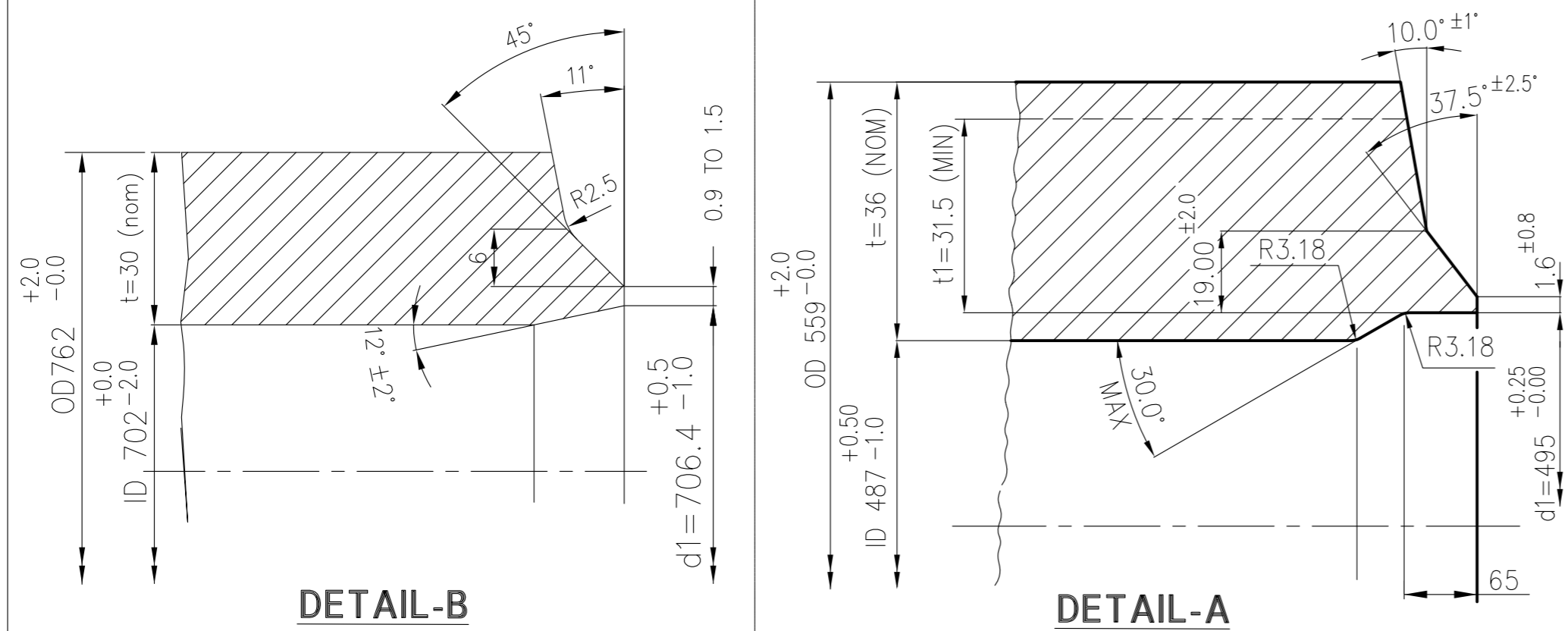
