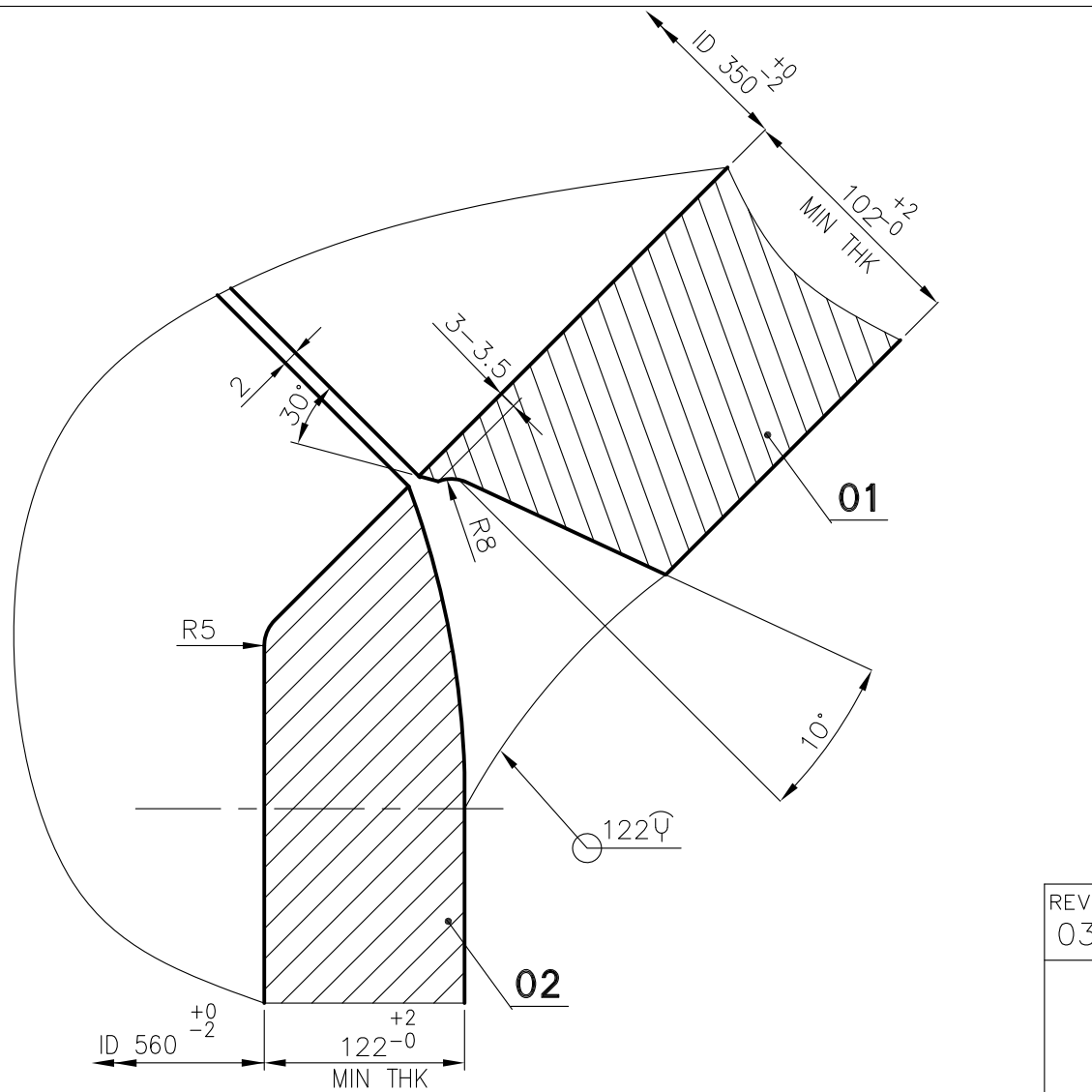
