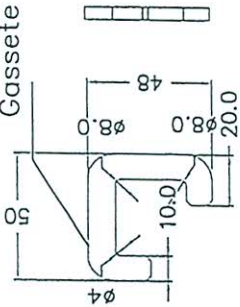
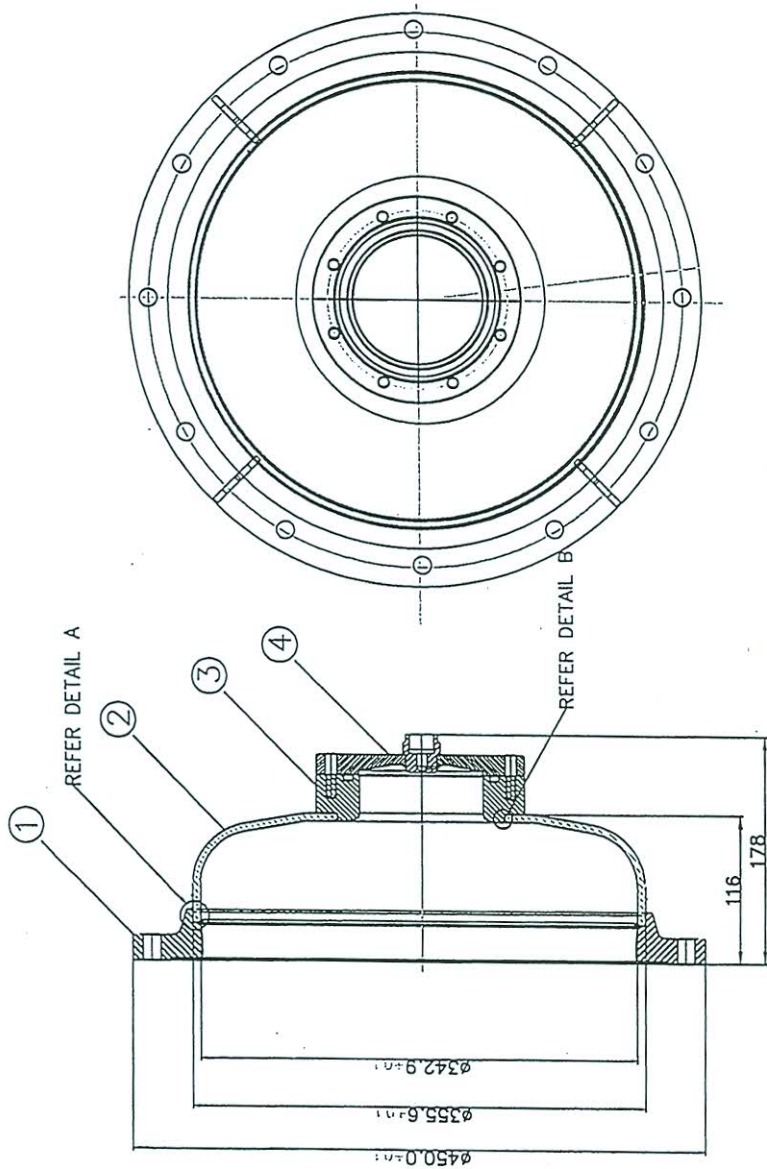


RD DG 4 35 0517 2040

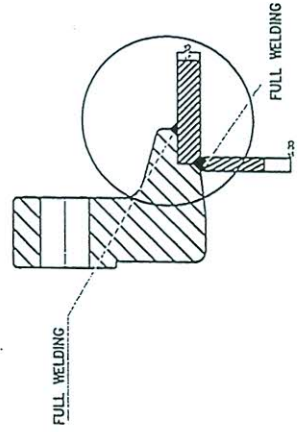
FIRST ANGLE PROJECTION

(ALL DIMENSIONS ARE IN mm)

