

CL12-U/SC/371 NO DRG

(ALL DIMENSIONS ARE IN mm)

TECHNICAL PARTICULARS OF HOT-DIP GALVANIZED STEEL

FABRICATION FOR INSTRUMENT TRANSFORMER

1-Applicable Standards - The material & process of galvanization and other relevant specifications should comply to the following latest Indian standard specifications:-

(a) Steel IS: 226

(b) Quality of zinc IS: 209 High Grade Electrolytic zinc

(c) Practice of Hot Dip IS: 2629

Galvanization on Iron or steel

(d) Testing of uniformity of zinc coating IS: 2633

(e) Hardwares (Metric) IS: 1363

(f) Galvanization on Hardwares IS: 1367 (PART - XII) with minimum

Mass of coating 300 gm/m²

2-Average thickness of zinc coating on steel structure shall be 85 microns (0.085 mm). It shall not be less than 60 microns at any place.

3-Mass of zinc coating shall be 610 gm/m² (minimum value).

4-All externally threaded hardwares like bolts, studs etc used shall be under cut 0.1 to 0.15 mm before galvanizing to receive zinc coating during hot-dip galvanizing the threads to be cleaned & retapped after 10 to 15 days to final size or per IS: 1363 for a tolerance grade of Gg.

5-All the internal threads of welded items & loose nuts are to be retapped after galvanizing to correct size to a tolerance class of G.H. These threads are not to be under cut before H.D.G.

6-All excess zinc must be removed from corner surfaces. EXCESS zinc from the surfaces which will receive gasket, must be removed thoroughly and the surface must be plain to avoid oil leakage from inside of assembly of equipment.

7-Any distortion which gets developed during dipping must be set right before despatch.

8-Matching part of one unit should be marked to avoid their interchange.

9-All the threaded parts shall be lightly greased. Wrenches & pieces having suitable holes shall be fitted on studs/bolts to avoid damage during transit & handling.

10-Ltmost care must be taken to clean & make rust free all the steel items before hot dip galvanizing.

ADDITIONAL INFORMATION

STATUS OF DRAWING

DISTRIBUTION OF PRINTS

RE 2 1 1 2

RE 2 1 1 2

RE 2 1 1 2

RE 2 1 1 2

RE 2 1 1 2

RE 2 1 1 2

RE 2 1 1 2

RE 2 1 1 2

RE 2 1 1 2

TYPE OF PRODUCT OR

NAME OF CUSTOMER/PROJECT



BHARAT HEAVY ELECTRICALS LIMITED
JHANSI

DEPT GRADE OF UN TOL DIM C/M/F



SCALE

WEIGHT (KG)

REF TO ASSY DRG

ITEM NO

CODE

GRADE OF UN TOL DIM C/M/F

SCALE

WEIGHT (KG)

REF TO ASSY DRG

ITEM NO

TITLE NOTES FOR HOT-DIP GALVANIZED STEEL FABRICATION

FOR INSTRUMENT TRANSFORMER

CARD

DRAWING NO

RE

FOR INSTRUMENT TRANSFORMER

CARD

DRAWING NO

RE

RE 2 1 1 2

RE 2 1 1 2

RE 2 1 1 2

CODE

CODE

CODE

GRADE OF UN TOL DIM C/M/F

GRADE OF UN TOL DIM C/M/F

GRADE OF UN TOL DIM C/M/F

SCALE

SCALE

SCALE

WEIGHT (KG)

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