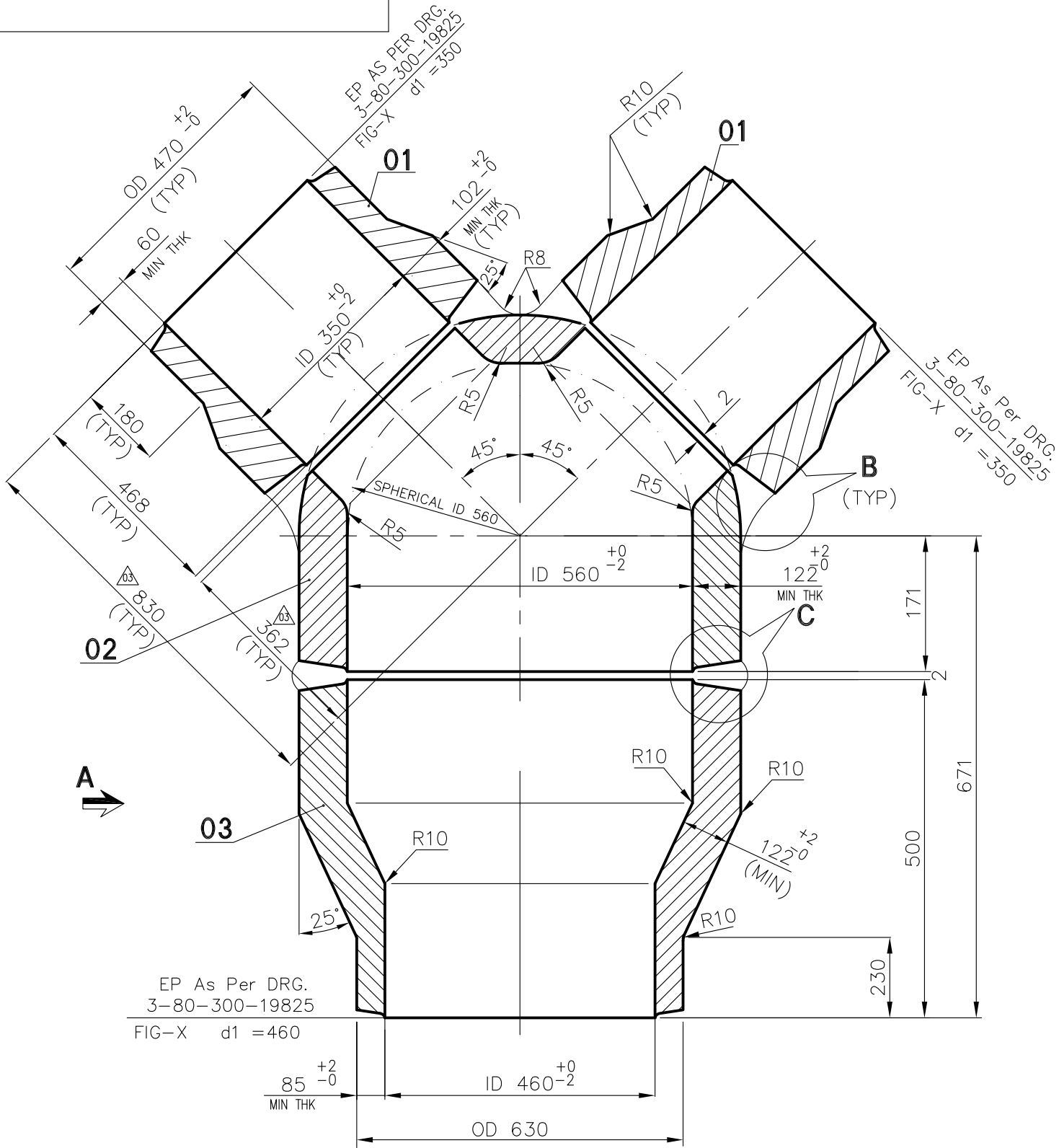