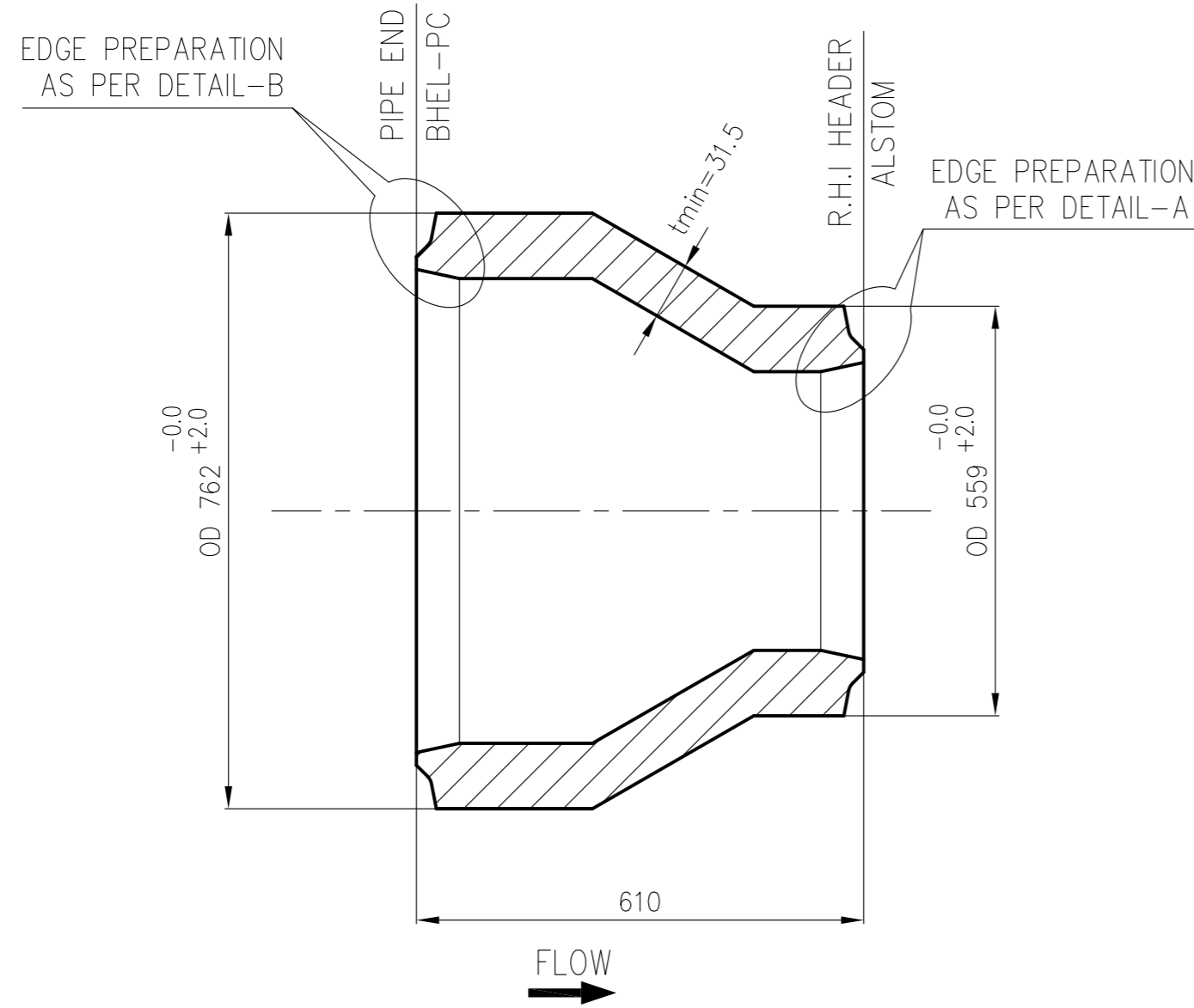


