

3-80-300-19825

DRAWING No.

NOTES: -

- 01. APPLICABLE FOR P91/P92
 - i) STRAIGHT WITH STRAIGHT/FITTING
 - ii) BEND WITH BEND/FITTING
- 02. FOR OD MISMATCHING REF. FIGURE-Xa.
- 03. $\alpha = 6^\circ$ FOR WALL THICKNESS ≤ 30 mm
- 04. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm

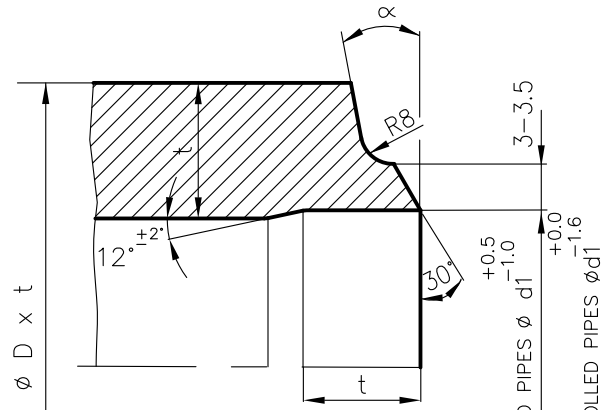


FIGURE - X

MATCHING EDGE PREPARATION FOR MISMATCH OD APPLICABLE FOR BENDS/FITTINGS OF P91/P92 MATERIALS

NOTES: -

- 01. OD OF STRAIGHT TO BE PHYSICALLY MEASURED/VERIFIED.
- 02. $\alpha = 6^\circ$ FOR WALL THICKNESS ≤ 30 mm
- 03. $\alpha = 10^\circ$ FOR WALL THICKNESS > 30 mm
- 04. t = THK OF CONNECTING PIPE (STRAIGHT)

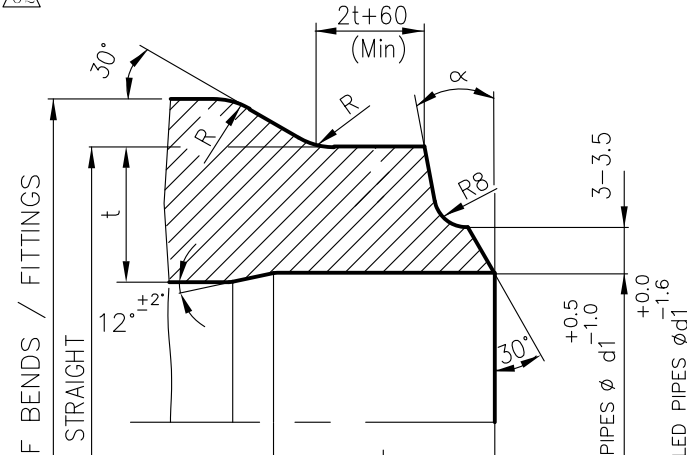
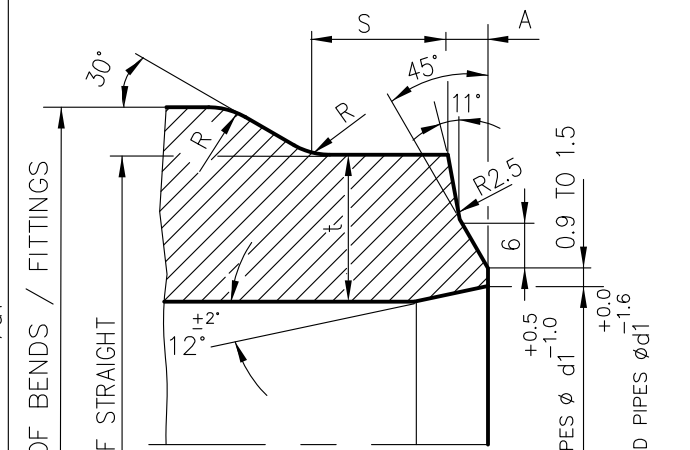


FIGURE - Xa

MATCHING EDGE PREPARATION FOR MISMATCH OD DIAMETRICALLY GREATER THAN 8 mm (ie OD1 - OD2 > 8mm) APPLICABLE FOR BENDS/FITTINGS OTHER THAN P91/P92 MATERIALS

NOTES: -

- 01. OD OF STRAIGHT TO BE PHYSICALLY MEASURED/VERIFIED.
- 02. WHEN $t < 65$, $S+A = 65$ Min. & $t > 65$, $S=65$ Min. WHERE t =THK OF CONN.PIPE(STRAIGHT).