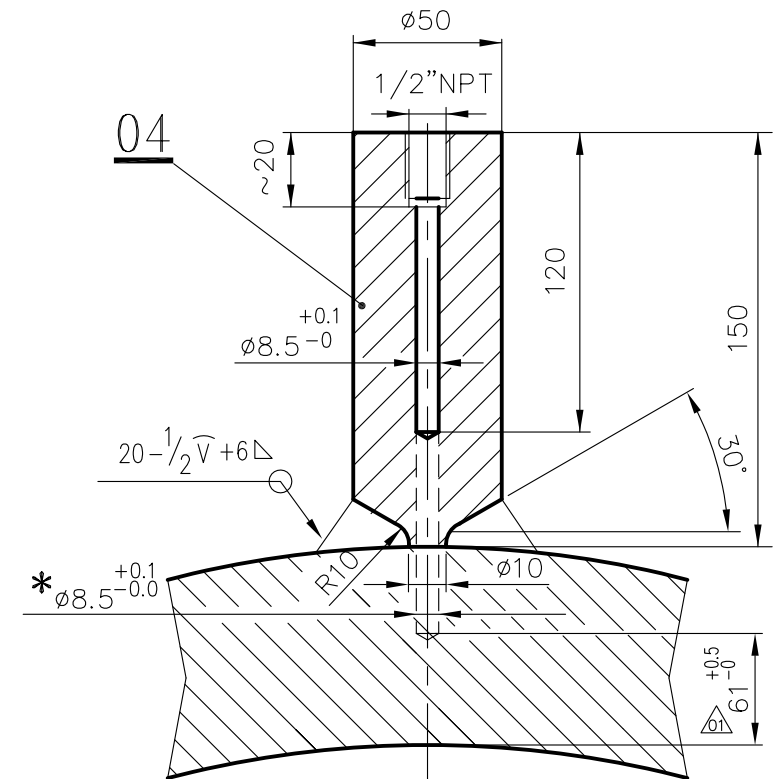
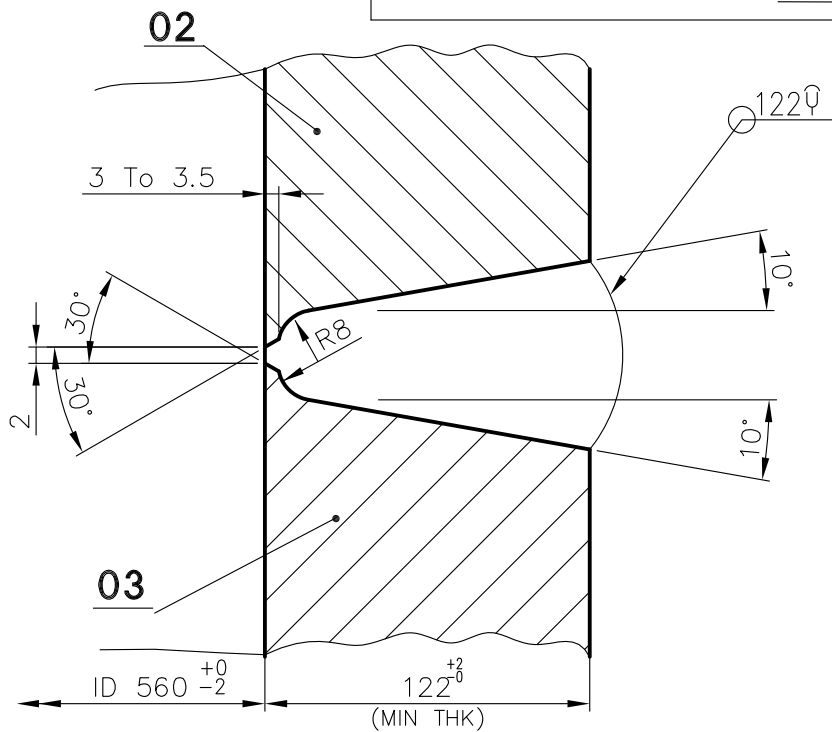
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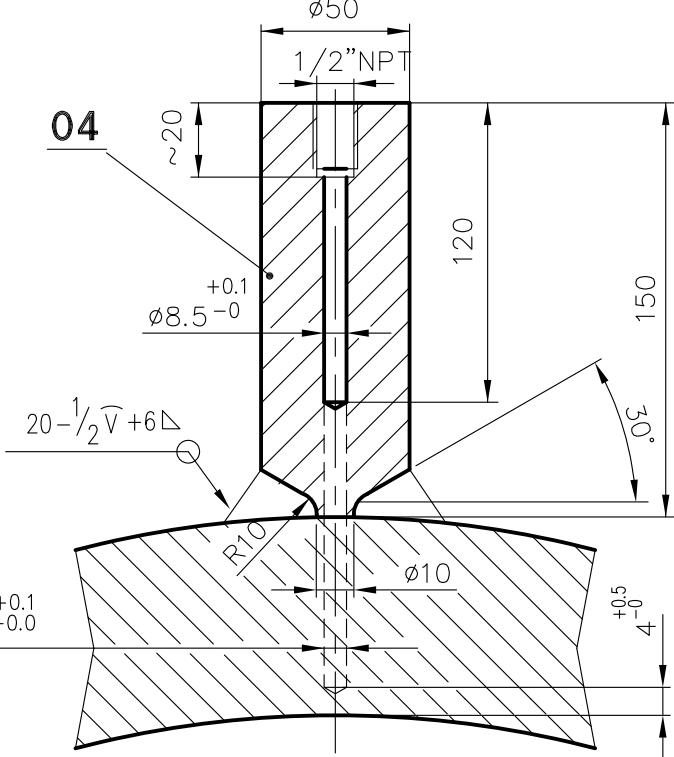
DETAIL-B

