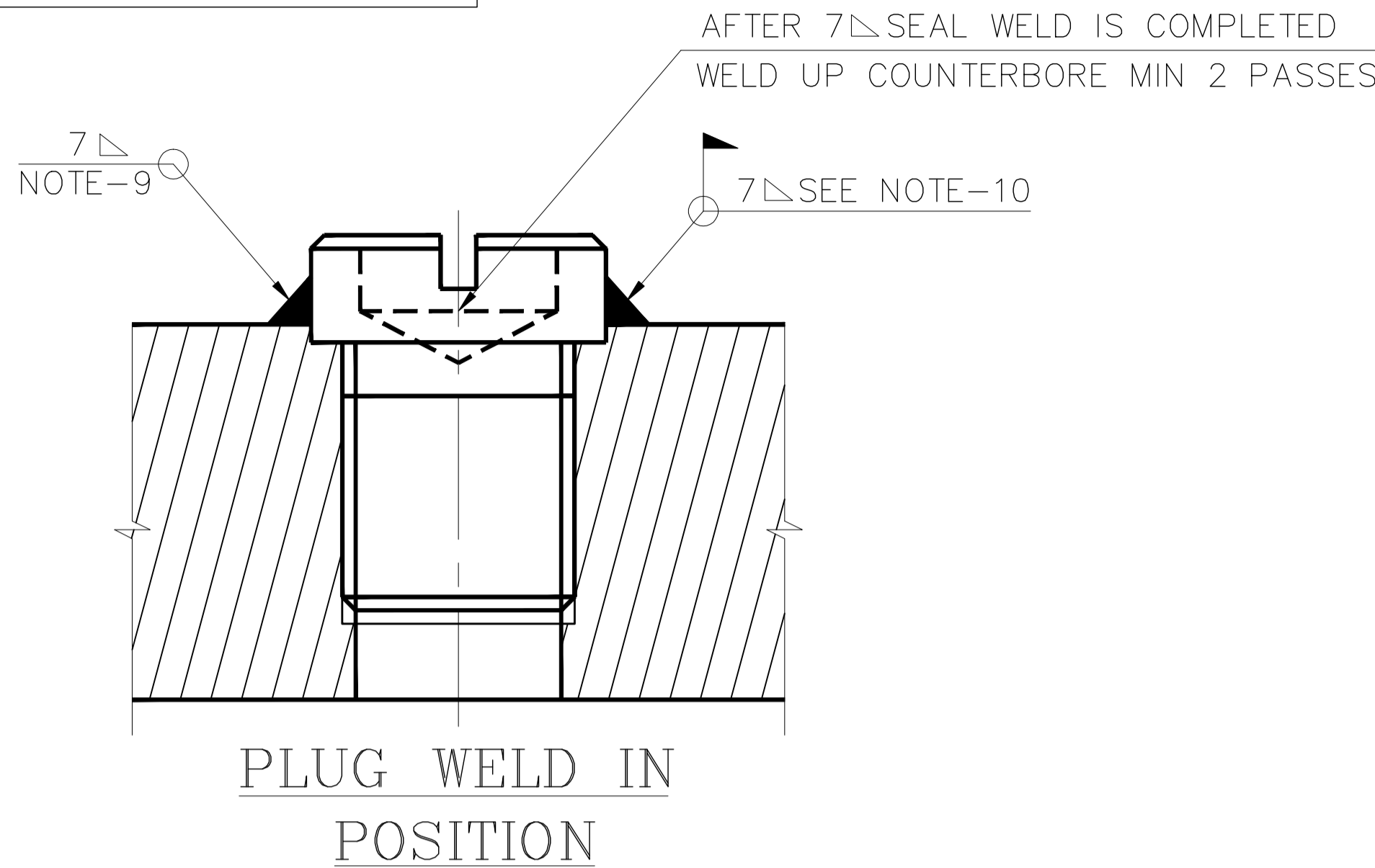


6108-0022

