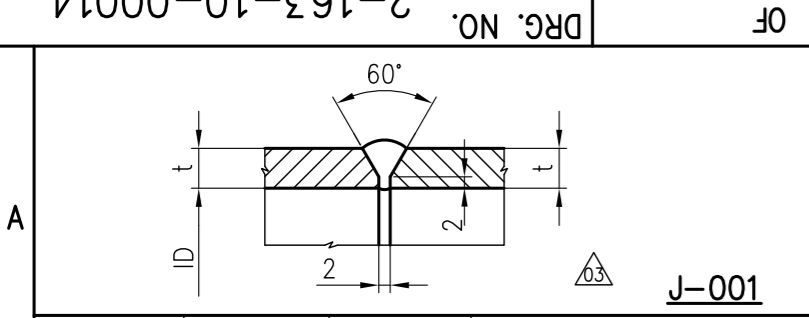
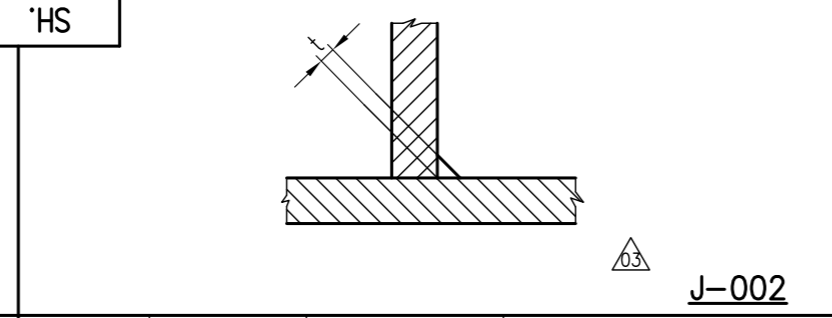


