

BHARAT HEAVY ELECTRICALS LIMITED
CORPORATE R&D DIVISION
INTEGRATED GASIFICATION COMBINED CYCLE

GENERAL NOTES FOR FABRICATION AND SUPPLY OF FLY ASH LOCKS AND
RECEIVERS (CYCLONE-1, 2 & CANDLE FILTER).

1. THE SUPPLIER SHOULD SUBMIT THE MANUFACTURER'S TEST CERTIFICATES FOR THE SA 515 Gr 70, WHILE SUPPLYING THE MATERIAL.
2. ALL MATERIALS OF CONSTRUCTION SHALL BE STRICTLY IN ACCORDANCE WITH BHEL SPECIFICATIONS OR DRAWING.
3. ELECTRODES TO BE USED FOR WELDING CS TO CS E6102; CS TO SS E309/E309 MO; SS TO SS E304.
4. ONLY QUALIFIED WELDER HAS TO PERFORM THE JOB.
5. ALL MAIN WELD JOINTS SHALL BE FULL PENETRATION BUTT WELDS OF RADIOGRAPHIC QUALITY
6. ALL WELD JOINTS SHALL BE CHECKED FOR DYE PENETRATION TEST.
7. WELD JOINTS SHALL BE RADIOGRAPHED AS PER STANDARDS.
8. THE VESSEL SHALL BE HYDRAULICALLY TESTED AT 8.0 KG/CM SQ. (G).
9. INTERNAL AND EXTERNAL SURFACES SHALL BE CLEANED FOR REMOVAL OF RUST, SCALES, ETC. TWO COATS OF RED OXIDE SHALL BE APPLIED TO THE OUTER SURFACE OF VESSELS.
10. ALL NOZZLE BOLTS TO STRAADLE CENTRE LINE UNLESS OTHERWISE STATED.
11. ALL D.P NOZZLES SHALL HAVE ½" NPT (M) AT OUT SIDE END.
12. ALL SHARP CORNERS SHALL BE ROUNDED OFF.
13. ALL NOZZLES SHOULD BE SUPPIED WITH COMPANION FLANGES AS MENTIONED IN THE BILL OF MATERIALS.
14. RAISED FACE OF FLANGES SHALL HAVE SERRATIONS OF CONCENTRIC PITCH 0.5 AND DEPTH 0.35.
15. THIS SPECIFICATION SHEET IS COMMON FOR THE DRG NO: 4-QYN-14-686-005, 006 AND 007 REV 01.