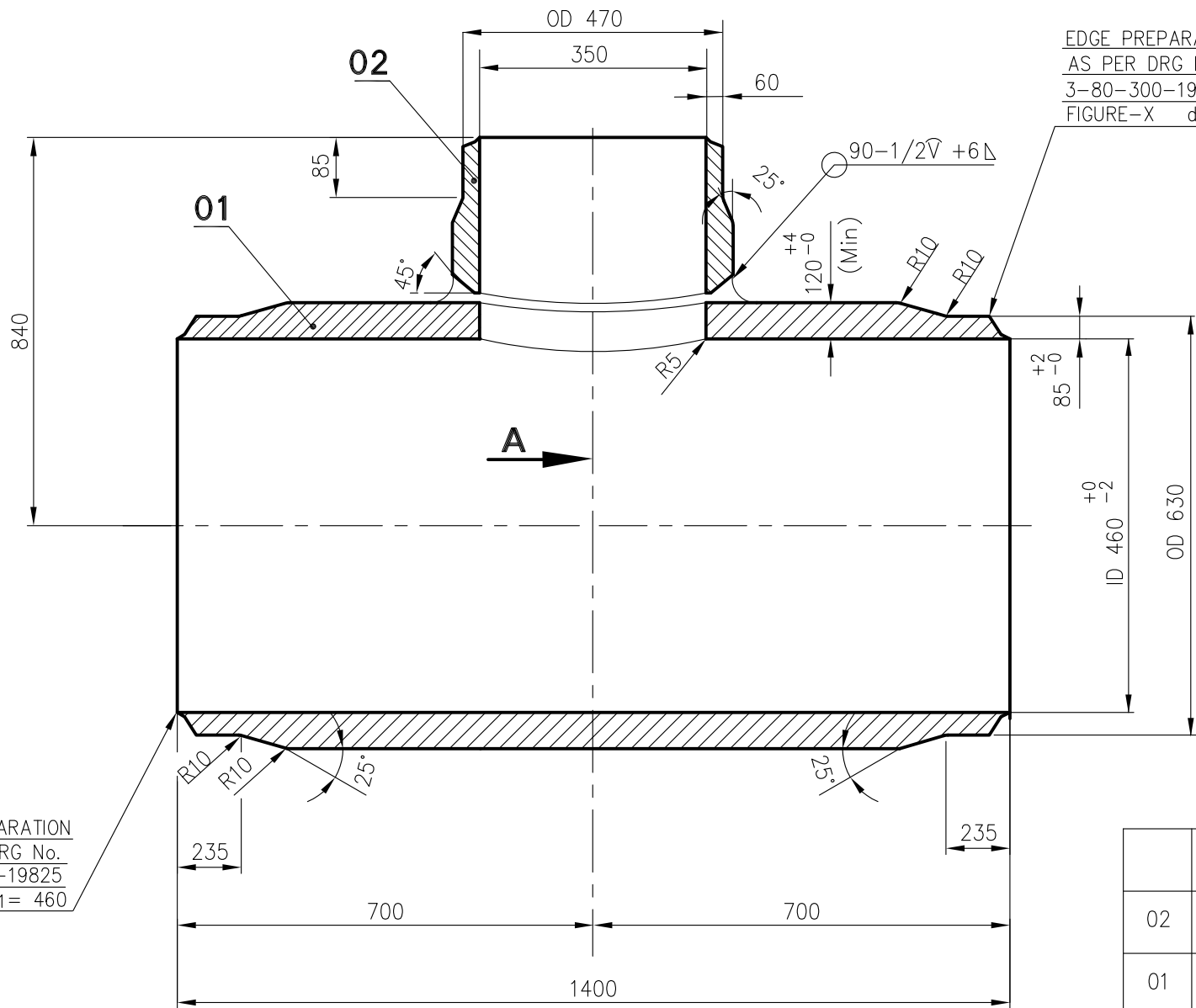


CAUTION THE INFORMATION ON THIS DOCUMENT IS THE PROPERTY OF BHARAT HEAVY ELECTRICALS LIMITED. IT MUST NOT BE USED DIRECTLY OR INDIRECTLY IN ANY WAY DETRIMENTAL TO THE INTEREST OF THE COMPANY