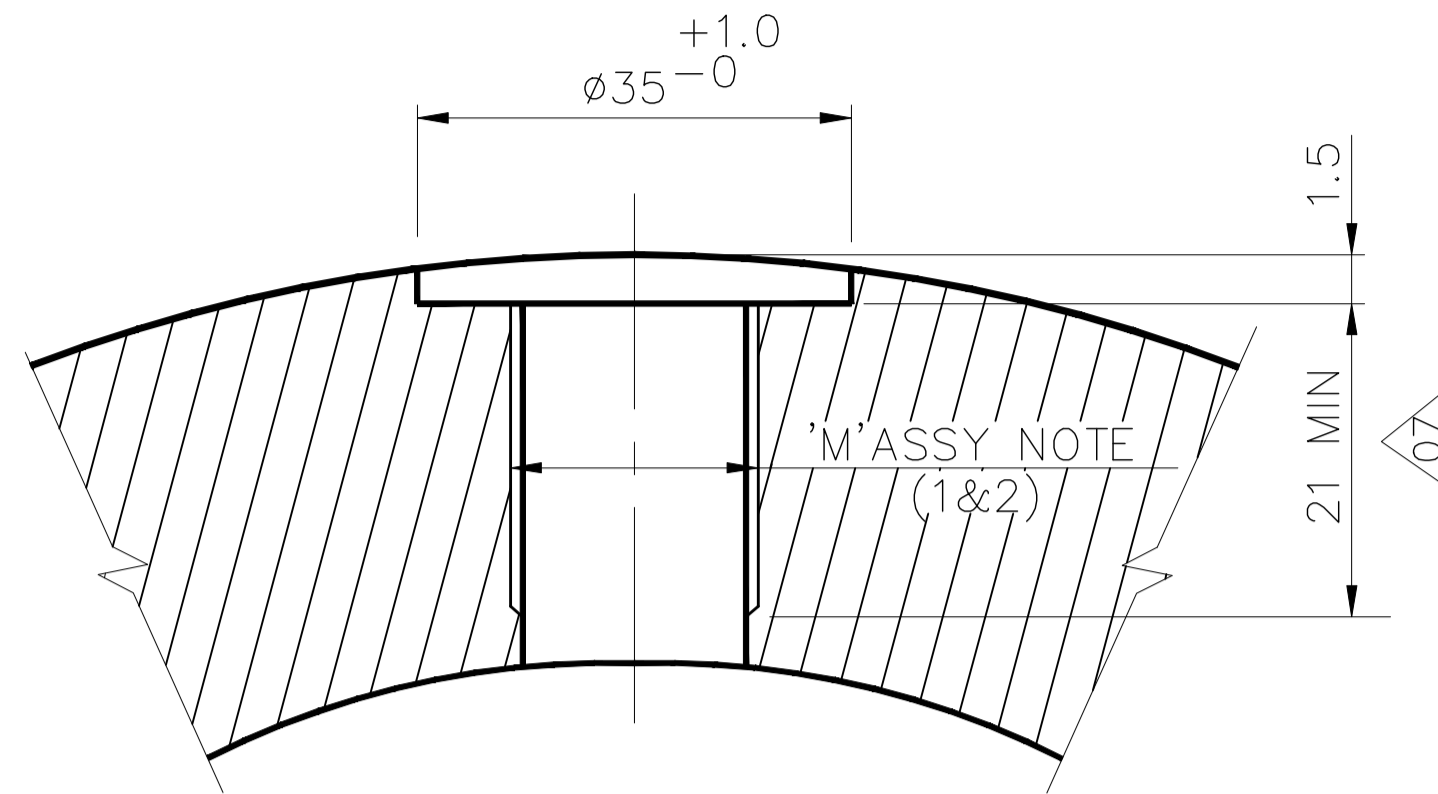
DRAWING NO.

