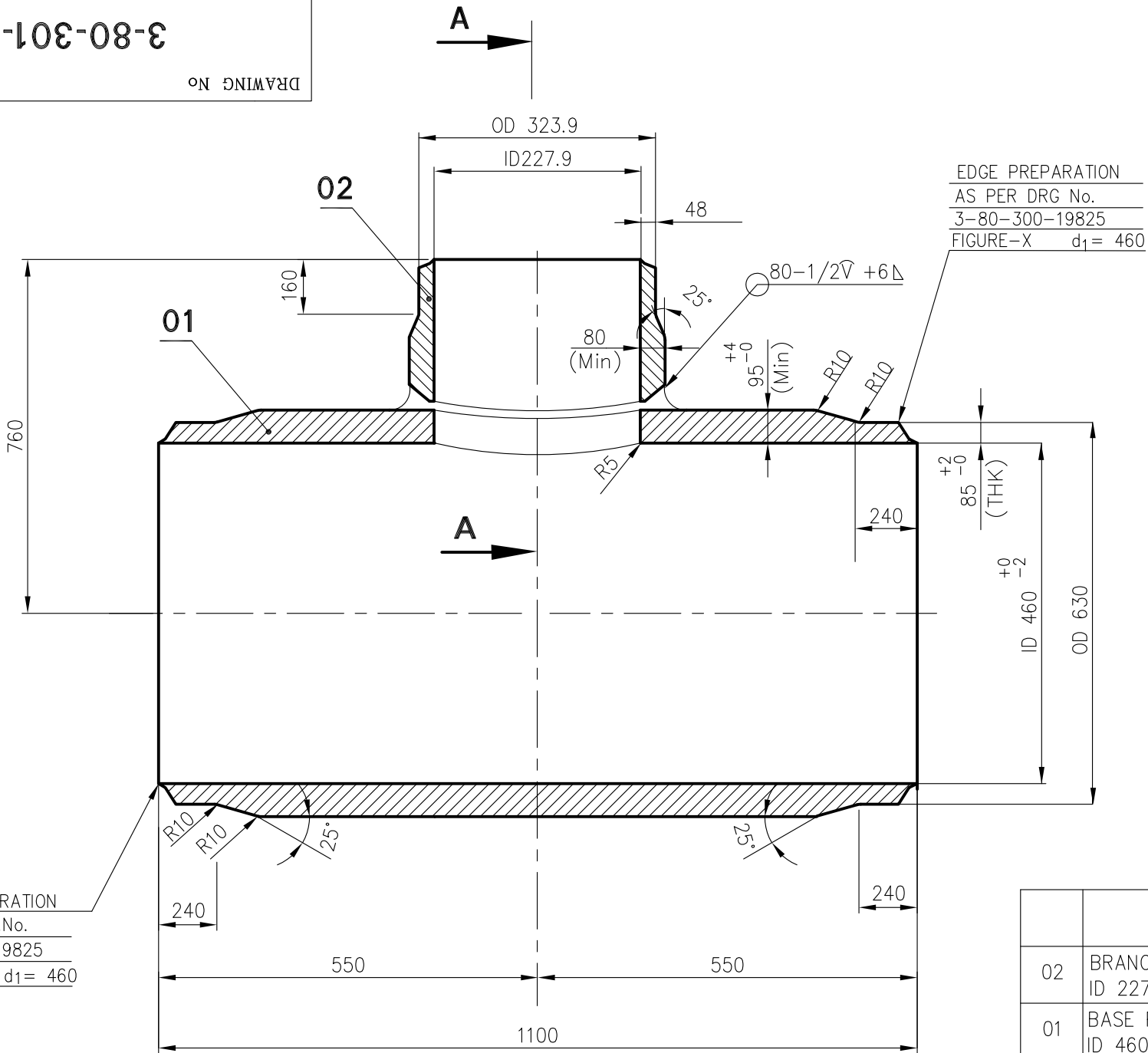


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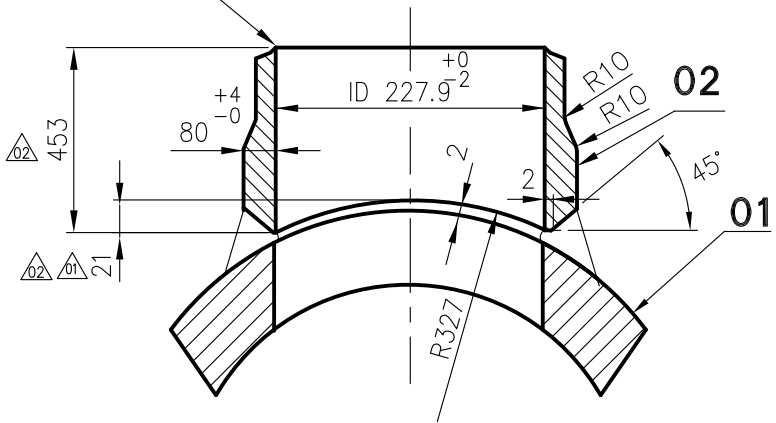
3-80-301-27186

DRAWING No



- NOTES :-**
1. DESIGN PRESSURE : 272 Kg/Sq.Cm (g)
2. DESIGN TEMPERATURE : 573° C
3. FOLLOW TDG : 108 LATEST
4. 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.
5. PIPE SA335P91(A) CAN ALSO BE USED IN PLACE OF SA182F91(A).
6. THE STOCK CODE FOR FINISHED UEQ. TEE: 925058800000.

EDGE PREPARATION
AS PER DRG No.
3-80-300-19825
FIGURE-X d₁= 231.3



SECTION-AA

02	BRANCH NOZZLE L=459 ID 227.9 x Thk 80 Min	3-80-301-27186	SA 182 F91	A	278,684 1
01	BASE PIPE L = 1100 ID 460 x Thk 95 Min	3-80-301-27186	SA 182 F91	A	1429,580 1
ITEM NO.	DESCRIPTION	DRAWING NO.	ITEM NO. VAR NO.	MATERIAL CODE MATERIAL SPEC.	UNIT WT. QTY.
TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT					
 BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, CHENNAI 600 017			NAME	SIGN	DATE
DEPT.			DRN	LALIT	-SD.-
GRADE OF UN TOL DIM			CHD	C.SARAVANAN	-SD.-
C/M/F			APPD	C.SARAVANAN	-SD.-
SCALE			WEIGHT (Kg).	BHEL PO REF.NO:	ITEM No.
N.T.S.			1709.000		
TITLE			CARD CODE	DRAWING No.	REV
FABRICATED UNEQUAL TEE (ID460x85/OD323.9x48) (SA182F91)			U 01	3-80-301-27186	03

REV 03	DATE 14.08.2012	ALTD : K.BOOPALAN -SD.- APPD : S.PANDA -SD.-	REV 02	DATE 04.03.11	ALTD : LALIT -SD.- APPD : C.SARAVANAN-SD.-	REV 01	DATE 21.02.11	ALTD : LALIT -SD.- APPD : C.SARAVANAN-SD.-
ZONE	DESIGN PRESSURE ALTERED REVISION INDICATED AS 03		ZONE	DIMENSION REVISED IN SECTION-AA REVISION INDICATED AS 02		ZONE	REVISION MARKED AS 01	