



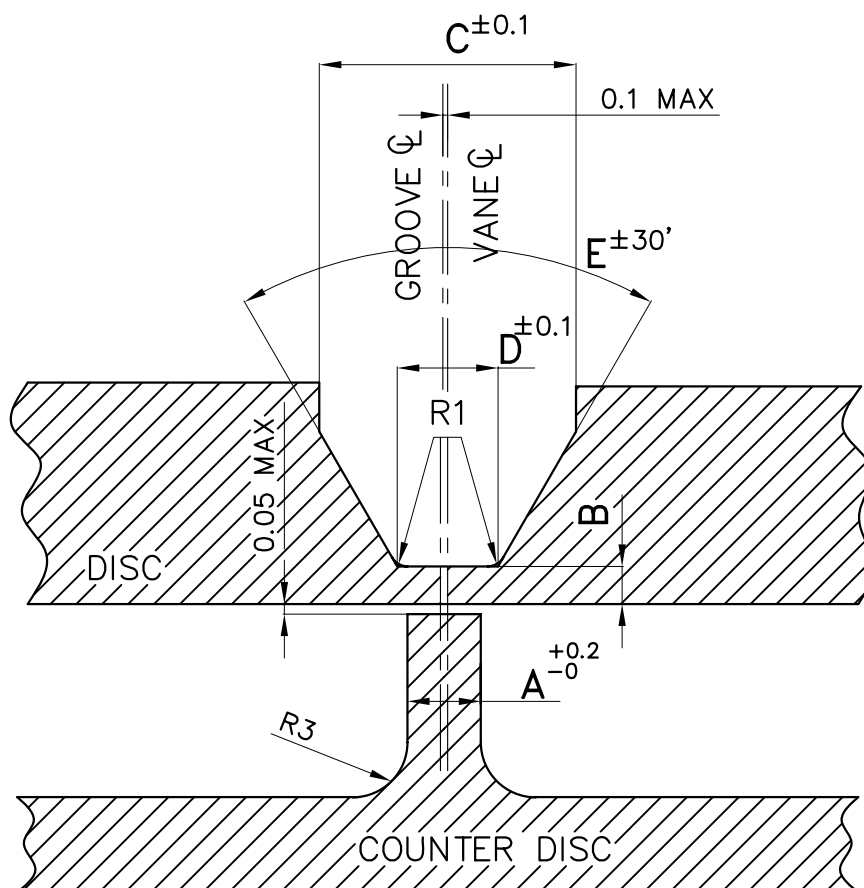
PRODUCT STANDARD
TURBINES & COMPRESSORS
HYDERABAD

TC7 2046

Rev. No. 00

PAGE 1 OF 2

WELD GROOVE DETAIL ON DISC OF EXTERNAL WELDED IMPELLERS
(FOR QUALIFICATION)



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VAR NO	VANE THICKNES A	GROOVE BOTTOM THICKNESS-B			GROOVE TOP WIDTH-C	GROOVE BOTTOM WIDTH-D	GROOVE ANGLE-E°
		MATERIAL					
		HY19377 (KMNCOGNE)	HY19391 (X12Cr13)	HY19395 (FV520B)			
01	4	1.5 ±0.05	1.5 ±0.05	1.5 ±0.05	14	5	60°
02	6	1.5 ±0.05	1.5 ±0.05	1.5 ±0.05	14	7	46°
03	2.5	1.0 ^{+0.2} / ₋₀	1 ^{+0.2} / ₋₀	1 ^{+0.2} / ₋₀	10	3.5	60°

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Refer to record of revisions

Prepared :
K GK

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PNR

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