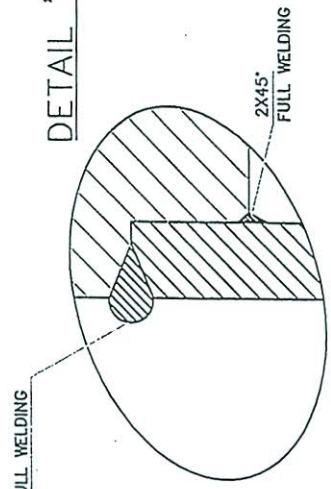
Gasete plate 4 No.s



DETAIL 'A'



DETAIL 'B'



VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	IT. NO.	MATL. CODE	UNIT WT.	QTY.
04		GAS VALVE COVER	RD DG 4 35 1133 4161		SS-304L		01
03		FLANGE-III	RD DG 4 35 1133 4320		SS-304L		01
02		DISH-II	RD DG 4 35 0517 2040		SS-304L		01
01		FLANGE - II	RD DG 4 35 0517 2012		SS-304L		01

MODIFIED ON 17/02/15

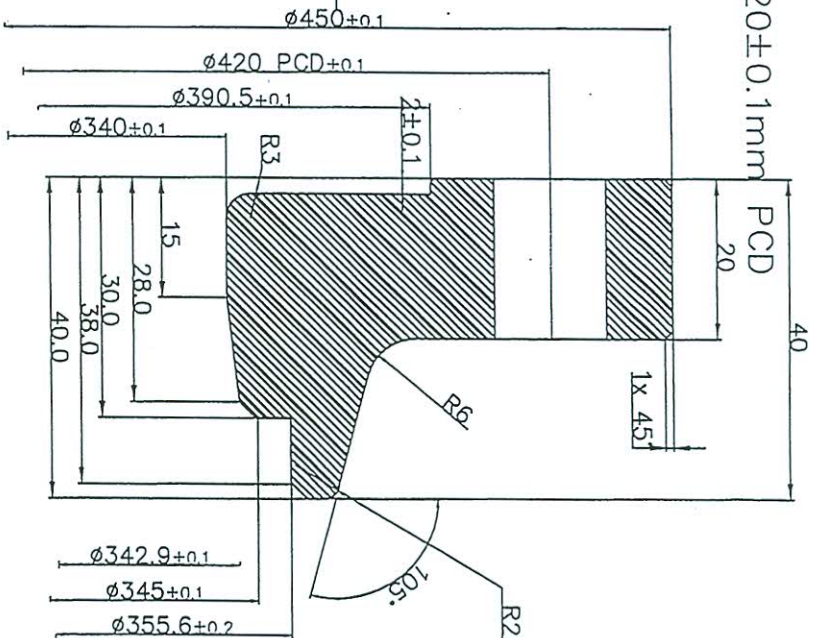
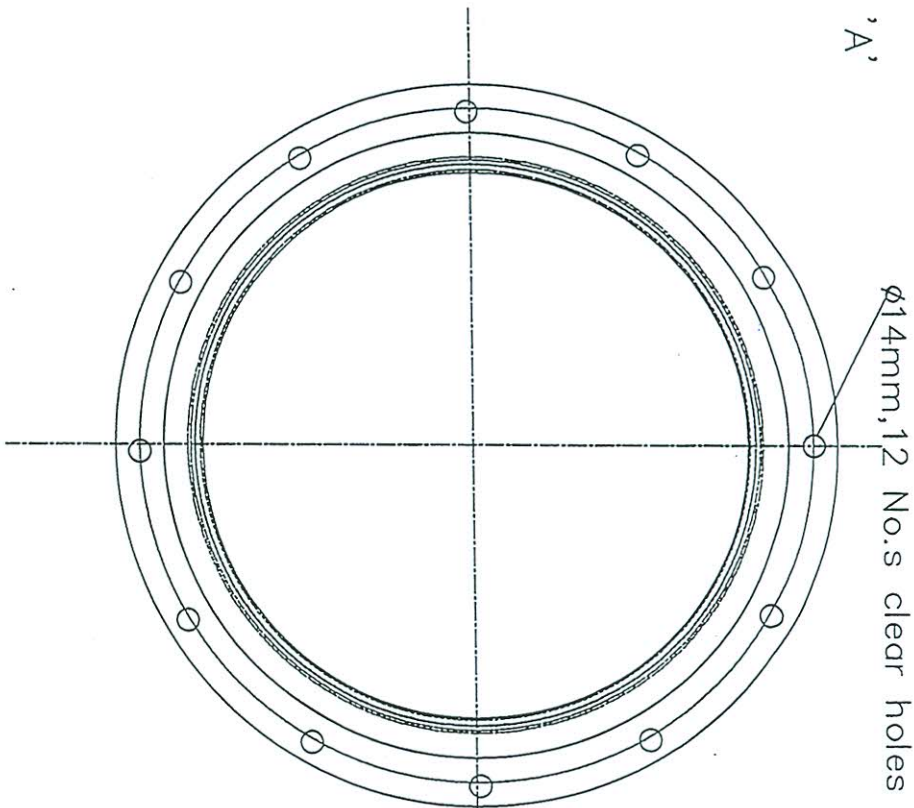
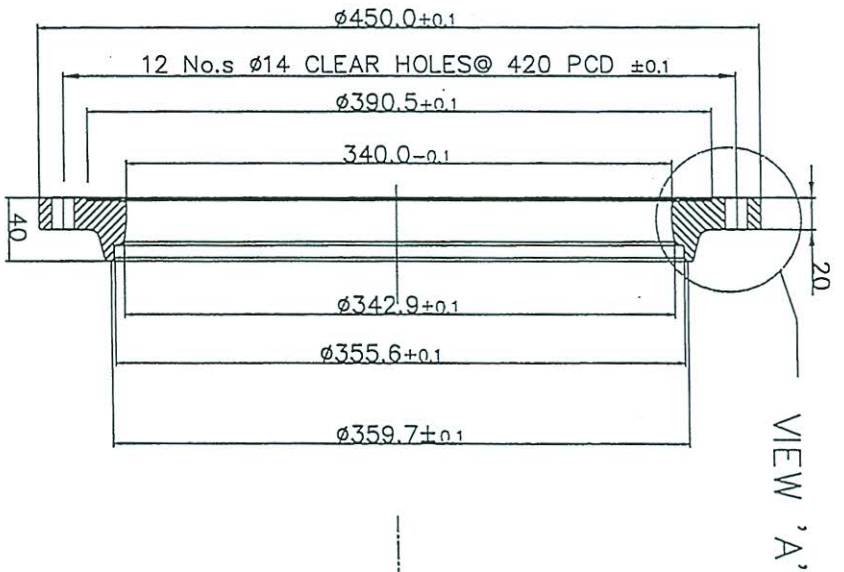
NOTE:

1. DISH AND FLANGES TO BE TIG / MIG WELDING WITH SUITABLE SS ELECTRODE.
2. THE ROOT SHOULD BE HOMOGENEOUS AND CONTINUOUS.
3. PRESSURE TEST AS PER SPECIFICATIONS.
4. TESTED ASSEMBLIES TO BE DEGREASED, SAND BLASTED AND POWDER COATED ON OUTSIDE.
5. ELECTRO POLISH INSIDE SURFACE.
6. LIFTING LUGS SHALL BE FULLY WELDED TO FLANGE AND DISH.

GSM-245

TYPE OF PRODUCT: DISH END-I
 NAME OF CUSTOMER: BHARAT HEAVY ELECTRICALS LTD. HYDERABAD
 DPT. CODE: 67A/7
 SCALE: 1:1
 WEIGHT(KG):
 REF. TO: RD DG 4 35 1133 2030 1
 DRAWING NO. RD DG 4 35 0517 2040
 SHEET NO. NO. OF SHEETS

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ENLARGED VIEW 'A'

- Note:
1. Sealing area shall be polished to RA 0.8 or better.
 2. ϕ 14.0 holes shall be chamfered uniformly (0.8x45°).
 3. PCD and flange centre shall be concentric within ± 0.05 .
 4. Finished flange shall be degreased and packed in 125 micron poly bag and sealed.
 5. Component shall be Machined to dimensions after welding to spherical pipe
 6. All sharp edges should be machined at 0.4 x 45°.

