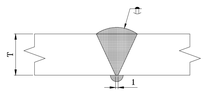
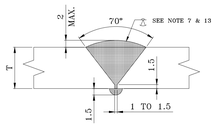
DRAWING NO. 15410001015



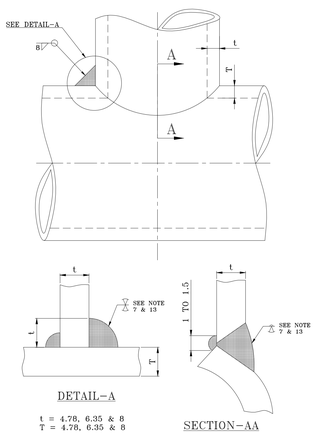
GAP INDICATED IS FOR REFERENCE ONLY TO BE SELECTED SUITABLE FOR ACHIEVING PROPER FUSION AND PENETRATION

FIG-1-LONGITUDINAL AND CIRCUMFERENTIAL WELD (UP-TO 4.8TK)



(i) FOR 4.78 TK. EDGE PREPARATION IS NOT COMPULSORY.
(ii) ABOVE 4.78 TK. EDGE PREPARATION IS A MUST.

FIG-2-LONGITUDINAL AND CIRCUMFERENTIAL WELD



t = 4.78, 6.35 & 8
T = 4.78, 6.35 & 8

FIG-3- ENCLOSURE INTERSECTION

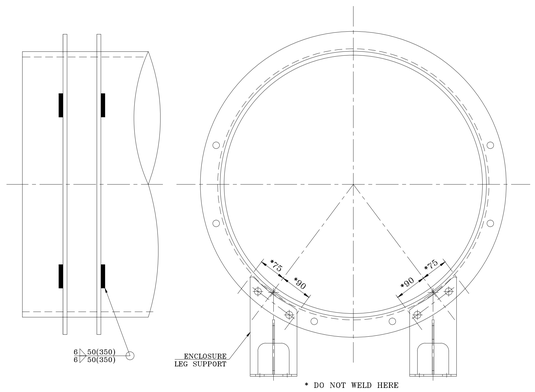


FIG-4- SUPPORT CHANNEL WELDING

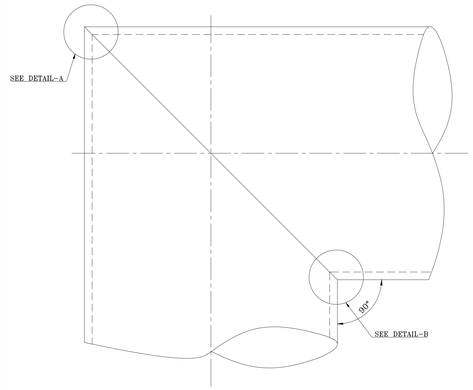
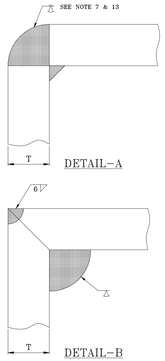


FIG-8- ENCLOSURE MITRE WELD



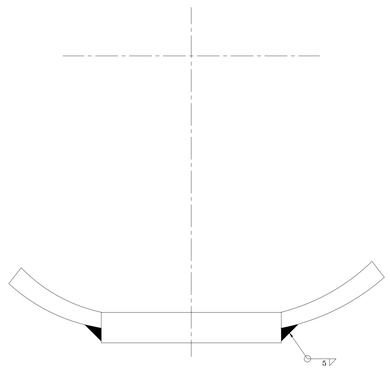


FIG-13- INSULATOR MOUNTING PLATE WELDING (FOR 500 ø ENCLOSURE)

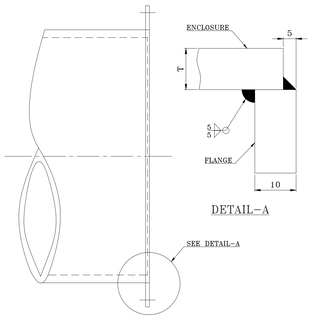


FIG-6- FLANGE WELDING

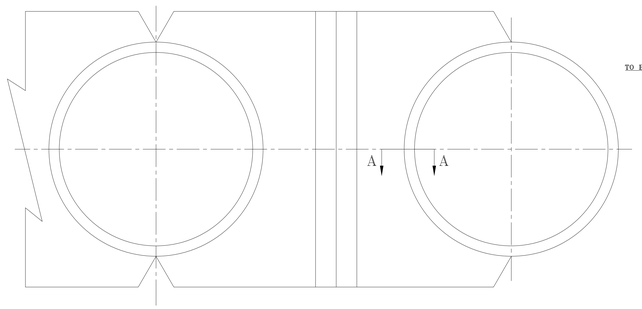
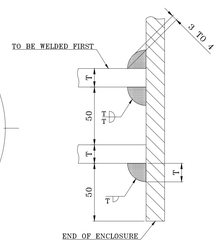