DRG. NO. 2-163-10-00014

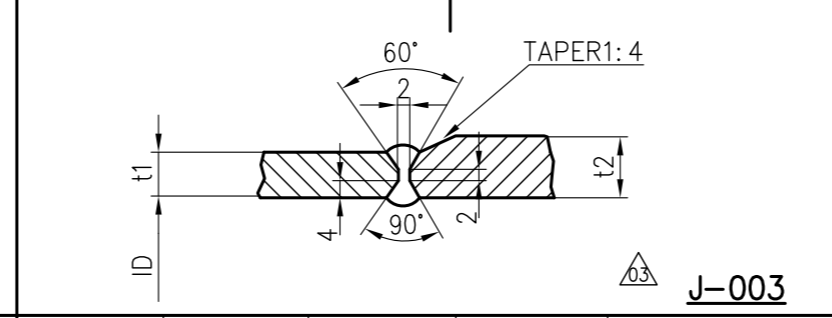
OF HS



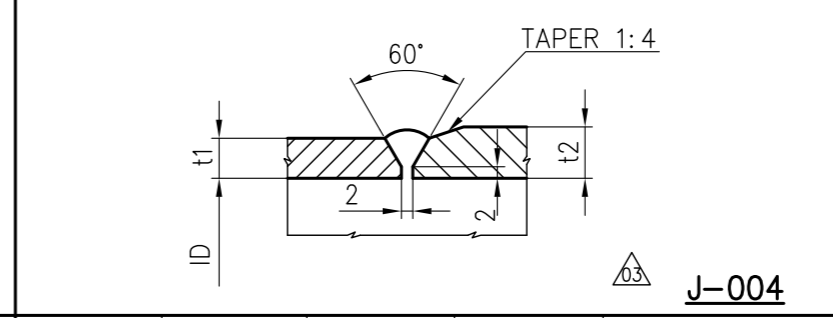
J-001



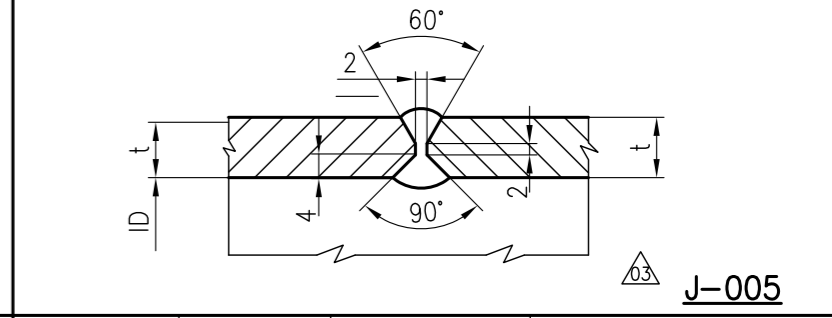
J-002



J-003



J-004



J-005

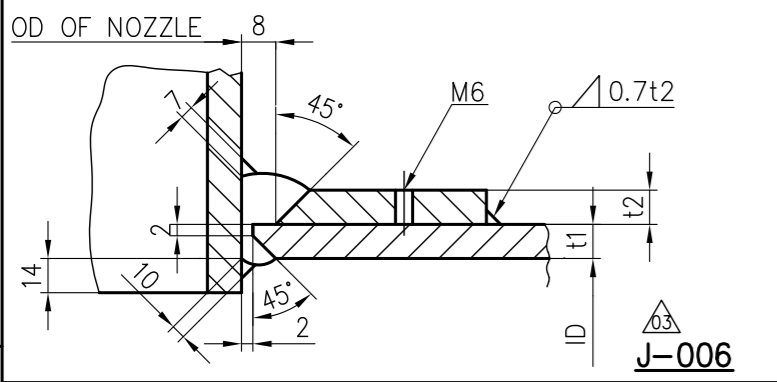
VAR.	t	MATERIAL	WPS NO.
J-001/A	5 TO 38	P1-P1**	WE 001/ WE 212
J-001/B	5 TO 20	P1-P8**	WE 118
J-001/C	5 TO 20	P8-P8**	WE 144
J-001/D	5 TO 20	P1-P8	WE 046
J-001/E	5 TO 20	P8-P8	WE 042
J-001/F	5 TO 38	P1-P1*	WE 006/ WE 227
J-001/G	1.6 TO 9.6	P8-P8	WE 314

VAR.	t	MATERIAL	WPS NO.
J-002/A	UPTO 38	P1-P1**	WE 001/ WE 212
J-002/B	UPTO 20	P1-P8**	WE 118
J-002/C	UPTO 20	P8-P8**	WE 144
J-002/D	UPTO 20	P1-P8	WE 046
J-002/E	UPTO 20	P8-P8	WE 042
J-002/F	UPTO 38	P1-P1*	WE 006/ WE 227

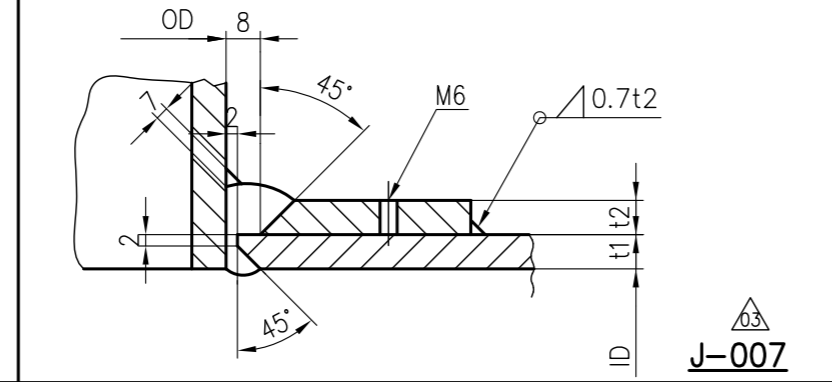
VAR.	t1	t2	MATERIAL	WPS NO.
J-003/A	10 TO 38	10 TO 40	P1-P1**	WE 001/ WE 212
J-003/B	10 TO 24	10 TO 24	P1-P8**	WE 118
J-003/C	10 TO 24	10 TO 24	P8-P8**	WE 144
J-003/D	10 TO 24	10 TO 24	P1-P8	WE 046
J-003/E	10 TO 24	10 TO 24	P8-P8	WE 042
J-003/F	10 TO 38	10 TO 38	P1-P1*	WE 006/ WE 227

VAR.	t1	t2	MATERIAL	WPS NO.
J-004/A	8 TO 38	8 TO 38	P1-P1**	WE 001/ WE 212
J-004/B	8 TO 24	8 TO 24	P1-P8**	WE 118
J-004/C	8 TO 24	8 TO 24	P8-P8**	WE 144
J-004/D	8 TO 24	8 TO 24	P1-P8	WE 046
J-004/E	8 TO 24	8 TO 24	P8-P8	WE 042
J-004/F	8 TO 38	8 TO 38	P1-P1*	WE 006/ WE 227