DETAIL-C



* AFTER WELDING THE STUB, BORE $\phi 8.5^{+0.1}_{-0}$ mm AS PER THE DRG.

DETAIL-D

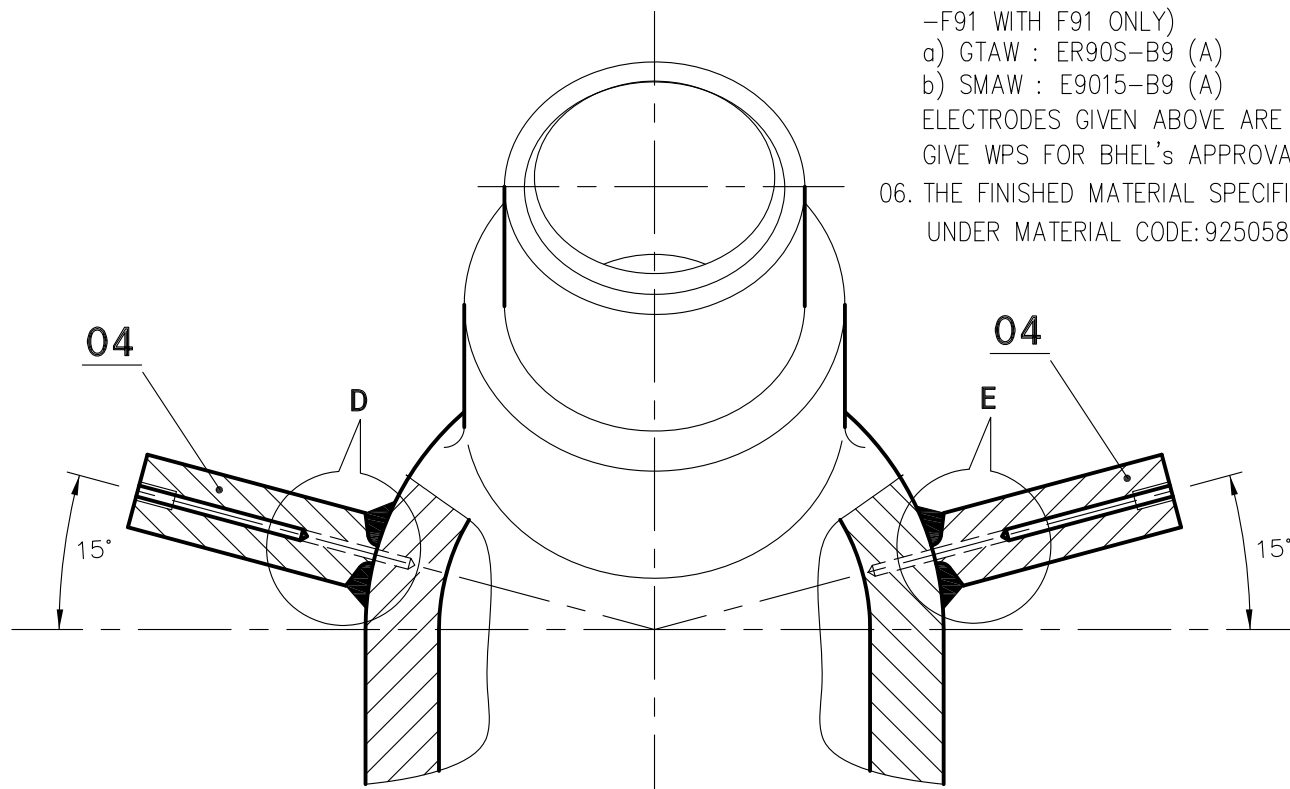


* AFTER WELDING THE STUB, BORE $\phi 8.5^{+0.1}_{-0}$ mm AS PER THE DRG.

DETAIL-E

NOTES :-

01. DESIGN PRESSURE : 272 Kg/Cm² (g)
02. DESIGN TEMPERATURE : 568° C
03. FOLLOW TDG:108. LATEST
04. PIPE SA335P91(A) CAN ALSO BE USED IN PLACE OF SA182F91(A).
05. ELECTRODES TO BE USED ARE (FOR WELDING OF -F91 WITH F91 ONLY)
- a) GTAW : ER90S-B9 (A)
- b) SMAW : E9015-B9 (A)
- ELECTRODES GIVEN ABOVE ARE INDICATIVE. VENDOR TO GIVE WPS FOR BHEL's APPROVAL.
06. THE FINISHED MATERIAL SPECIFICATION WILL BE SA182F91(A) UNDER MATERIAL CODE:925058790000



VIEW-A

ITEM NO	DESCRIPTION	DRAWING NO	MATERIAL CODE	UNIT WEIGHT
04	TEMP. STUB. $\phi 50$ L=150	2-80-301-10066	SA 182 F91	4
03	OUTLET FORGING ID560 x THK122 MIN / ID460 x 85 MIN THK	2-80-301-10066	SA 182 F91	845
02	BODY FORGING ID 560 x THK 122 MIN	2-80-301-10066	SA 182 F91	555
01	INLET FORGING ID 350 x THK 102 MIN	2-80-301-10066	SA 182 F91	312
VAR NO	ITEM NO	DESCRIPTION	DRAWING NO	MATERIAL CODE
JOB NO.	REL NO.	DATE	QUANTITY	

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT



BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, CHENNAI 600 017

DEPT.	GRADE OF UN TOL. DIM	SCALE	WEIGHT (Kg).	BHEL PO REF. NO.	ITEM No.
CODE	C/M/F	N.T.S.	1632.000		
TITLE	Y-PIECE (ID460x85/ID350x60) SA182F91	U 01	2-80-301-10066	04	