3-80-320-31193
DRAWING No

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NOTES

- DESIGN PRESSURE : 75 Kg/Cm2(g)
- DESIGN TEMPERATURE : 380 °C
- THE FINISHED MATERIAL SPECIFICATION IS 'SA 234 WPC'(A)
- THE FINISHED MATERIAL CODE IS '92 117 932 0000'
- FOLLOW TDC No. : TDG-102 (LATEST REVISION)
- DESIGN, MANUFACTURING, INSPECTION, TOLERANCES AND TESTING SHALL BE AS PER IBR, ANSI B16.9 AND SA 234.

01	ASME B16.9 REDUCER L=610 OD762X30/OD559x36	3-80-320-31193	-	A	288,209	
ITEM NO.	DESCRIPTION	DRAWING NO.	ITEM NO.	SA 234 WPC	A	UNIT WT.
			VAR NO.	MATERIAL SPEC.	C	QTY.

SPACE FOR IBR APPL.

	BHARAT HEAVY ELECTRICALS LTD., PIPING CENTRE, CHENNAI 600 017			NAME	SIGN	DATE	NO OF ITEMS
	DRN	KONDAPA			04.01.2014	-	
	CHD	KONDAPA			04.01.2014	-	
	APPD	R.SESHAGIRI			04.01.2014	-	

REV 01	DATE	ALTD APPD
ZONE		

DEPT. CODE	GRADE OF UN TOL. DIM C/M/F		SCALE N.T.S.	WEIGHT (Kg) ~289	BHEL PO REF.NO. -	ITEM No. -
TITLE ASME B16.9 BW CON REDUCER (OD762X30/OD559x36)			CARD CODE U 01	DRAWING No. 3-80-320-31193		REV 00

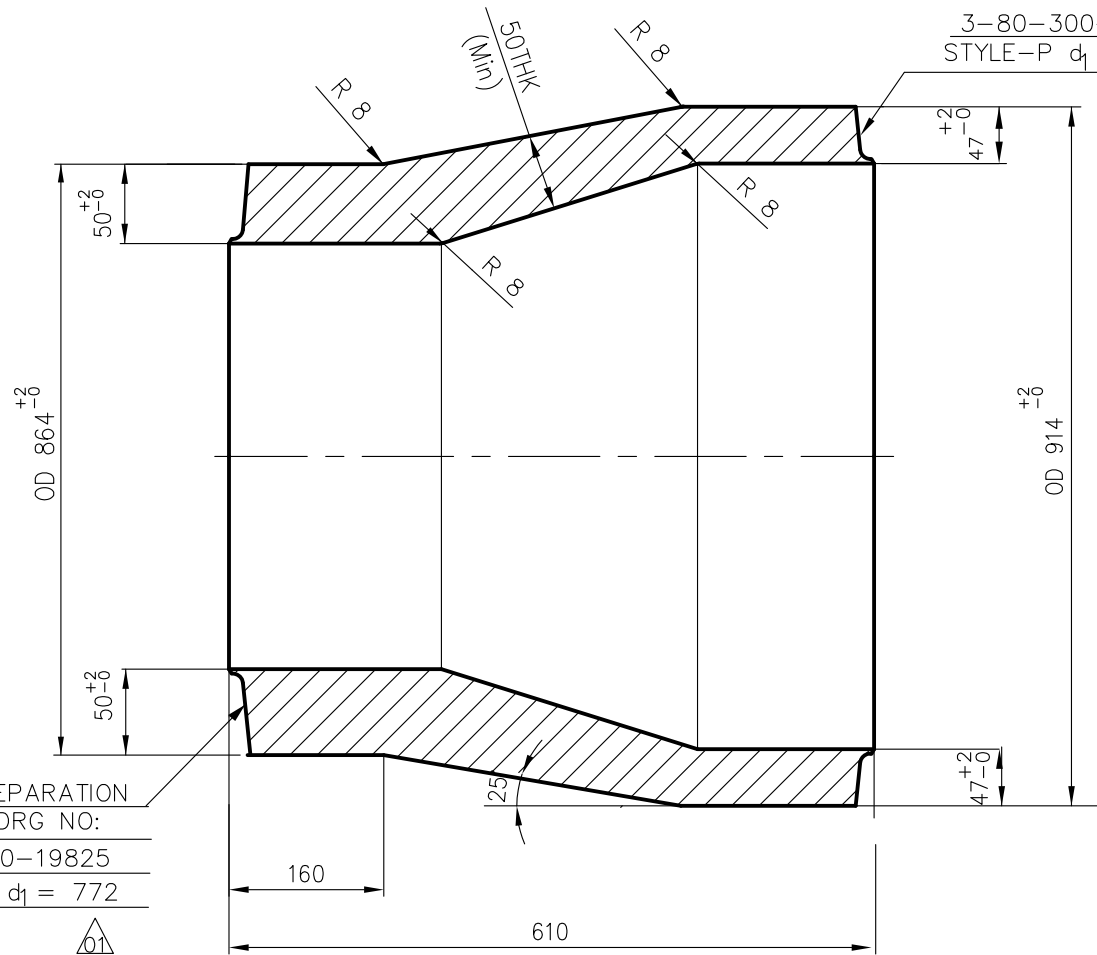
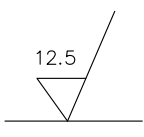
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REV	DATE	ALTERED: KONDAPA
01	16.09.14	APPROVED: R.SESHAGIRI
WELD END DIA REVISED		