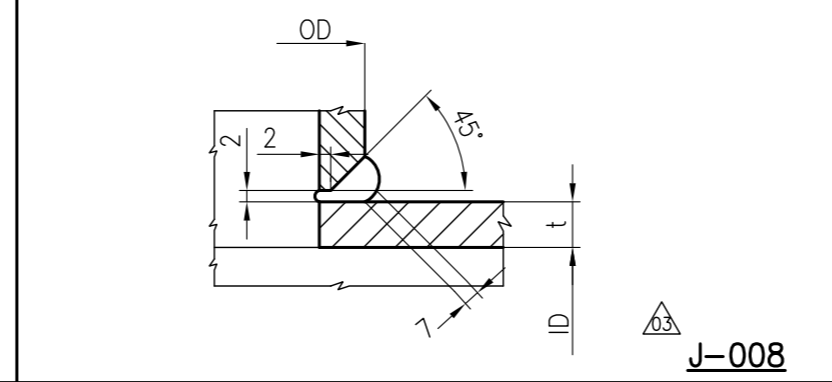
VAR.	t	MATERIAL	WPS NO.
J-005/A	10 TO 38	P1-P1**	WE 001/ WE 212
J-005/B	10 TO 24	P1-P8**	WE 118
J-005/C	10 TO 24	P8-P8**	WE 144
J-005/D	10 TO 24	P1-P8	WE 046
J-005/E	10 TO 24	P8-P8	WE 042
J-005/F	10 TO 38	P1-P1*	WE 006/ WE 227



