

Form No:	 PE&SD	BHARAT HEAVY ELECTRICALS LIMITED PROJECT ENGINEERING & SYSTEMS DIVISION	PY 52 238
		TECHNICAL SPECIFICATION	Rev. No. 00
		REDUCER, CONCENTRIC / ECCENTRIC, CARBON STEEL (GALVANIZED), BUTT WELDING	Page 1 of 1

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1.0 GENERAL

- 1.1 The Butt Welding Concentric / Eccentric 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 Reducers of sizes NPS½" 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 Reducers of Larger End size NPS ½" to 14":
Seamless Construction according to ASTM A234 Gr WPB.
- 2.2 For Reducers of Larger End size NPS 16" to 48":
Welded Construction according to ASTM A234 Gr WPB-W.
- 2.3 Galvanizing shall be carried out as per ASTM A123.

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 (Galvanized), shall be designated as: *CRDCR CS (GALV) 12" x 10" STD x STD BW*

An Eccentric Reducer of Size 12" Sch 20 x 10" Sch 30 Carbon Steel (Galvanized), shall be designated as: *ERDCR CS (GALV) 12" x 10" SCH 20 x SCH 30 BW*

A Concentric Reducer of Size 12" Thk 10mm x 10" Thk 8mm Carbon Steel (Galvanized), shall be designated as: *CRDCR CS (GALV) 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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RECORD OF REVISIONS:

Rev	Date	Revision Detail	Revised by	Approved by
00	20.07.2018	FIRST ISSUE	 G.KALYAN	 SRIKANTH G

Refer Doc	LAYOUTS & PIPING ENGINEERING	PREPARED	CHECKED	APPROVED	DATE
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