NOTES :- ALL DIMENSIONS ARE IN MILLIMETRES

- DESIGN PRESSURE : 73.1 Kg/Cm² (g)
- DESIGN TEMPERATURE : 510° C
- FITTING SHALL CONFORM TO ALL THE REQUIREMENTS OF ASME B16.9 & A 234(LATEST).
- FOLLOW TDG.TDC.102.REV04
- THIS DRAWING IS FOR INDICATING THE OVER ALL DIMENSIONS, CONNECTING PIPE SIZE AND MATERIAL SPECIFICATION.

EDGE PREPARATION
AS PER DRG NO:
3-80-300-19825
STYLE-P d₁ = 820



EDGE PREPARATION
AS PER DRG NO:
3-80-300-19825
STYLE-P d₁ = 772

	REDUCER L=610 OD 914 x thk47min/ OD 864X50	92 117 573 0000	A	714 000
		SA 234 WP22CL1		
VAR NO.	DESCRIPTION	MATL. CODE	A	UNIT
		MATL. SPECN.	C	DI
				UNIT.WT.(Kg)
				QTY.

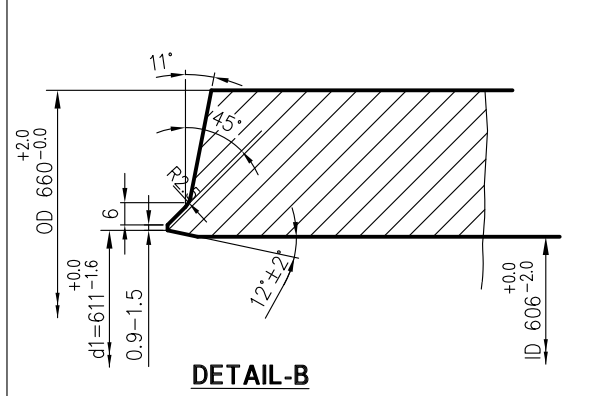
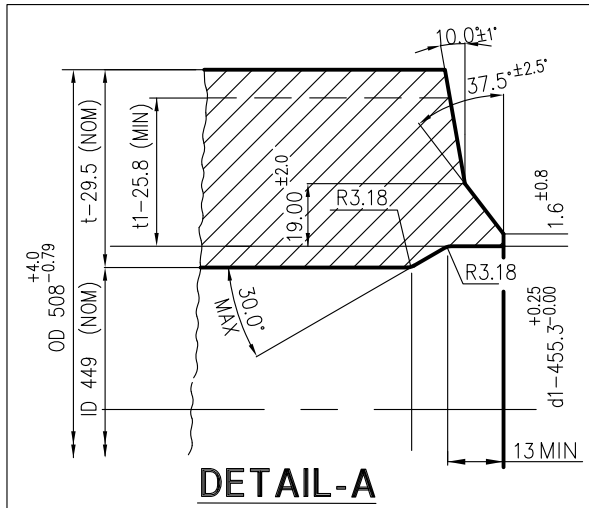
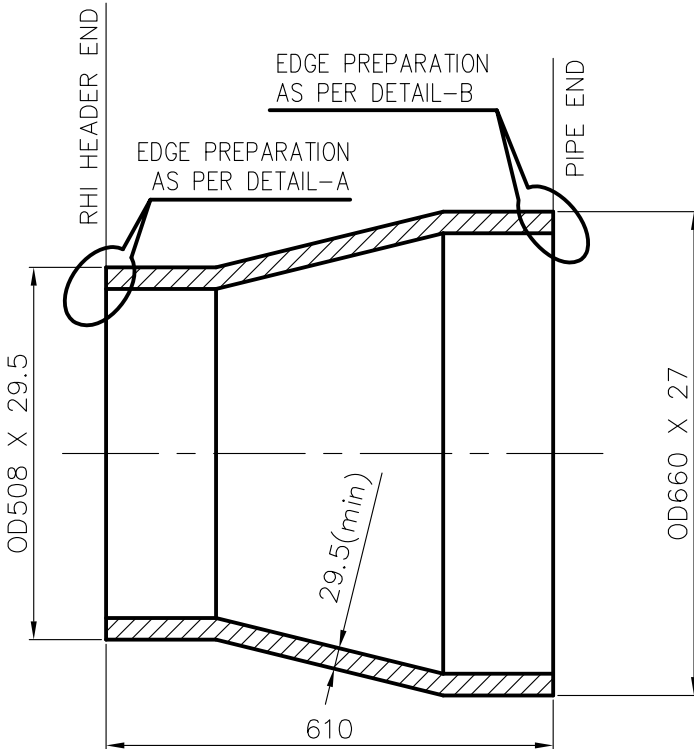
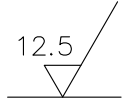
		BHARAT HEAVY ELECTRICALS LIMITED		DRN	LALIT	SIGN	DATE	NO.OF VAR