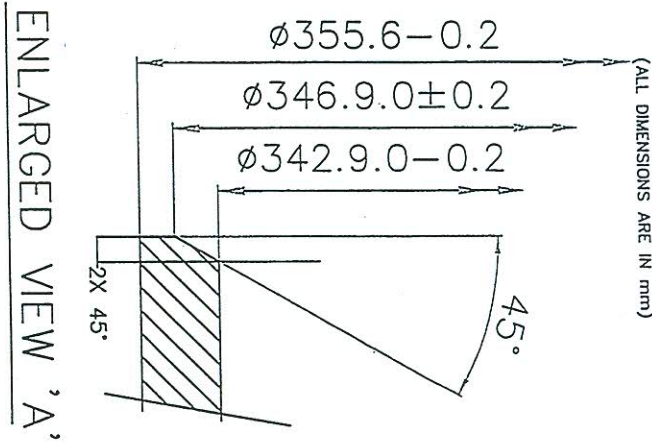
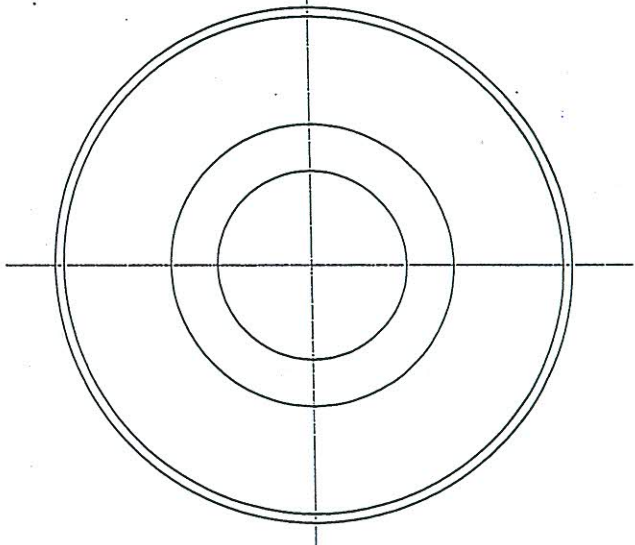
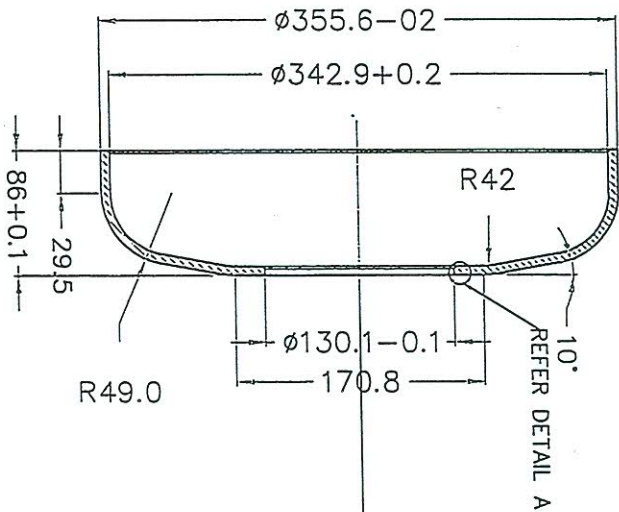
VAR. NO.	ITEM NO.	DESCRIPTION	QTY.
01		BLOCK	2

TYPE OF PRODUCT: GSM-245
NAME OF CUSTOMER: BHARAT HEAVY ELECTRICALS LTD. HYDERABAD

DEPT. CODE	GRADE OF TOL. DIM. C/M/F	SCALE	WEIGHT(KG)	DRW. NO.	DATE
		NTS		NSK	06.06.13
				NSK	06.06.13
				MIRYAO	06.06.13

TITLE	CARD CODE	DRAWING NO.	REV.
FLANGE-II	RD DG 4 35 0517 2012 00		

REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED			CHECKED



ALL SHARP EDGES SHALL BE MACHINED TO 0.4x45°
DISH SHALL BE PREPARED WITH SUITABLE DIE.

