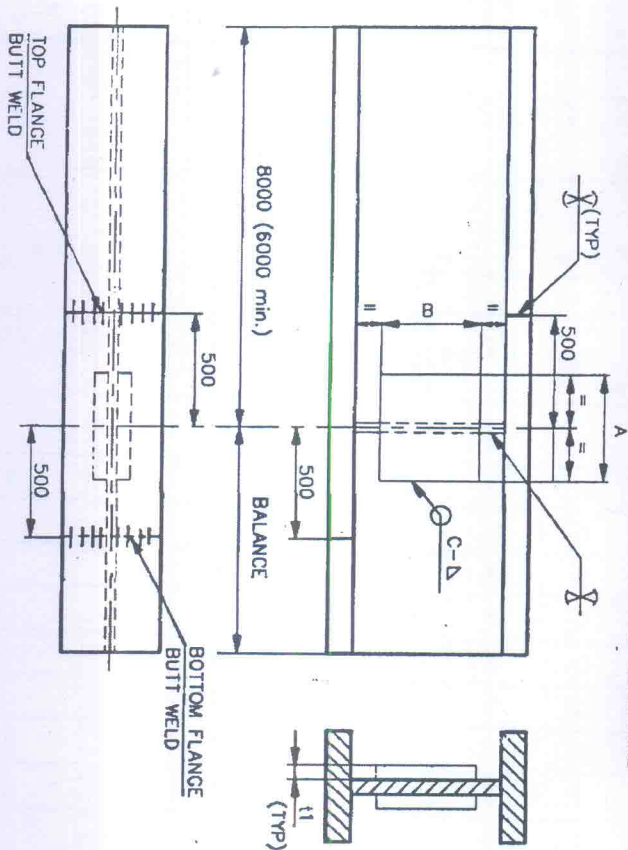


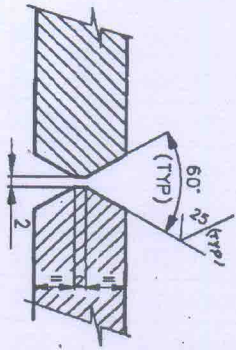
L1871-008-08-E

ON DRAWING

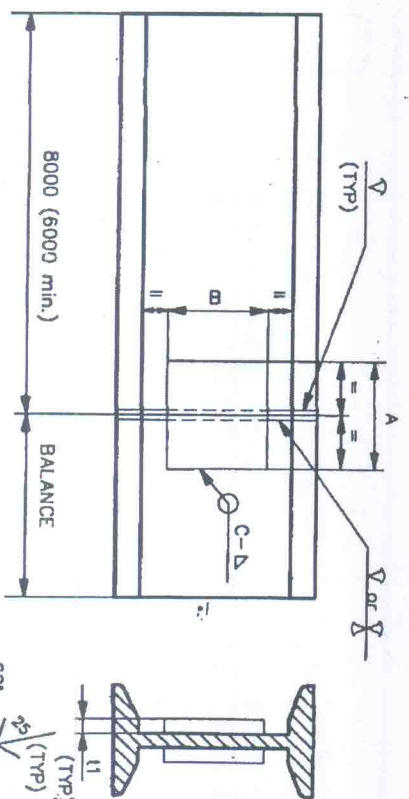
SPlicing DETAILS FOR WELDED BEAMS



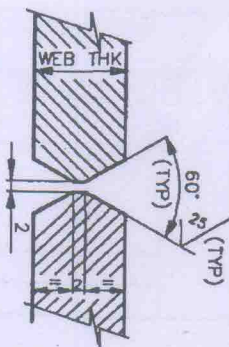
Sl. No.	DESCRIPTION	A	B	t1	C
01	WB1	640	650	10	8
02	WB2	640	640	12	10
03	WB3	640	630	12	10
04	WB4	640	610	12	10
05	WB5	680	680	12	10
06	WB6	680	680	16	12
07	WB7	770	780	12	10
08	WB8	770	760	12	10
09	WB9	770	760	16	12

EDGE PREPARATION FOR WEBS
AND FLANGES OF WELDED BEAMS

SPlicing DETAILS FOR ROLLED SECTION



Sl. No.	DESCRIPTION	A	B	t1	C
01	ISMB125	100	80	4	3
02	ISMB150	120	105	4	3
03	ISMB200	160	140	5	4
04	ISMB250	200	185	5	4
05	ISMB300	250	230	6	5
06	ISMB350	300	275	6	5
07	ISMB400	340	325	8	6
08	ISMB450	380	365	8	6
09	ISMB500	430	410	8	6
10	ISMB600	510	495	10	8

EDGE PREPARATION FOR WEBS
OF ISMB 125 TO ISMB 450
AND ALL FLANGESEDGE PREPARATION FOR WEBS
OF ISMB 500 TO ISMB 600BHARAT HEAVY ELECTRICALS LTD.,
PIPING CENTRE, MADRASDEPT. GRADE OF
UN TOL. DIM
C/M/FSCALE
N T S

WEIGHT (kg).