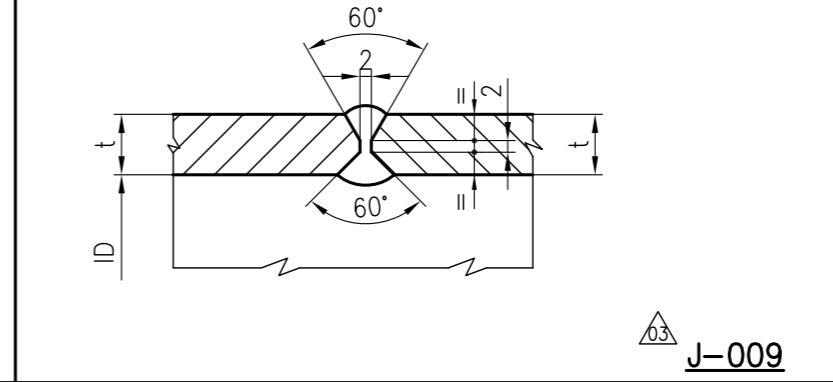
J-006



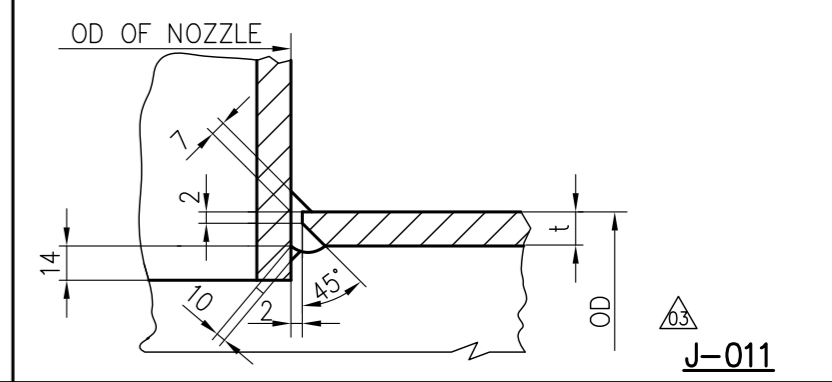
J-007



J-008



J-009



J-011

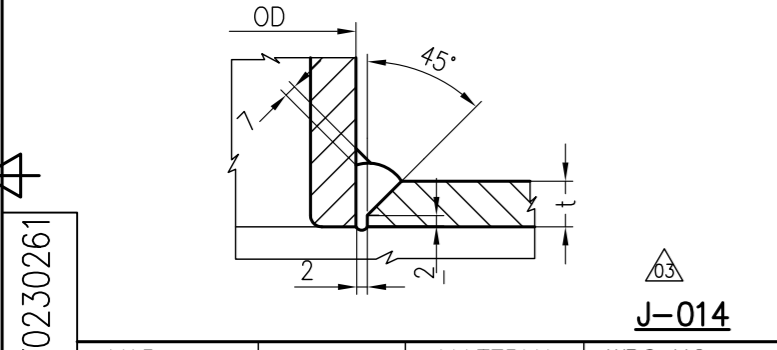
VAR.	t1	t2	MATERIAL	WPS NO.
J-006/A	5 TO 38	5 TO 38	P1-P1**	WE 001
J-006/B	5 TO 24	5 TO 24	P1-P8**	WE 118
J-006/C	5 TO 24	5 TO 24	P8-P8**	WE 144
J-006/D	5 TO 24	5 TO 24	P1-P8	WE 046
J-006/E	5 TO 24	5 TO 24	P8-P8	WE 042
J-006/F	5 TO 38	5 TO 38	P1-P1*	WE 006/ WE 507

VAR.	t1	t2	MATERIAL	WPS NO.
J-007/A	5 TO 38	5 TO 38	P1-P1**	WE 001
J-007/B	5 TO 24	5 TO 24	P1-P8**	WE 118
J-007/C	5 TO 24	5 TO 24	P8-P8**	WE 144
J-007/D	5 TO 24	5 TO 24	P1-P8	WE 046
J-007/E	5 TO 24	5 TO 24	P8-P8	WE 042
J-007/F	5 TO 38	5 TO 38	P1-P1*	WE 006/ WE 507

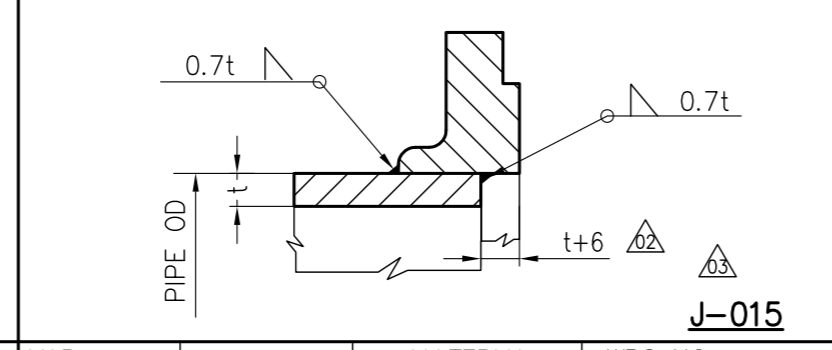
VAR.	t	MATERIAL	WPS NO.
J-008/A	5 TO 38	P1-P1**	WE 001
J-008/B	5 TO 24	P1-P8**	WE 118
J-008/C	5 TO 24	P8-P8**	WE 144
J-008/D	5 TO 24	P1-P8	WE 046
J-008/E	5 TO 24	P8-P8	WE 042
J-008/F	5 TO 38	P1-P1*	WE 006

VAR.	t	MATERIAL	WPS NO.
J-009/A	10 TO 38	P1-P1**	WE 001/ WE 212
J-009/B	10 TO 24	P1-P8**	WE 118
J-009/C	10 TO 24	P8-P8**	WE 144
J-009/D	10 TO 24	P1-P8	WE 046
J-009/E	10 TO 24	P8-P8	WE 042
J-009/F	10 TO 38	P1-P1*	WE 006

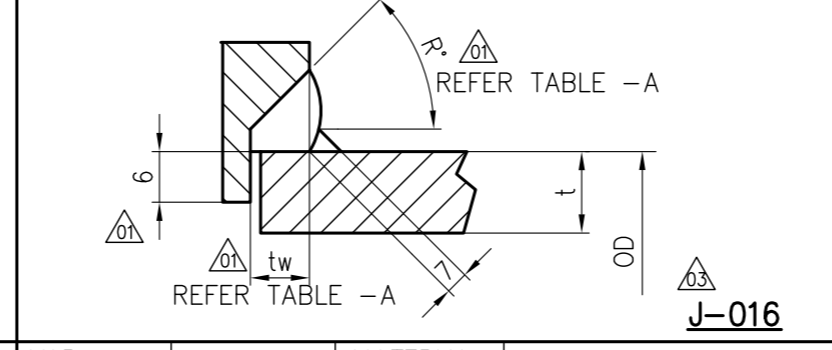
VAR.	t	MATERIAL	WPS NO.
J-011/A	5 TO 38	P1-P1**	WE 001
J-011/B	5 TO 24	P1-P8**	WE 118
J-011/C	5 TO 24	P8-P8**	WE 144
J-011/D	5 TO 24	P1-P8	WE 046
J-011/E	5 TO 24	P8-P8	WE 042
J-011/F	5 TO 38	P1-P1*	WE 006