VAR. NO.	REMARKS	VAR. ITEM NO.	DESCRIPTION	STD.	DRAWING NO.	VAR.	MATL. SPECN.	UNIT	QTY.	ZONE
01			SHEET				SS-304L		01	

TYPE OF PRODUCT: GSM-245
NAME OF CUSTOMER: BHARAT HEAVY ELECTRICALS LTD. HYDERABAD

DRN. NO.	NSK	DATE	14.10.13
CHKD.	BSM	VAR.	01
APPD.	MMRAO	BY	HS

DEPT. CODE: DISH-1
SCALE: 1:1
WEIGHT(KG):

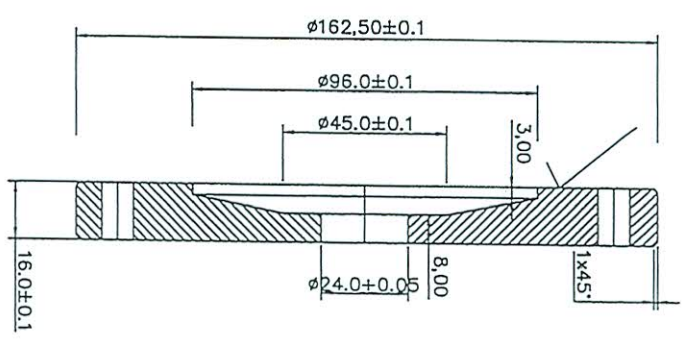
RD DG 4 35 0517 2040
RD DG 4 35 0517 2041

REV.	DATE	ALTERED	REV.	DATE	ALTERED
		CHECKED			CHECKED
ZONE			ZONE		

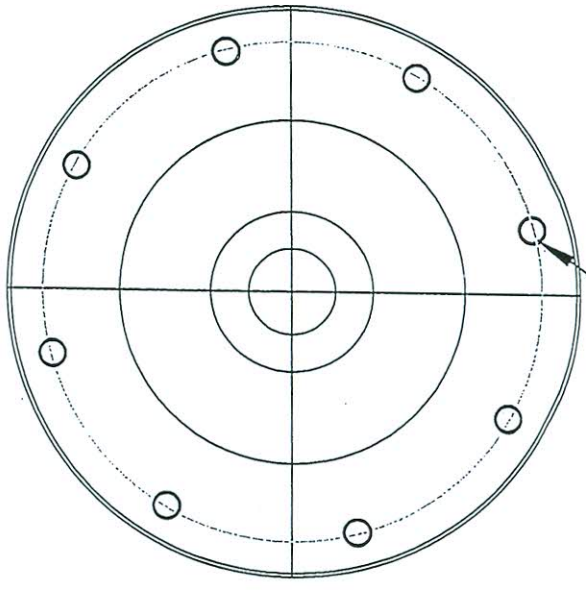
INVENTORY NO.	SIGN. AND DATE	REF. DRG. NO.
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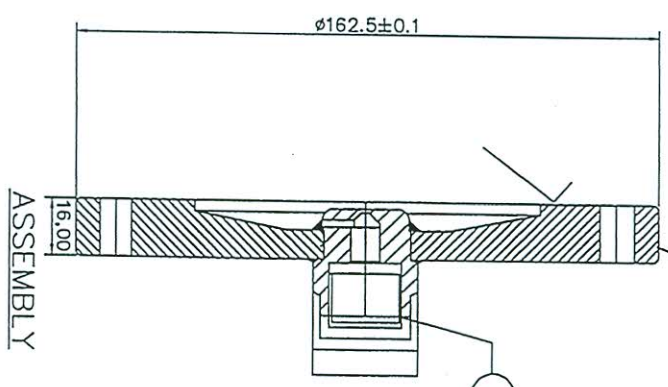
INVENTORY NO. SN. AND DATE REF. DRG. NO.



