

Form No:	 PE&SD	BHARAT HEAVY ELECTRICALS LIMITED PROJECT ENGINEERING & SYSTEMS DIVISION		PY 52 103
		TECHNICAL SPECIFICATION		Rev. No. 01
		REDUCER, CONCENTRIC, CARBON STEEL, BUTT WELDING		Page 1 of 2

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1.0 GENERAL

- 1.1 The Butt Welding Concentric Reducers supplied according to this specification shall conform to the requirements of latest version of ASME Standard B16.9 "Factory-Made Wrought Butt welding Fittings" and comply with the following additional requirements.
- 1.2 This specification is applicable for Concentric Reducers of sizes NPS ½" to NPS 48".

2.0 MATERIAL & CONSTRUCTION:

Material, Construction, Chemical Composition, Mechanical Properties, Heat Treatment, Testing and other requirements related to Material shall be in accordance with the ASTM Standard (latest version) as specified below:

- 2.1 For Concentric Reducers of Larger End size NPS ½" to 14":
Seamless Construction according to ASTM A234 Gr WPB.
- 2.2 For Concentric Reducers of Larger End size NPS 16" to 48":
Welded Construction according to ASTM A234 Gr WPB-W.

3.0 DIMENSIONS, TOLERANCES AND OTHER REQUIREMENTS:

Shall be as per ASME B16.9 (Latest edition).

4.0 SIZE AND THICKNESS:

Sizes of Large and Small ends of the Reducer (NPS in inches) and their corresponding Wall thicknesses (Schedule) shall be as per BHEL Enquiry/Order.

5.0 DESIGNATION:

A Concentric Reducer of Size 12" STD x 10" STD Carbon Steel, shall be designated as:
CRDCR CS 12" x 10" STD x STD BW

A Concentric Reducer of Size 12" schedule 20 x 10" schedule 30 Carbon Steel, shall be designated as:
CRDCR CS 12" x 10" SCH 20 x SCH 30 BW

A Concentric Reducer of Size 12" Thickness 10mm x 10" Thickness 8mm Carbon Steel, shall be designated as:
CRDCR CS 12" x 10" THK 10 X THK 8 BW

6.0 TECHNICAL DELIVERY CONDITIONS:

- 6.1 Unless otherwise specified on the order, IBR certification is not required.
- 6.2 All other requirements shall be as per BHEL Corporate Standard AA0851402 – Technical Delivery Conditions for Pipe Fittings. ASME Standard B16.28 referred in this TDC shall be read as ASME B16.9.

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Refer Doc	LAYOUTS & PIPING ENGINEERING	PREPARED	CHECKED	APPROVED	DATE
		 CH MANOJ	 SRIKANTH G	 S B RAO	20.07.15

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RECORD OF REVISIONS:

Rev No	Date	Revision Detail	Revised by	Approved by
01	02.05.2017	UPDATED S.NO.5: DESIGNATION	 G.KALYAN	 SRIKANTH G
00	20.07.2015	FIRST ISSUE	 SRIKANTH G	 S B RAO

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