REF. DRG. No. 30-B-SS-01013/02

ITEM

TITLE
TYPICAL SPlicing DETAILS
OF ROLLED/WELDED BEAMSCARD
CODE

DRAWING No. 3-80-800-14817

REV

S/F A3

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

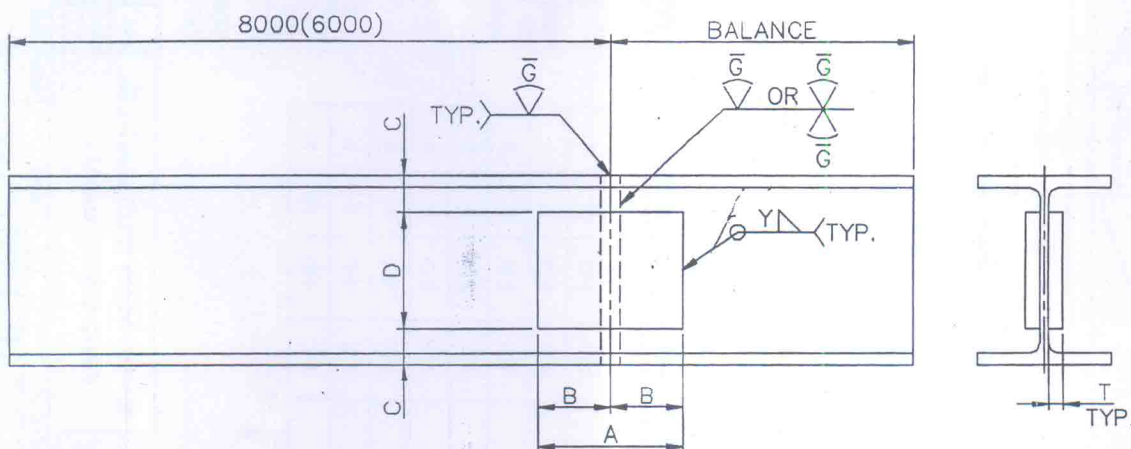
CAUTION: The information on this document is the property of BHARAT HEAVY ELECTRICALS LTD. It must not be used directly or indirectly in any way detrimental to the interest of the company.

REV	DATE	ALTERED
		CHECKED

ALL DIMENSIONS ARE IN MILLIMETRES

FOR PRODUCTION
REF.-RELEVANT QWI FOR PAINTING
REF.-PR:QA:500 FOR UNTOL. DIMNS.

TYPICAL JOINT DETAILS FOR IPE AND SR SECTION



S.No.	SECTION	FABRICATED SECTION	A	B	C	D	T	Y
01	IPE 400	400x200x16x8	250	125	50	300	6	5
02	IPE 450	450x200x20x8	300	150	50	350	6	5
03	IPE 500	500x200x20x8	400	200	50	400	6	5
04	IPE 600	600x200x16x8	450	225	50	500	6	5
05	IPE 600	600x200x20x10	450	225	50	500	8	6
06	IPE 600	600x200x24x12	450	225	50	500	10	8
07	SR 700	700x200x16x8	500	250	50	600	6	5
08	SR 750	750x200x20x8	500	250	50	650	6	5
09	SR 800	800x200x20x8	500	250	50	700	6	5
10	SR 850	850x200x20x8	500	250	50	750	6	5
11	SR 900	900x200x20x10	750	375	50	800	8	6
12	SR 1000	1000x200x20x8	800	400	50	900	8	6

		BHARAT HEAVY ELECTRICALS LTD., UNIT: BOILER AUXILIARIES PLANT, RANIPET - 532 406.		DRN CHD APPD	NAME A.PARASU C.GANESH C.GANESH	SIGN   	DATE 17.10.2008	NO. OF VAR -
DEPT AQCS CODE 862	GRADE OF UNTOL. DIM PR: QA: 500		SCALE N.T.S	WEIGHT (KG). *	REF. TO ASSY./OLD DRG. -	ITEM NO. -	NO. OF ITEMS -	
TITLE IPE AND SR SECTION				CARD CODE U 01	DRAWING NO. 4-79-000-00762		REV 00	

Size A4
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