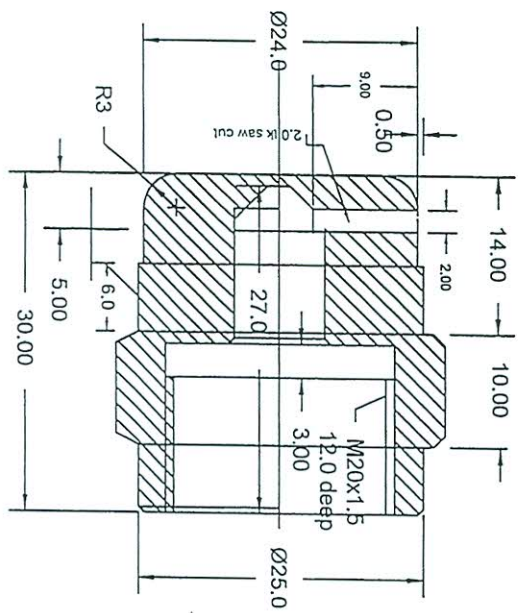
FLANGE-IV



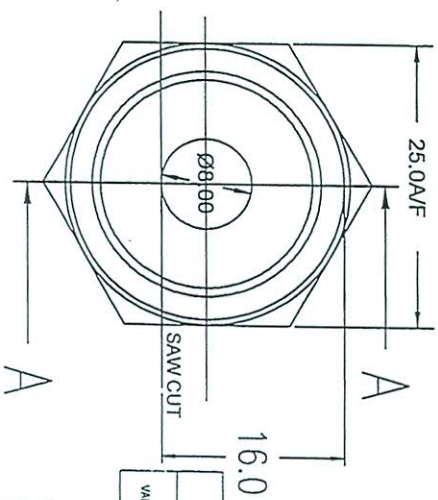
8 NO., 9.2 CLEAR HOLES
@140±0.07 PCD WITH 0.4X45° C/F



ASSEMBLY



SECTION AA



GAS STUD (2)

ALL SHARP EDGES SHALL BE MACHINED TO 0.4X45°.
MARKED SURFACE SHALL BE FINISHED TO RA0.8

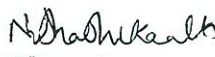
FINAL ON 12/05/11


VAR NO	REMARKS	VAR NO	ITEM NO.	DESCRIPTION	QTY	DRAWING NO.	IT/NO	MATL CODE	MATL SPECN	UNIT	QTY	ZONE
02				GAS STUD	01			SS-304L				
01				FLANGE - IV	01			SS-304L				

CGSM-145

TYPE OF PRODUCT	BHARAT HEAVY ELECTRICALS LTD.	
NAME OF CUSTOMER	HYDERABAD	
DEPT.	GRADE OF	SCALE
CODE	C/N/P	NTS
TITLE	WEIGHT(KG)	2.5
GAS VALVE COVER		
CARD CODE	DRAWING NO.	NO. OF SHEETS
	RD DG 4 35 1133 4161	1