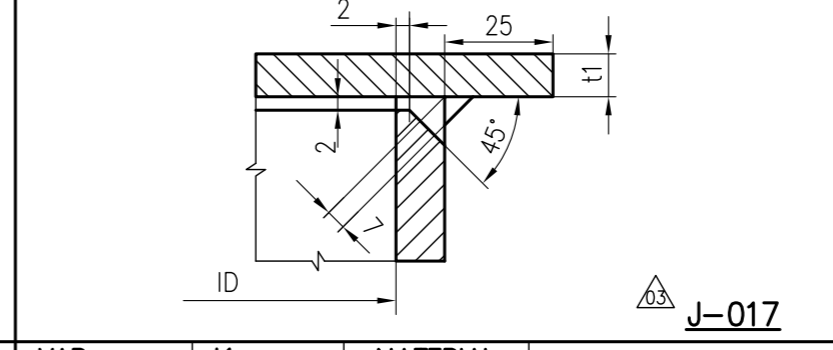
J-014



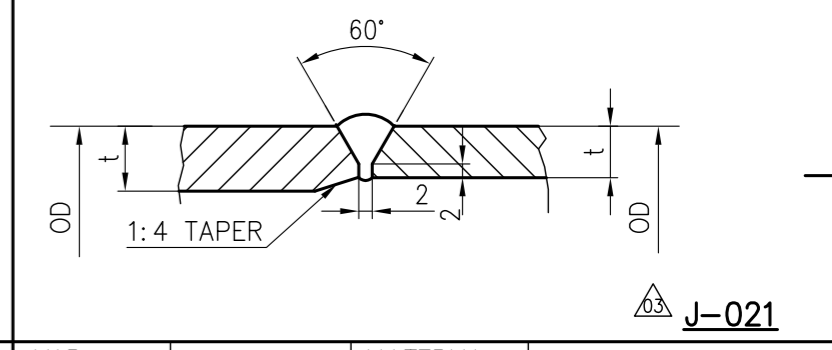
J-015



J-016



J-017



J-021

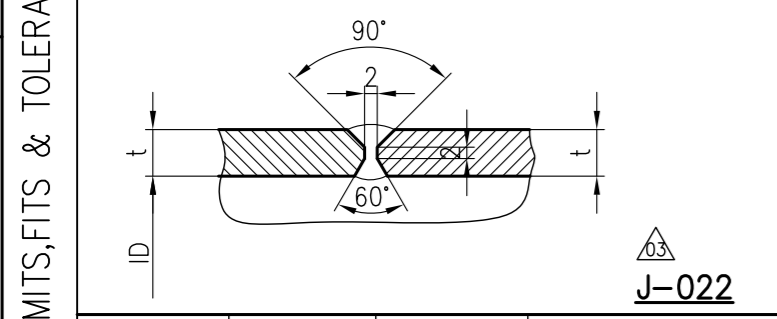
VAR.	t1	MATERIAL	WPS NO.
J-014/A	5 TO 38	P1-P1**	WE 001
J-014/B	5 TO 24	P1-P8**	WE 118
J-014/C	5 TO 24	P8-P8**	WE 144
J-014/D	5 TO 24	P1-P8	WE 046
J-014/E	5 TO 24	P8-P8	WE 042
J-014/F	5 TO 38	P1-P1*	WE 006

VAR.	t	MATERIAL	WPS NO.
J-015/A	5 TO 28	P1-P1**	WE 001
J-015/B	5 TO 28	P1-P8**	WE 118
J-015/C	5 TO 24	P8-P8**	WE 144
J-015/D	5 TO 28	P1-P8	WE 046
J-015/E	5 TO 24	P8-P8	WE 042
J-015/F	5 TO 28	P1-P1*	WE 006/ WE 507

