

**TOA Valve Body Machining/Welding Scope**

Component	Material Description	Material	Process -1 Rough m/c Code	Process -1 Drawing No	Process - 2 Welding Code	Process - 2 Drawing no	Process - 3 Final Code	Process - 3 Drawing no
931121208000	BODY ROUGH-G046	A216 WCC	x	x	931121209000	2VG04616574	931121200000	2VG04615152
921502930000	BODY-WCC_GNV_2.5_1500-G042	A216 WCC	931119438000	2VG04215153	931119439000	2VG04216572	931119430000	2VG04215101

**Process - 1 Scope-**

Complete Rough Body machining in Vendor Scope, seat machining before buffer layer (excluding any Welding as mentioned in Drawing)

**Process - 2 Scope-**

Buffer layer E309 welding on seat, seat machining, Stellite-6 Welding on Seat, machining before and after stellite -6 welding, 309 Mol Stainless Steel welding in Neck of the body

**Process - 3 Scope-**

Complete final machining of Body with all threading and Lapping on seat

\* Note all Fixtures and Guages are to be procured by the vendor for machining.

**Bonnet**

Component	Material Description	Material	Rough m/c Code	Drawing No
931133538000	BONNET ROUGH-G065	SA 105	931133530000	3VG06520427
	3VG06520426/01/000			

Scope: Rough machined and welded Bonnet will be provided. Complete machining as per drawing No. 3VG06520427

**Disk**

Component	Material Description	Material	Rough m/c Code	Drawing No
931121148000	DISC ROUGH-G045	A182 F22 CL3	931121140000	4VG04518038
	4VG04518037/01/000			

Scope: Rough machined and welded Disk will be provided. Complete machining with Tuffriding to be done as per drawing No. 4VG04518038