REV.	DATE	ALTERED	CHECKED	ZONE

PSGSG/13 -14/18	Product Specifications For Reducer assembly	Drg. No.	RD DG 4 35 0517 2040
		Date	17.02.15
		Product	GSM245
<p>1.0</p> <p>2.0</p> <p>3.0</p> <p>3.1</p> <p>3.2</p> <p>3.3</p> <p>3.4</p>	<p>Application : The Dish end assembly to Drawing. No. RD DG 4 35 0517 2040 is used for gas filled applications. The gas pressure in this Dish end is to be maintained at 0.5 MPa. The Dish end shall meet following Specifications.</p> <p>Drawings :</p> <p>Main Assembly Drawing DISH END : RD DG 4 35 0517 2040 Component / part drawings:</p> <p style="padding-left: 40px;">RD DG 4 35-0517-2041 RD DG 43 5-0517-2012 RD DG 4 35-1133-4160 RD DG 4 35-1133-4161</p> <p>SPECIFICATIONS:</p> <p>Material: Low Carbon Austenitic stainless steel confirming to AISI-304.</p> <p>Standard seamless or ERW (straight/ spiral) tubular sections shall be used for construction, where ever applicable in design. Fabricated / drawn sections can be used for other areas not confirming to standard pipe schedules.</p> <p>Drawn profiles, to size, only shall be used for direct welding with the flanges. No smithy is allowed for formation/ matching of profiles in view of defect inception. Pipe and flanges shall be TIG / MIG welded with suitable SS electrode</p> <p>The welded sections shall be sized as per drawing and verified /tested using Dye Penetration (D.P.) technique or x-ray at all stages of welding. Inside edges/weld shall be fused to obtain near smooth weld surface</p>		
1/4	PSGSG/13-14/18.doc		 Signature

PSGSG/13 -14/18	Product Specifications For Reducer assembly	Drg. No.	RD DG 4 35 0517 2040
		Date	17.02.15
		Product	GSM245
<p>3.5</p> <p>3.6</p> <p>3.7</p> <p>3.8</p> <p>3.9</p> <p>3.10</p> <p>3.11</p>	<p>The flanges shall be manufactured to drawings and welded as per instructions to the shells maintaining parallelism of faces and perpendicularity as prescribed. Machining shall be done after welding only. Job will not be accepted in case there is any parallelity/perpendicularity error of PCDs of flanges.</p> <p>The flange sealing surfaces shall be polished to RA 0.8 or better and the bolting holes shall be machined fine, using jig borer/ CNC milling, and shall have uniform chamfer. The tolerances, wherever not mentioned in the drawing, shall be within 0.1°. Any sharp corners shall be removed as per the drawing. Wherever not specified in the drawing, a chamfer of 0.5x45° shall be provided at the sharp corners and edges.</p> <p>Weld splatter, if any, shall be removed by chipping or grinding on completion of the weld.</p> <p>Dye penetration report shall be generated and submitted to BHEL</p> <p>The tested assembly should be cleaned, degreased and prepared for pressure test. The assembly shall be tested at 8.5 bar pressure for 4 hours and pressure drop shall be recorded and communicated to BHEL. In case of pressure drop a course leak check shall be performed. The leak shall be rectified and the test repeated to satisfaction. Components indicating drop in pressure during this test will not be accepted. The arrangement shall be kept at 13 bar for 15 minutes prior to this test to verify pressure withstanding capabilities specified in drawing.</p> <p>The assemblies further shall be powder coated (> 50 Micron) on the outer surfaces to Siemen's grey shade as specified on drawing .During this operation all flanges shall be masked at the sealing surfaces and at the rim.</p> <p>The dimensional checks and the leak test shall be carried out in presence of BHEL inspector. It is preferable to have first stage inspection after manufacturing of components(Before full welding).</p>		
2/4	PSGSG/13-14/18.doc		 Signature

PSGSG/13 -14/18	Product Specifications For Reducer assembly	Drg. No.	RD DG 4 35 0517 2040
Date		17.02.15	
Product		GSM245	
3.12	The accepted component shall be packed in wooden boxes with suitable covers on the flanges to prevent transit damages. A thick polyethylene cover shall be used to seal to component from ingress of moisture and water. For transit time higher than a week, adequate quantity of moisture absorbent shall also be placed with the component		
3.13	Following certificates shall be furnished for acceptance of the component: 1 Material certificate, 2 Material test certificate, 3 Stage wise DP / X-ray tests 4 Pressure withstand test report		
3.14	A certified copy of above documents shall be sent along with the delivery note.		
3.15	Components / fittings required for pressure test shall be arranged by supplier only		
3.16	Any Other information: In case of doubts please contact BHEL for clarifications. Supplier can furnish any other/additional information, considering overall requirements		
3/4	PSGSG/13-14/18.doc		<i>N. Shashikant</i> Signature