		PIPING CENTRE		CHD	C.SARAVANAN		16.05.10	
		CHENNAI 600 017		APPD	C.SARAVANAN		16.05.10	
DEPT	GRADE OF UNTOL.DIM		SCALE	WEIGHT (KG).	BHEL PO REF.NO:		ITEM NO.	NO. OF ITEMS
CODE	C / M / F		N.T.S	714.000				
TITLE				CARD CODE	DRAWING NO.			REV
REDUCER (OD914Xthk47min/OD864X50)SA234WP22CL1				U 01	4-80-320-70721			01

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REV 01	DATE	ALTERED :
		CHD & APPD :

NOTES:

- 1) DESIGN PRESSURE : 73.1 Kg/Cm²(g)
- 2) DESIGN TEMPERATURE : 378 °C
- 3) WORKING MEDIUM : STEAM
- 4) FOLLOW TDC No. : TDG-102 (LATEST REVISION)
- 5) DESIGN, MANUFACTURING, INSPECTION, TOLERANCES AND TESTING SHALL BE AS PER IBR, ANSI B16.9 AND SA 234.



-	OD660x27/OD508x29.5 L=610	92 117 845 0000	A	250 000	
					SA 234 WPC
VAR No.	DESCRIPTION	STD	A/C/P	UNIT	UNIT WT. (KG)
					QUANTITY



