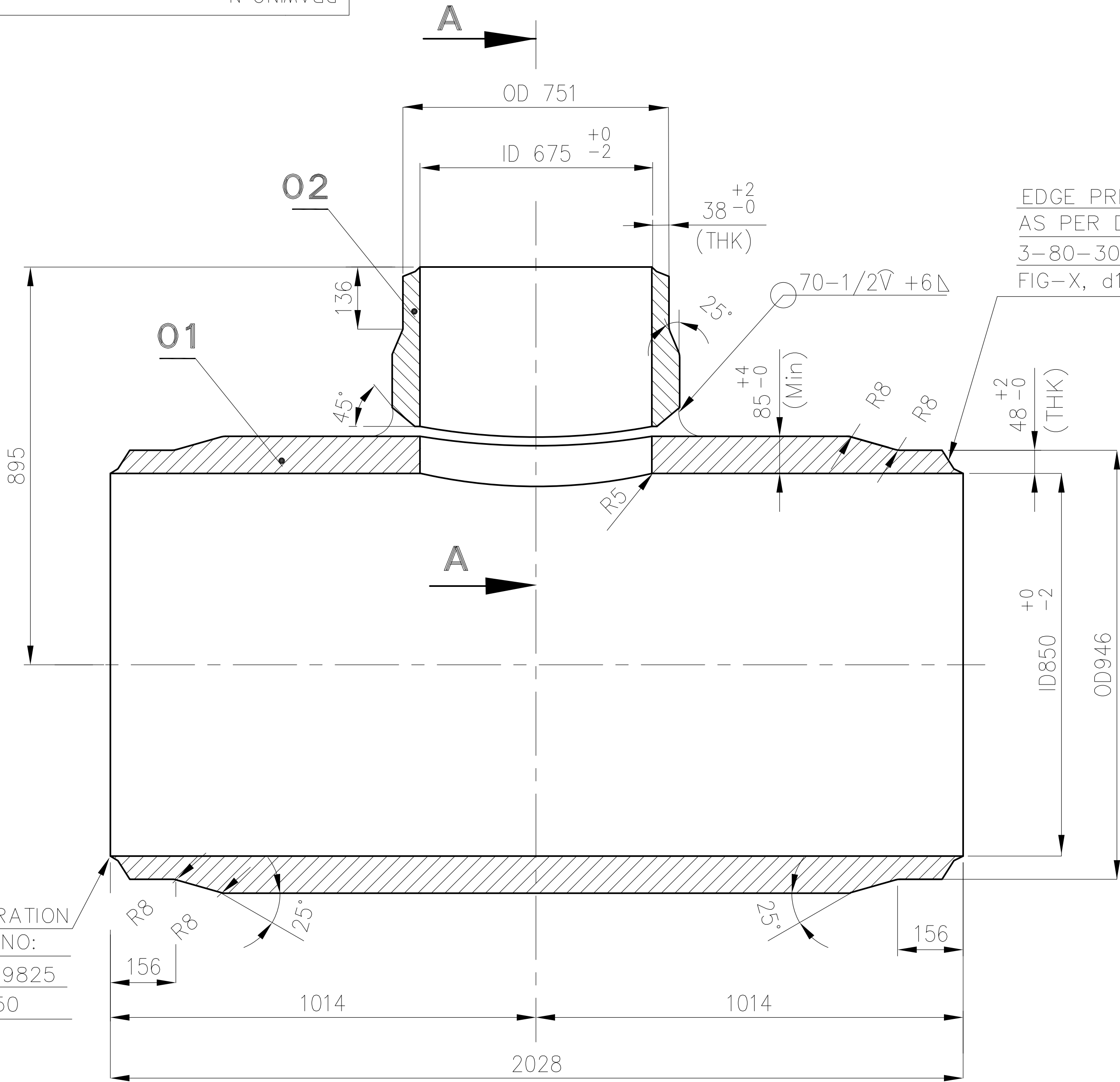


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3-80-310-30688

DRAWING No



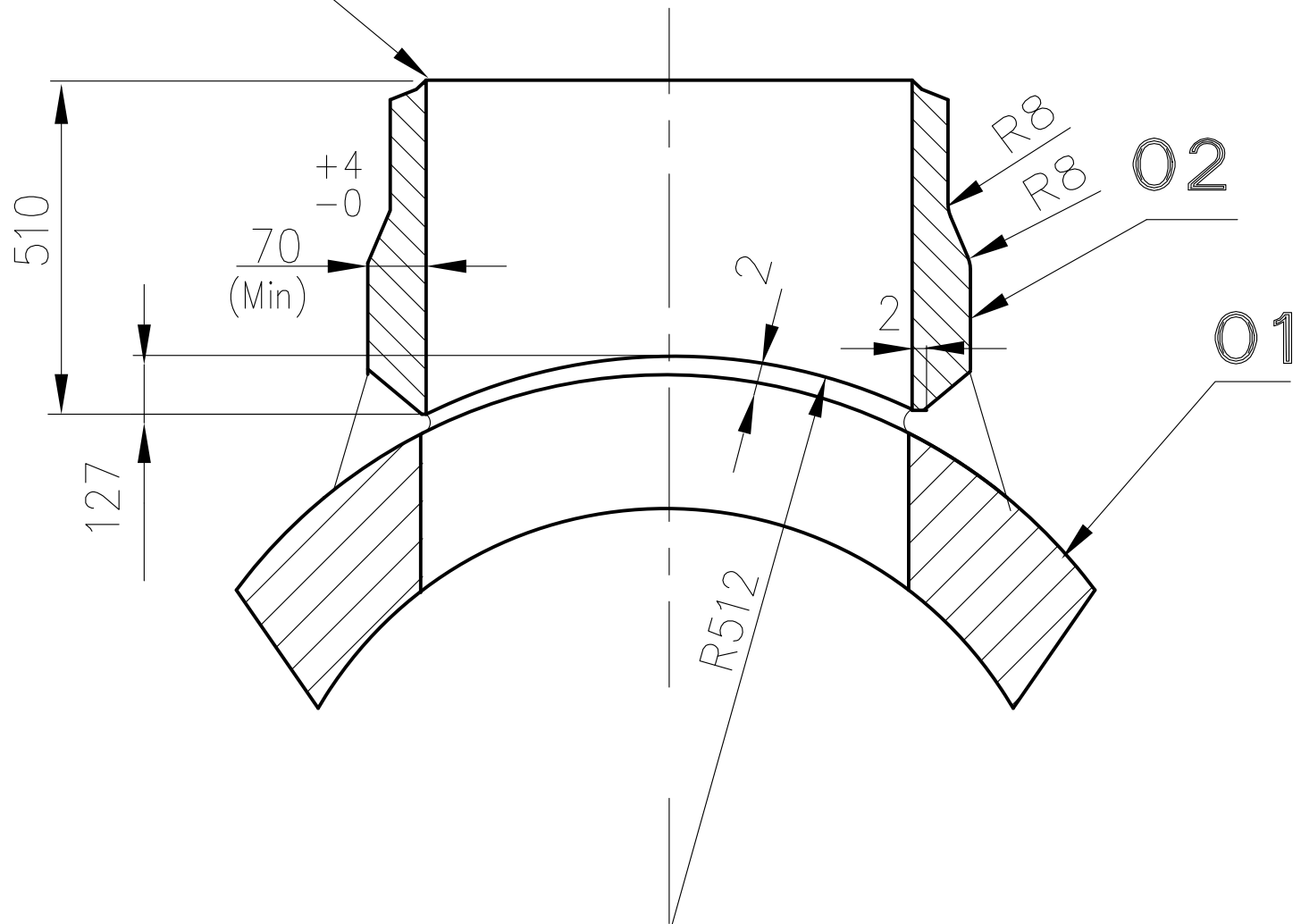
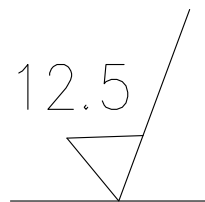
EDGE PREPARATION
AS PER DRG.NO:
3-80-300-19825
FIG-X, d1=850

EDGE PREPARATION
AS PER DRG.NO:
3-80-300-19825
FIG-X, d1 =850

EDGE PREPARATION
AS PER DRG.NO:
3-80-300-19825
FIG-X, d1=675

NOTES :-

- DESIGN PRESSURE : 70 Kg/Sq.Cm (g)
- DESIGN TEMPERATURE : 601° C
- FOLLOW TDG : 108
- 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 THE FINISHED UEQ. TEE:92 505 610 0000



SECTION-AA

02	BRANCH NOZZLE L=510 ID 675 x Thk 70 Min	3-80-310-30688		SA 182 F91	A	---
						1
01	BASE PIPE L = 2028 ID 850 x Thk 85 Min	3-80-310-30688		SA 182 F91	A	---
						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

DRN	NAME KONDAPA	SIGN	DATE 07.06.13	NO OF ITEMS
CHD	KONDAPA		07.06.13	
APPD	R.SESHAGIRI		07.06.13	

DEPT.	GRADE OF UN TOL. DIM		SCALE	WEIGHT (Kg).	BHEL PO REF.NO:	ITEM No.
CODE	C/M/F		N.T.S.	3860		
TITLE				CARD CODE	DRAWING No.	REV
FABRICATED UNEQUAL TEE (ID850X48/ID675X38) SA182F91				U 01	3-80-310-30688	00

REV 02	DATE	ALTD : APPD :	REV 01	DATE	ALTD : APPD :
ZONE			ZONE		