VAR.	t	MATERIAL	WPS NO.
J-016/A	5 TO 38	P1-P1**	WE 001
J-016/B	5 TO 38	P1-P8**	WE 118
J-016/C	5 TO 24	P8-P8**	WE 144
J-016/D	5 TO 24	P1-P8	WE 046
J-016/E	5 TO 24	P8-P8	WE 042
J-016/F	5 TO 38	P1-P1*	WE 006

VAR.	t1	MATERIAL	WPS NO.
J-017/A	5 TO 120	P1-P1**	WE 001
J-017/B	5 TO 50	P1-P8**	WE 118
J-017/C	5 TO 50	P8-P8**	WE 144
J-017/D	5 TO 24	P1-P8	WE 046
J-017/E	5 TO 20	P8-P8	WE 042
J-017/F	5 TO 50	P1-P1*	WE 006

VAR.	t	MATERIAL	WPS NO.
J-021/A	5 TO 28	P1-P1**	WE 001/ WE 212
J-021/B	5 TO 24	P1-P8**	WE 118
J-021/C	5 TO 24	P8-P8**	WE 144
J-021/D	5 TO 24	P1-P8	WE 046
J-021/E	5 TO 24	P8-P8	WE 042
J-021/F	5 TO 28	P1-P1*	WE 006



J-022

TABLE-A

VAR.	COUPLING SIZE	R'	tw (mm)
01	1/2"	45	5
02	3/4"	45	6
03	1"	45	6.5
04	1 1/4"	45	7.5
05	1 1/2"	30	15
06	2"	30	20.5

- NOTES:-**
- TOLERANCE FOR ROOT FACE AND ROOT GAP ±0.1
 - ALL DIMENSIONS ARE IN mm
 - P1 - CARBON STEEL
 - P4 - ALLOY STEEL
 - P8 - STAINLESS STEEL
 - * - WITH PRE-HEAT
 - - WITH STRESS RELIEVING
 - FOR TACK WELDING : WPS NO MATERIAL
WE 006 P1-P1*
WE 046 P1-P8
WE 042 P8-P8
WE 118 P1-P8 •
WE 144 P8-P8 •
 - FOR REPAIR WELDING : WE 006 P1-P1
WE 001 P1-P1**
 - ∆ INDICATES THROAT

VAR.	t	MATERIAL	WPS NO.
J-022/A	10 TO 38	P1-P1**	WE 001/ WE 212
J-022/B	10 TO 24	P1-P8**	WE 118
J-022/C	10 TO 24	P8-P8**	WE 144
J-022/D	10 TO 24	P1-P8	WE 046
J-022/E	10 TO 24	P8-P8	WE 042
J-022/F	10 TO 38	P1-P1*	WE 006/ WE 227

REV.	DATE	ALTERED	CHECKED	APPD
03	13.04.15	Uma	h	h
02	14.10.04	h	h	JSN/h
01	29.11.02	h	h	JSN/h

REV.	DATE	ALTERED	CHECKED	APPD
03	13.04.15	Uma	h	h
02	14.10.04	h	h	JSN/h
01	29.11.02	h	h	JSN/h

REV.	DATE	ALTERED	CHECKED	APPD
03	13.04.15	Uma	h	h
02	14.10.04	h	h	JSN/h
01	29.11.02	h	h	JSN/h

REV.	DATE	ALTERED	CHECKED	APPD
03	13.04.15	Uma	h	h
02	14.10.04	h	h	JSN/h
01	29.11.02	h	h	JSN/h

WELDING ENGG APPROVAL :		
NAME	SIGNATURE	DATE
P. MALLESH		20.04.15

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

DRN.	NAME	SIGN.	DATE	NO. OF VAR.
AL RAJAM	UMESH MENON		12.04.02	NA
TSN BHARGAV	JSN/h		12.04.02	NA

DEPT.	GRADE OF TOL. DIM. C/M/F	SCALE	WEIGHT (KG)	REF. TO ASSY DRG.	ITEM NO.	NO. OF ITEMS
HEE	NA	NA	NA	NA	NA	NA

TITLE	CARD CODE	DRAWING NO.	REV.
WELD DETAILS & WPS NOS. FOR DEAERATOR	NA	2-163-10-00014	03

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