3-80-301-27185

DRAWING No

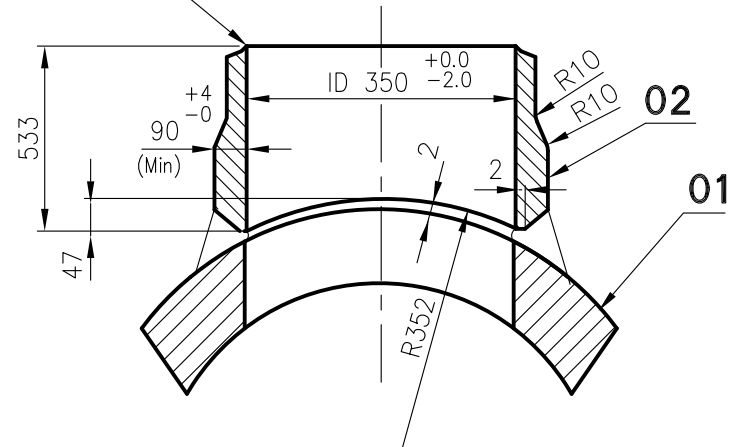


EDGE PREPARATION
AS PER DRG No.
3-80-300-19825
FIGURE-X d₁ = 460

EDGE PREPARATION
AS PER DRG No.
3-80-300-19825
FIGURE-X d₁ = 350

NOTES :-

- DESIGN PRESSURE : 272 Kg/Sq.Cm (g)
- DESIGN TEMPERATURE : 573° C
- FOLLOW TDG : 108 LATEST
- ELECTRODES TO BE USED ARE,
a) GTAW : ER90S-B9 (A)
b) SMAW : E9015-B9 (A)
ELECTRODES GIVEN ABOVE ARE INDICATIVE. VENDOR TO GIVE WPS FOR BHEL's APPROVAL.
- PIPE SA335P91(A) CAN ALSO BE USED IN PLACE OF SA182F91(A).
- THE STOCK CODE FOR FINISHED UEQ. TEE: 92508810000



SECTION-AA

EDGE PREPARATION
AS PER DRG No.
3-80-300-19825
FIGURE-X d₁ = 460

ITEM NO.	DESCRIPTION	DRAWING NO.	ITEM NO.	MATERIAL CODE	A	UNIT WT.
02	BRANCH NOZZLE L=531 ID 350 x Thk 90 Min	3-80-301-27185		SA 182 F91	A	518,310 1
01	BASE PIPE L = 1400 ID 460 x Thk 120 Min	3-80-301-27185		SA 182 F91	A	2401,800 1
ITEM NO.	DESCRIPTION	DRAWING NO.	ITEM NO.	MATERIAL SPEC.	C	QTY.

TYPE OF PRODUCT
OR NAME OF
CUSTOMER/PROJECT



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

NAME	SIGN	DATE	NO OF ITEMS
DRN LALIT		07.05.10	
CHD C.SARAVANAN		07.05.10	
APPD C.SARAVANAN		07.05.10	

DEPT.	GRADE OF UN TOL. DIM	SCALE	WEIGHT (Kg).	BHEL PO REF.NO:	ITEM No.
CODE	C/M/F	N.T.S.	2921.000		
TITLE FABRICATED UNEQUAL TEE (ID460x85/ID350x60) (SA182F91)			CARD CODE U 01	DRAWING No. 3-80-301-27185	REV 01

REV	DATE	ALTD	REV	DATE	ALTD
02		APPD	01	14.08.2012	APPD S.PANDA -SD.-
ZONE			ZONE		DESIGN PRESSURE ALTERED REVISION INDICATED AS 01