FIG-7- SHUNT WELDING



SECTION-AA

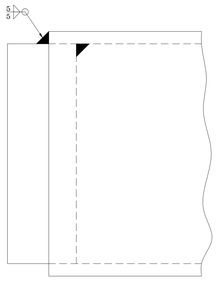


FIG-5- ENCLOSURE TO BACKING TUBE WELDING ARRANGEMENT

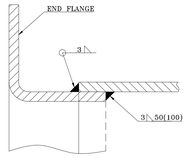


FIG-11- SPB FLANGE WELDING DETAILS

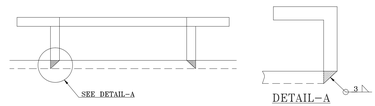
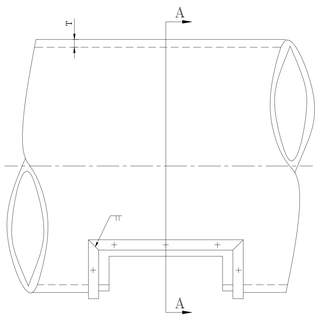
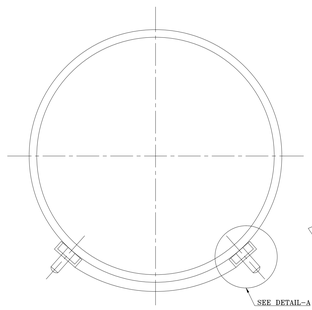
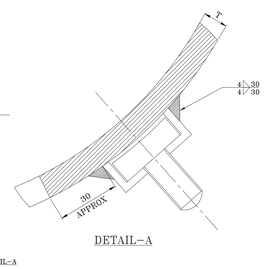


FIG-12-SPB WINDOW FLANGE WELDING DETAILS





SECTION-AA



DETAIL-A

FIG-9- SCREW RETAINING CHANNEL WELDING

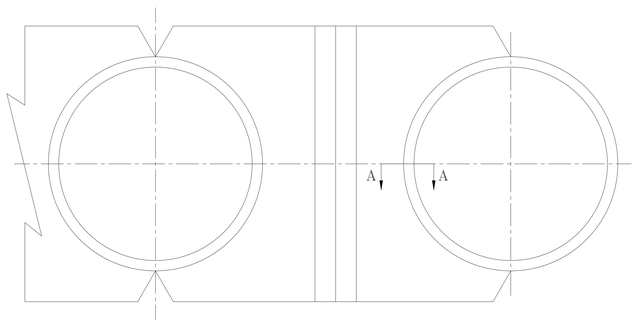
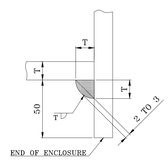


FIG-10- SHUNT WELDING FOR TAP-OFF



SECTION-AA

NOTES:-

1. FOR WELDING USE TYPE NG 21 (5% SILICON ALLOY) WELDING ROD TO IS 739/BS 29011955.
2. WELDING PROCESS WILL BE ARGON ARC.
3. SCREW TO BE PLACED BEFORE WELDING RETAINING CHANNEL.
4. WELD ON OUTER SIDE OF SCREW RETAINING CHANNEL OPPOSITE TO SCREW.
5. CURVED CHANNELS ARE KEPT SLIGHTLY LONGER AND SHALL BE CUT SUITABLY.
6. AT WELDING STAGE PROVIDE GAP FREE JOINT AT BOLT RETAINING CHANNEL & CORNERS.
7. ALL WELDS TO BE SEAL WELDED. (FOR IPBD ONLY)
8. AFTER WELDING ALL THE SPATTERS, FLAKES ETC MUST BE REMOVED.
9. ALL WELDED JOINTS MUST FORM SOUND JOINT AND BE FREE WELDING DEFECT.
10. WHERE EVER SEALING WELDING IS NOT CALLED REMOVE ALL WELDING SPATTERS FLAKES ETC FROM INSIDE OF THE ENCLOSURES.
11. FOR 4.8 MM THICK SHEETS USE TIG / MIG WELDING.
12. ALSO WELD ON INNER SIDE OF SCREW RETAINING CHANNEL OPPOSITE TO ALTERNATE SCREWS.
13. LONGITUDINAL WELDS IN WELDED ASSY. OF CONSECUTIVE SECTIONS TO BE STAGGERS WELDED. (FOR IPBD ONLY)
14. FOR WELDING PROCEDURE REFER BUSDUCT STANDARD NO. BD: 15001 W.
15. REFER CODE OF PRACTICE FOR AL. WELDING IN BUSDUCT NO. BD: 15010 W.

FIRST ANGLE PROJECTION
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PROJECT –

भारत हैवी इलेक्ट्रिकल्स लिमिटेड - रुदपुर
BHARAT HEAVY ELECTRICALS LIMITED RUDRAPUR

	NAME	SIGN.	DATE	NO. OF VAR.
DRN.			–	
CKD.	एस॰ के॰ गुप्ता		–	
APPD.	आर॰ के॰ लाल		–	

REV.	DATE	ALTERD	REV.	DATE	ALTERD	REV.	DATE	ALTERD
		CHEKED			CHEKED	15	03.07.12	CHEKED

DRG. RETRACE BY RUDRAPUR

DEPTT.	UNTOL.DIM.GR.	SCALE	WEIGHT-KG	REF.TO ASSY.DRG.	IT.NO.	NO.OF ITEM
ECC	C/M/F	–	–	–	–	

TITLE: STANDARD WELDING FOR ENCLOSURE

DRAWING NO. 15410001015 REV. 15

SHEET NO.- 01 NO.OF SHEETS- 01 SIZE- A1