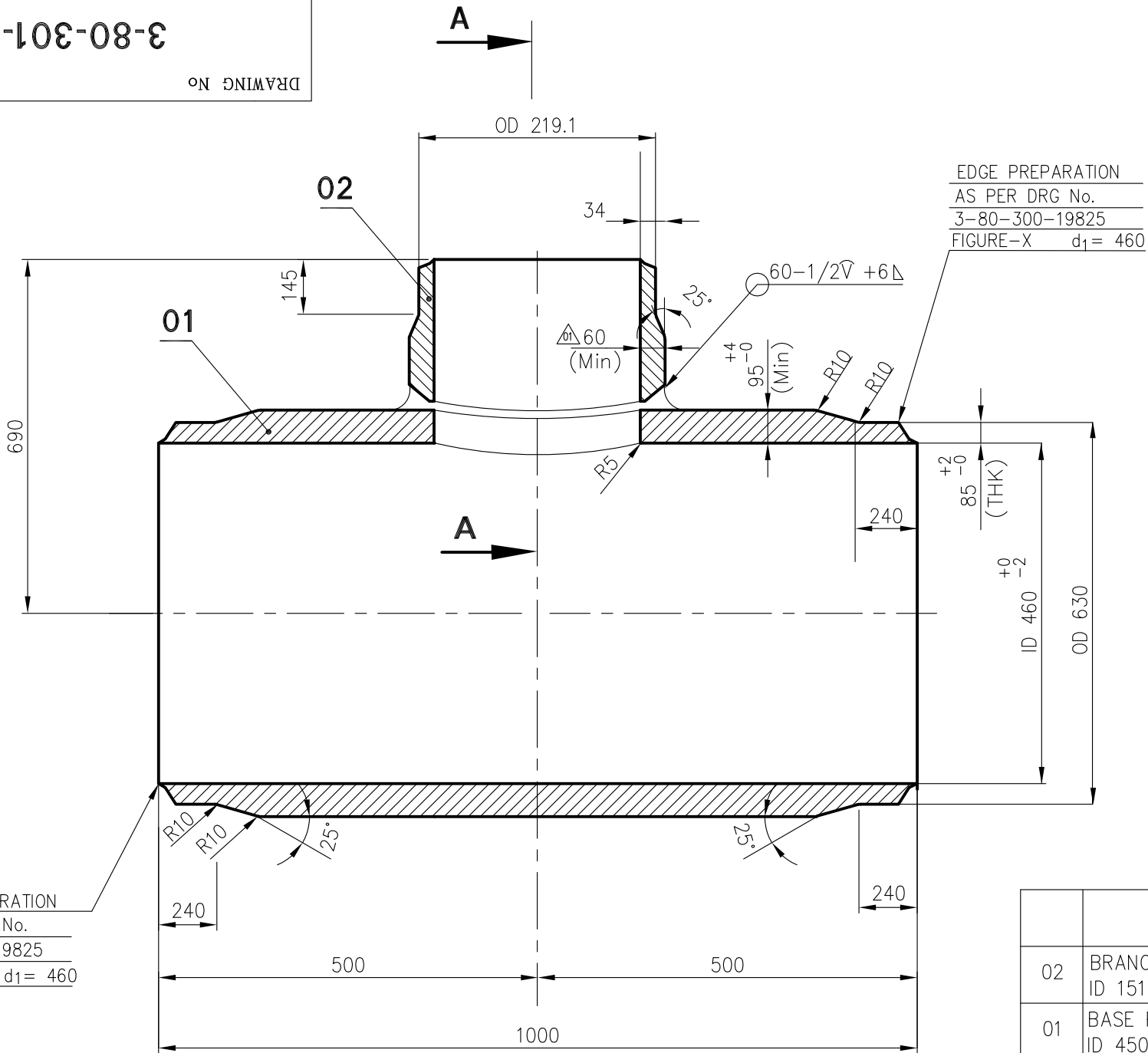


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26172-103-08-3

DRAWING No

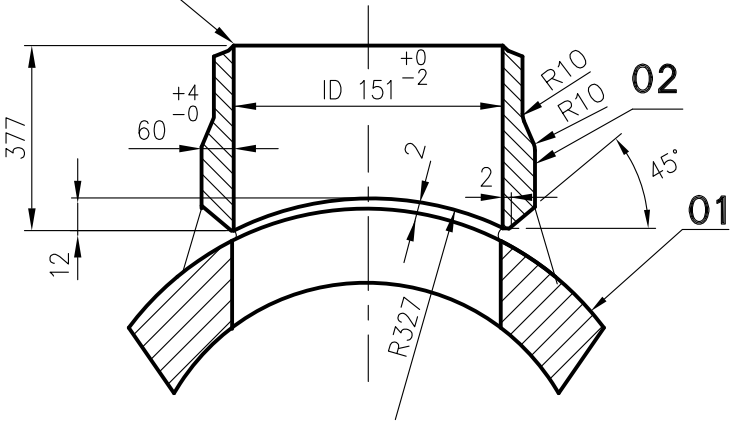


EDGE PREPARATION
AS PER DRG No.
3-80-300-19825
FIGURE-X d₁= 156.4

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: 925058820000

12.5



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=377 ID 151 x Thk 60 Min	3-80-301-27192		SA 182 F91	A	117,700 1
01	BASE PIPE L = 1000 ID 450 x Thk 95 Min	3-80-301-27192		SA 182 F91	A	1299,610 1
ITEM NO.	DESCRIPTION	DRAWING NO.	ITEM NO.	MATERIAL CODE	A	UNIT WT.
			VAR 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	-SD.-	07.05.10	
CHD C.SARAVANAN	-SD.-	07.05.10	
APPD C.SARAVANAN	-SD.-	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.	1418.000		

TITLE	CARD CODE	DRAWING No.	REV
FABRICATED UNEQUAL TEE (ID460x85/OD219.1x34) (SA182F91)	U 01	3-80-301-27192	02

REV 02	DATE 14.08.2012	ALTD K.BOOPALAN –SD.– APPD S.PANDA –SD.–	REV 01	DATE 04.03.11	ALTD LALIT –SD.– APPD C.SARAVANAN–SD.–
ZONE	DESIGN PRESSURE ALTERED REVISION INDICATED AS 		ZONE	DIMENSION REVISED AS MARKED. REVISION INDICATED AS 	