FOR TOLERANCES OF UNTOLERANCED DIMENSIONS DURING MANUFACTURE REFER PLANT STD. NO TP 023 0299

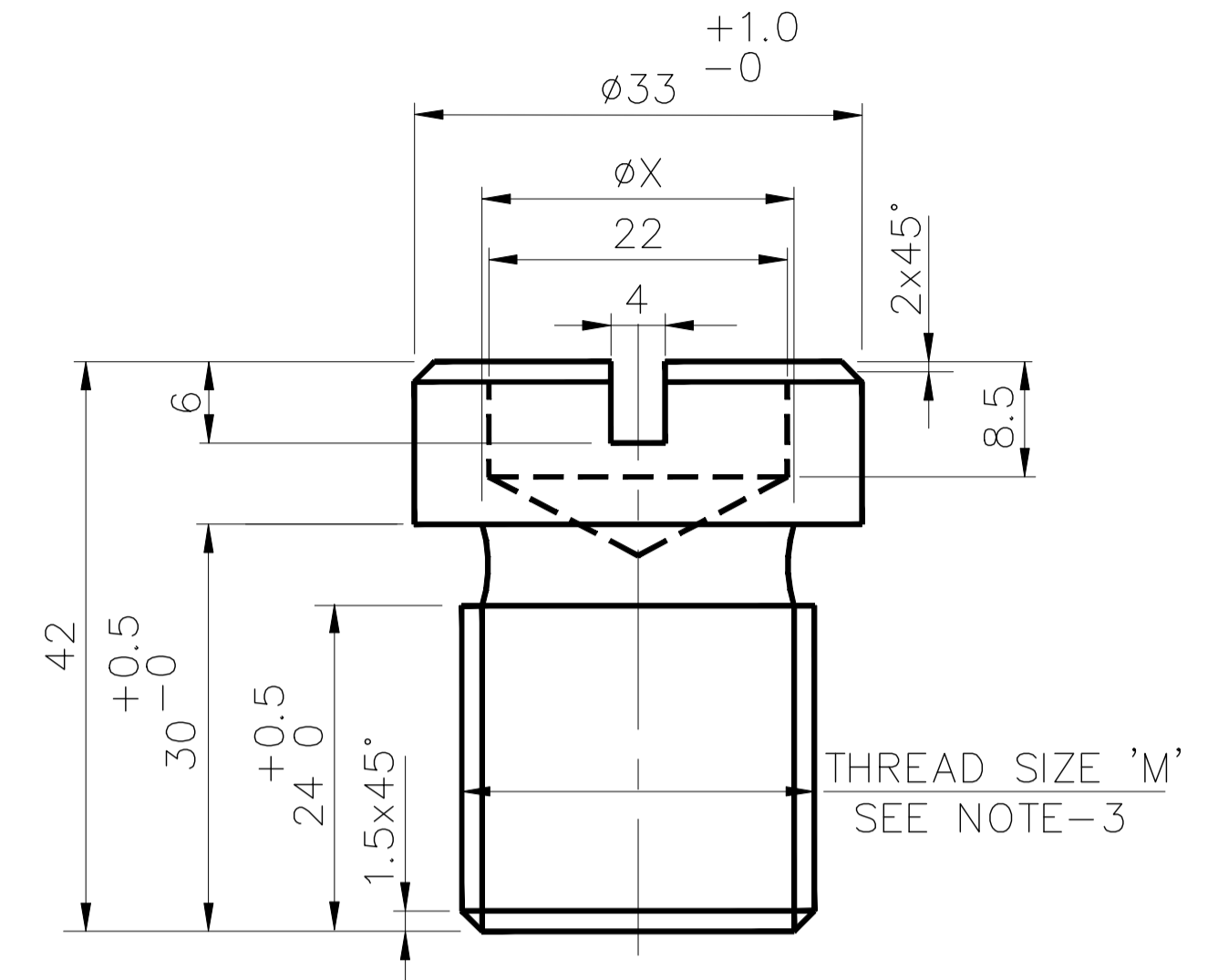
ASSEMBLY AND WELDING DETAILS



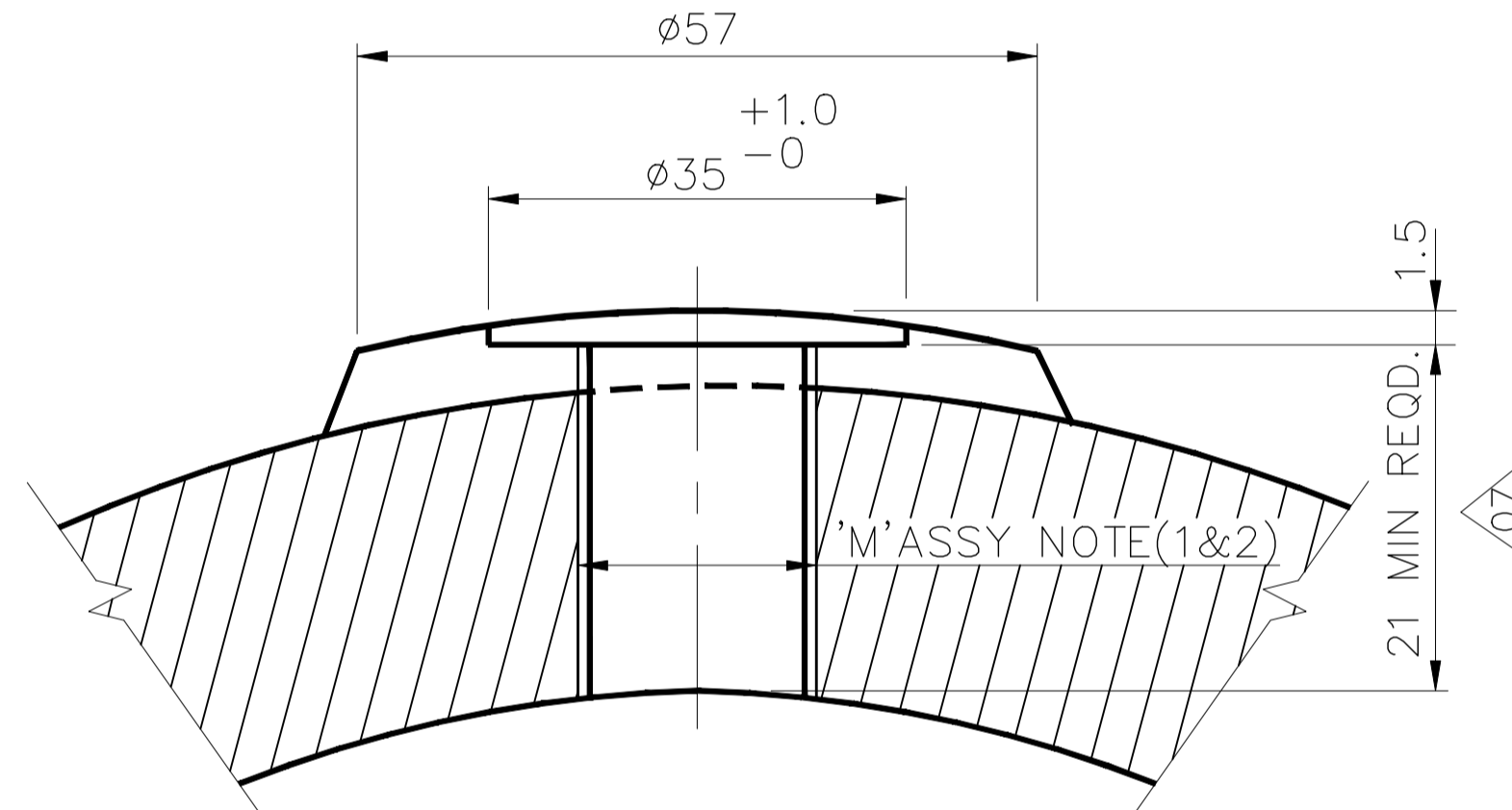
PLUG WELD IN POSITION



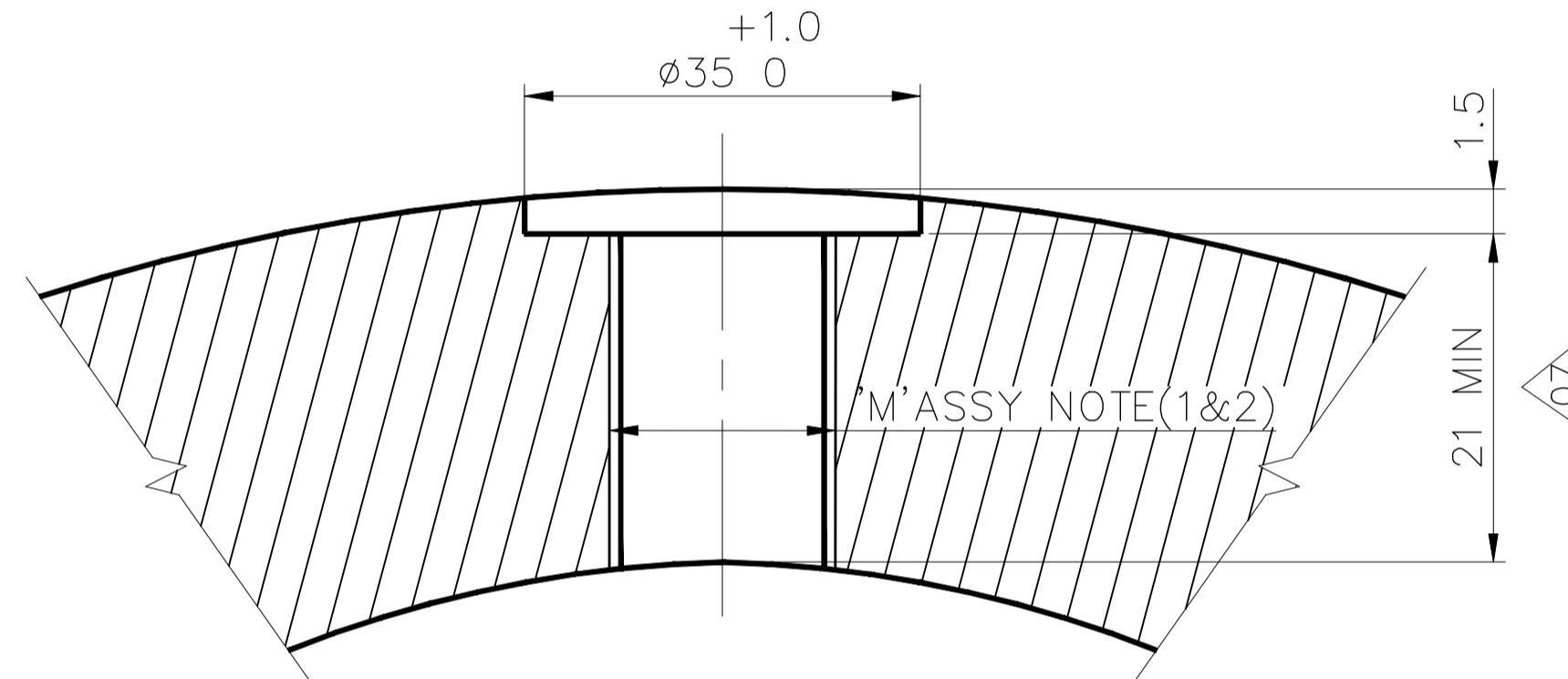
DETAIL Y
SEE NOTE 7(a)



DETAIL OF PLUG



SEE SHOP GUIDELINES
DETAIL-Z



DETAIL U
SEE NOTE 7(b)

NOTE: -

1. THREADS ON PLUG AND HEADER/PIPE SHOULD CONFORM TO COARSE SERIES OF CORPORATE STD AA 0230202 (BPS-412513)
2. TOLERANCE CLASS FOR EXTERNAL THREADS ON PLUG SHOULD BE AS PER 89 OF CORPORATE STD AA 0231816 (BPS-412515)
3. THE VARIATION IN THREAD SIZE IS TO IDENTIFY CARBON AND ALLOY STEEL PLUGS SEPERATELY.
4. MARK THE BPS CODE AND MATERAL CODE
5. CE REF. INDEX No. 12.9, 3.8, STD No. 23-63-22, DRG No. D980-0103-4
6. FOR DESIGN PRESSURE AND DESIGN TEMPERATURE REFER RELEVANT PRODUCT DRAWINGS.
7. DESIGN, MANUFACTURING AND INSPECTION AS PER IBR-1950
8. R.G. PLUG IS TO BE PROVIDED AT ANY CIRCUMFERENTIAL LOCATION AND AT ANY DISTANCE IN BETWEEN 90 MM AND 150 MM FROM PIPE CIRCUMFERENTIAL JOINT.