BHARAT HEAVY ELECTRICALS LIMITED
PIPING CENTRE
CHENNAI 600 017

	NAME	SIGNATURE	DATE
DRN	POONGKODI.V	..sd..	07/08/2013
CHD	SUKUMAR.B	..sd..	07/08/2013
APPD	C.V.NATHAN	..sd..	07/08/2013

DEPT	ALL DIMENSIONS ARE IN MM	PROJECTION	SCALE	WEIGHT (Kg)	REF TO ASSY / OLD DWG
CODE			N.T.S	250	

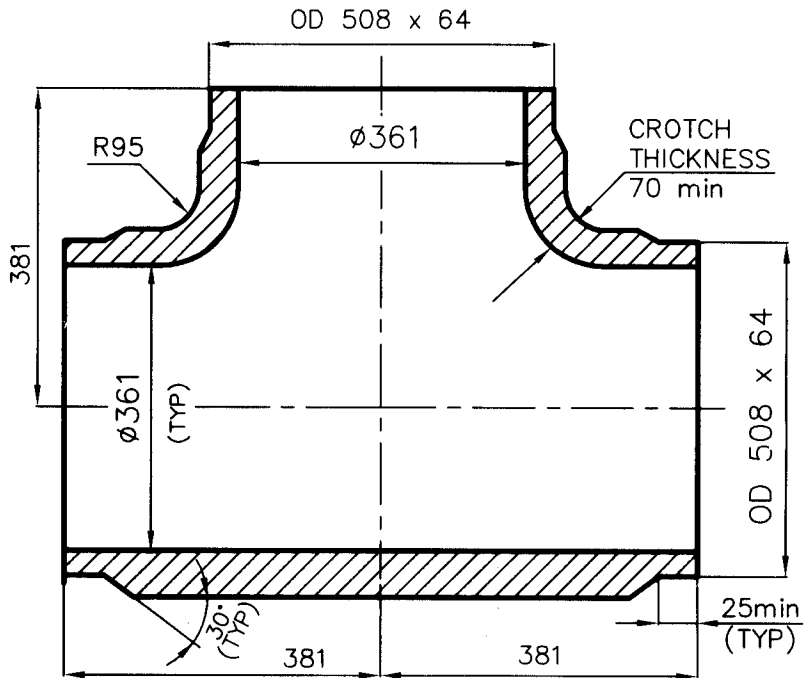
TITLE	DRAWING NO :	REV
ASME B16.9 BW CON REDUCER OD660x27/OD508x29.5	4-80-320-77261	00

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REV	DATE	ALTERED
		APPROVED

ALL DIMENSIONS ARE IN MILLIMETRES

RAW MATL SPECN: SA106Gr.C(A)
 FITTING SPECN : SA234WPC(A)
 FITTING SPECN : SA234WPC(A)
 FITTING MATERIAL CODE : 92 505 779 0000





NOTES:

- 1) ALL DIMENSIONS ARE FINISHED DIMENSIONS.
- 2) FOR TOLERANCES REFER STD. DRG. NO. 4-80-301-26192.
- 3) MANUFACTURING, INSPECTION AND TESTING SHALL BE AS PER IBR, ASME B16.9 & SA234.
- 4) MINIMUM THICKNESS FOR MAIN & BRANCH SHALL NOT BE LESS 56 mm
- 5) BORE TO $\phi 361$ AFTER FORMING, ON RUN AND BRANCH ENDS.
- 6) EDGE PREPARATION SHALL BE AS PER DRG. No.3-80-300-19825
 STY. P d1=392.00
- 7) HIGHER THICKNESS RAW MATERIAL PIPE CAN ALSO BE USED IN VIEW OF NOTE 5.
- 8) TEE SHALL BE MACHINED ON THEIR OUTSIDE DIAMETER BOTH RUN OF BRANCH ENDS FOR A MINIMUM LENGTH OF 25mm AS SHOWN IN THE DRG

PIPE OD 812.8 x 75 NOM L=1200	15 983 567 1200	A	1635.000
	SA 106 GRC		
RAW MATL SIZE	MATL. CODE	A	UNIT WT
	MATL. SPECN.	C	QTY

STANDARD

 BHARAT HEAVY ELECTRICALS LTD. PIPING CENTRE MADRAS 600 017		NAME	SIGN	DATE
		DRN	K.R.BALA	21.07.06
		CHD	T.N.ELANGOVAN	21.07.06
		APPD	T.N.ELANGOVAN	21.07.06
DEPT	GRADE OF UNTOL. DIM	SCALE	WEIGHT (KG).	REF. TO ASSY./OLD DRG.
CODE	C / M / F		1635.000	
TITLE		CARD CODE	DRAWING NO.	REV
EQUAL TEE OD 508 x 64		U 01	4-80-423-6260800	