STYLE - Pa

MATCHING EDGE PREPARATION FOR MISMATCH OD DIAMETRICALLY GREATER THAN 8 mm (ie OD1 - OD2 > 8mm) APPLICABLE FOR ELBOWS OTHER THAN P91/P92 MATERIALS

NOTES: -

- 01. OD = OUTSIDE DIA OF CONN. PIPE (STRAIGHT) TO BE PHYSICALLY MEASURED/VERIFIED.
- 02. t = THK OF CONN.PIPE (STRAIGHT)

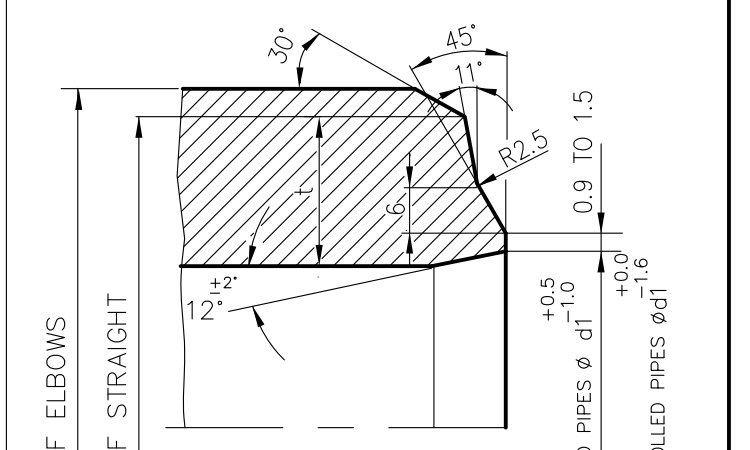


FIGURE - Z

NOTES: -

- 01. APPLICABLE FOR P91 PIPE BEND WELDED WITH P91 STRAIGHT PIPE FOR THICKNESS ≤ 30 mm AND OD ≥ 558 mm.
- 02. $\alpha = 6^\circ$ FOR WALL THICKNESS ≤ 30 mm
- 03. FOR OD MISMATCH, REFER THE OD MACHINING ONLY SHOWN IN FIGURE-Xa
- 04. FIGURE-Xb AND FIGURE-Xc ARE NOT APPLICABLE FOR P92 MATERIALS.

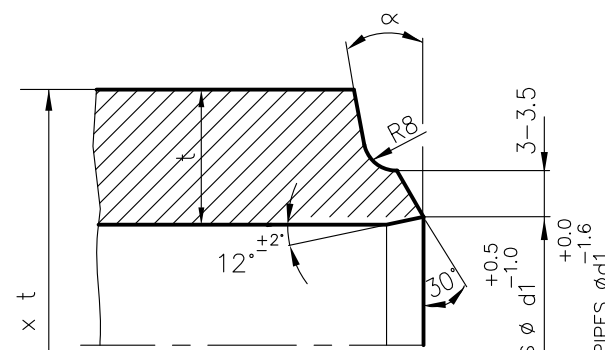


FIGURE - Xb (BEND END)

