
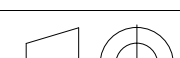


NOTES:—

1. FOR STRAIGHT BUSBAR BUTT WELD IN QUARTER OCTAGON/ CIRCULAR SHALL BE DONE AT SIMILAR LOCATION AND SHALL BE OF EQUAL LENGTH AS THAT OF SPACER. FOR PITCHES OF SPACERS REFER PROJECT DRG. BUTT WELD SHALL BE AVOIDED AT SLOT LOCATION ADDITIONAL 25mm. BUTT WELD WILL BE DONE AT BOTH ENDS OF SLOT. WELDING WILL NOT BE DONE IN OFF CUT- PORTIONS FOR MAKING ANGULAR-BUSBAR.
2. FOR WELDING USE TYPE NG 21 (5% SILICON ALLOY) WELDING ROD TO BS:2901:1955/IS:739.
3. WELDING PROCESS WILL BE ARGON ARC.
4. ALL SHARP EDGES OF FINISHED CONDUCTOR ARE TO BE ROUNDED OF WITHIN 3mm RADIUS.
5. BACKING WELD SHALL BE DONE ONLY FOR SINGLE CHANNEL BUSBAR AND BACKING WELD WILL NOT BE DONE FOR BUSBAR BOX FORMED OUT OF TWO CHANNELS.
6. IMP-ALL THE WELDING FLAKES/SPATTERS ETC. MUST BE REMOVED.
7. BACKING WELD SHALL BE DONE ON ENDS OF CONDUCTOR WELDING LENGTH SHALL BE EQUAL TO THE LENGTH OF SPACER USED APPLICABLE FOR FIGS. 1,4,5,6,9,17,18,&19.
8. FOR WELDING PROCEDURE REFER BUSDUCT STANDARD NO: BD -15002 W.
9. REFER CODE OF PRACTICE FOR AL. WELDING IN BUSDUCT NO: BD :15010 W.
- 10.FOR FIG 1,4,5,6,9,11,17&18 PARTIAL PENETRATIONS WELD ACCEPTABLE.
- 11.FOR ASSY. OF CIRCULAR CONDUCTOR REF. DRG, NO.35415151112.

		CUSTOMER			—			PROJECT				—						
		भारत हेवी इलेक्ट्रिकल्स लिमिटेड - रुद्रपुर BHARAT HEAVY ELECTRICALS LIMITED RUDRAPUR							DRN.		NAME		SIGN.		DATE		NO. OF VAR.	
									CKD.		एन. के. गुप्ता		—		—			
									APPO.		आर. के. नान		—		—			
									REF. TO. ASSY.DRG.		—		—		—			
									IT.NO.		—		—		—			
DEPTT.		UNTO L.DIM.GR.				SCALE		WEIGHT—KG						NO. OF ITEM				
ECC		C/M/F				—		—										
TITLE		STANDARD WELDING FOR COND										DRAWING NO. 15410001013				REV. 12		
										SHEET NO.— 01		NO.OF SHEETS— 01				SIZE— A1		