ASSY NOTE: -

1. TOLERANCE CLASS FOR INTERNAL THREADS ON HEADER PIPE SHOULD BE AS PER 'H' OF CORPORATE STD. AA 0231816 (BPS 412515)
2. DRILL SIZE FOR INTERNAL THREAD M27 & M24 ARE D24 & D21 RESPECTIVELY.
3. HEADER/PIPE MATERIAL SHALL GOVERN THE SELECTION OF PLUG MATERIAL
4. WELDING PREHEAT, POSTHEAT ETC. AS PER RELEVANT QUALITY CONTROL PROCEDURES
5. THE PLUG SHOULD REST ON THE SHOULDER IN HEADER/PIPE
6. ENSURE ENGAGEMENT OF MINIMUM 7 THREADS

DESIGN GUIDE LINES

- (7) (a) WHEN $t_n > 22.5$ mm, THE DETAIL-'Y' TO BE FOLLOWED.
 - (b) WHEN $t_n = 22.5$ mm, THE DETAIL-'U' TO BE FOLLOWED NO WELD BUILD UP REQUIRED.
 - (c) WHEN $t_n < 22.5$ mm, SEE SHOP GUIDE LINES.
- WHERE t_n IS THE MINIMUM WALL THICKNESS OF HEADER/PIPE
- SHOP GUIDELINES IN CONTINUATION OF DESIGN GUIDELINES-7(C)
- SHOP SHOULD MEASURE THE ACTUAL WALL THICKNESS OF THE HEADER/PIPE. IF THE ACTUAL WALL THICKNESS IS LESS THAN 22.5 mm ADDITIONAL MATERIAL SHALL BE ADDED BY SHOP AS PER DETAIL-'Z'.
8. AFTER RADIOGRAPHY, SCREW UP PLUG TIGHTLY PRIOR TO SEAL WELDING
 9. AFTER THE SHOP RADIOGRAPHIC TEST OVER, THIS SEAL WELD IS TO BE DONE WITH MINIMUM TWO PASSES.
 10. AFTER THE SITE RADIOGRAPHIC TEST OVER, THIS SEAL WELD IS TO BE DONE WITH MINIMUM TWO PASSES.

VARIANT NUMBER	ITEM NUMBER	DESCRIPTION	STD	DRAWING NUMBER	ITEM NO	MATERIAL CODE	AC/P	UNIT	UNIT WEIGHT	GS	ZONE
20	02	RG PLUG AS M24x3 (D24, T=24)		6108 0022 22		94 331 009 SA182 F22 CL3	A		0.300		
23	01	RG PLUG CS M27x3 (D27, T=24)		6108 0022 21		94 331 008 SA 105	A		0.300		
X					VAR NO	MATERIAL SPECN	DI	QUANTITY			

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT		Bharat Heavy Electricals Ltd UNIT: HIGH PRESSURE BOILER PLANT TIRUCHIRAPALLI - 620014		DRN	S.K.	SIGNATURE	DATE
DEPT		PP		CHD	G.U.		05/84
CODE		121		APPD	S.V.		05/84
WEIGHT (Kg)		REFER UNIT		REF TO ASSY / OLD DWG			
N.T.S		WT		6108-0022-02			
TITLE						DRAWING NO :	
PLUG FOR RADIOGRAPHIC TEST ACCESS HOLE						6108-0022	
						REV	
						08	

REV	DATE	ALTERED :	JERIN	REV	DATE	ALTERED :	GEETHA	REV	DATE	ALTERED :	P.S.	REV	DATE	ALTERED :		REV	DATE	ALTERED :	
08	03.06.09	CHD & APPD :	R.T.	07	19.10.06	CHD & APPD :	R.T.	06	03.02.05	CHD & APPD :	R.T.	05	03.01.04	CHD & APPD :		04	23.04.01	CHD & APPD :	
ZONE	NOTE-8 REVISED		ZONE	MIN. THREAD LENGTH REVISED FROM 29 TO 21 mm IN DETAILS U, Y & Z. ASSY. NOTE-7 REVISED TO CHANGE DIMN. FROM 30.5 TO 22.5.		ZONE	DRG. RETRACED. NOTE NoS. 6 & 7 REVISED IN LINE WITH IBR REG. 367 AMENDMENT Dt. 09.04.2002		ZONE	NOTE-8 ADDED		ZONE	NOTE No. 6 & 7 ADDED. IN BOM DIAMETER 'D', THICK 't' ADDED FOR VAR.No. 01 & 02		ZONE	RETRACED. NOTE ALTERED. MATERAL CODE ADDED. A SLOT GIVEN IN THE HEAD OF THE PLUG			

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