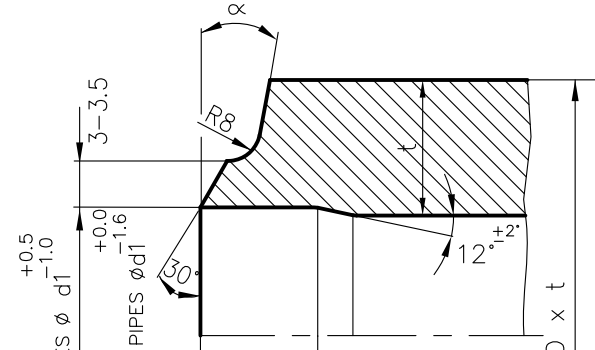
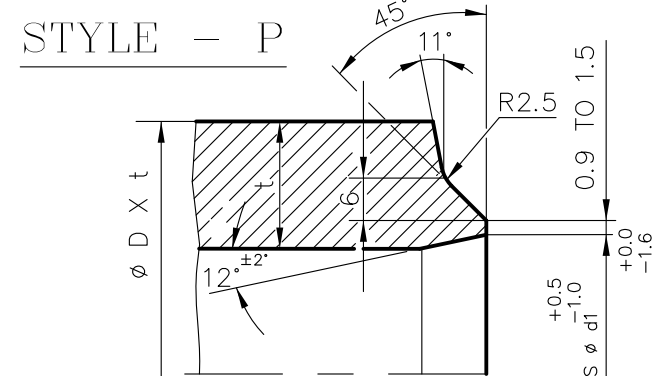


FIGURE - Xc (STRAIGHT END)

STYLE - P

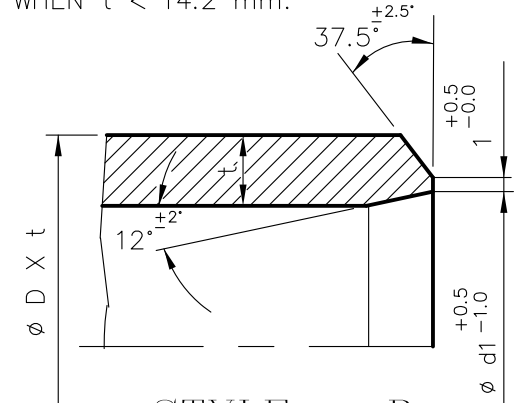


NOTES: -

- 01. USE WHEN $t \geq 14.2$ mm.
- 02. FOR OD MISMATCHING REF. FIGURE-Pa

NOTES: -

- 01. USE WHEN $t < 14.2$ mm.



STYLE - D

TYPE OF PRODUCT OR NAME OF CUSTOMER/PROJECT

STANDARD

	BHARAT HEAVY ELECTRICALS LTD.		DRN	NAME	SIGN	DATE	NO OF ITEMS
	PIPING CENTRE, MADRAS		CHD	K.B.RAGUNATH		11.10.01	
			APPD	M.C.SEKARAN		11.10.01	
				APPD	A.VELAYUTHAM	11.10.01	

DEPT.	GRADE OF UN TOL DIM	SCALE	WEIGHT (Kg)	NAME OF ORIGINAL ORGANISATION	ITEM No.
CODE	C/M/F				

TITLE	CARD CODE	DRAWING No.	REV
EDGE PREPARATION DETAILS	U 01	3-80-300-19825	03

GENERAL NOTES :

- 01. THE MINIMUM THICKNESS AT WELD END SHALL NOT BE LESS THAN
 - a) 0.875 TIMES t NOM. FOR OD PIPES.
 - b) t MIN. FOR ID CONTROLLED PIPES.
- 02. t NOM & t MIN SHALL BE AS PER SPECIFIED PIPE SIZE.
- 03. SHARP CORNERS SHALL BE ROUNDED OFF WHEREEVER 'R' IS INDICATED.

NOTES FOR WELDING:

- 01. WELD REINFORCEMENT TO BE FLUSH GROUND AND MERGED WITH PARENT METAL WITHOUT ANY UNEVENNESS.

REV 03	DATE 10.04.13	ALTERED: M.R.K	APPROVED: C.K.N
ZONE	FIG.Xb AND FIG.Xc ADDED. IN FIG.X. NOTE 01 MODIFIED. IN FIG.Xa, STY-Pa, FIG.Z. P92 MATERIAL ADDED		
REV 02	DATE 10.01.13	ALTERED: M.R.K	APPROVED: C.K.N
ZONE	IN FIG.Xa, NOTE 04 ADDED. GENERAL NOTES 03 ADDED. IN FIG.Xa, 8MM OD MISMATCH IS REMOVED		
REV 01	DATE 11.05.04	ALTERED: R.SENDHIL	APPROVED: A.VELAYUTHAM
ZONE	PROJECT NAME REMOVED AND STANDARD INCORPORATED IN TITLE BLOCK		