



GUIDELINES FOR ACCEPTABILITY OF RADIATORS.

FOLLOWING GUIDELINES SHALL BE FOLLOWED FOR ACCEPTANCE OF RADIATORS.

1. ALL SEAM WELDING WHEN REPAIRED FOR LEAKPROOF SHALL BE GROUND TO SMOOTH AND STRAIGHTNESS OF EDGES SHALL BE MAINTAINED WITHIN 2 mm./mtr. AND MAX UPTO 3 mm. ON TOTAL LENGTH.
2. LEAKAGE AT NIPPLE TO HEADER WELDED JOINT SHALL BE ARRESTED BY WELDING EXTERNALLY. WELDING SHALL BE GROUND TO SMOOTH. WELD SIZE AT THIS LOCATION IS 3 mm. & SHALL NOT INCREASE IN ANY CASE ABOVE 5 mm. AT CERTAIN LOCATIONS.
3. ALL OUTER ELEMENTS OF RADIATOR SHALL HAVE EXTERNAL WELDING AT NIPPLE TO HEADER JOINTS IN ADDITION TO INTERNAL WELDING TO MAINTAIN UNIFORMITY IN RADIATORS.
4. PROJECTION OF EDGES AT MATCHING LINE SHALL BE MAINTAINED AS PER DRG NO. 14994300011.
5. ALL WELD SPATTERS, BURRS, EXTRA PROJECTIONS OF WELD DEPOSITS SHALL BE GROUND TO SMOOTH AND STRAIGHTNESS OF EDGES SHALL BE MAINTAINED.
6. LEAKAGES AT SEAM WELDED JOINTS OF ELEMENTS SHALL BE ARRESTED BY WELDING MANUALLY FOR THE LOCAL AREA AND WELDING SHALL BE GROUND TO SMOOTH.
7. ALL WELDING SIZE SHALL NOT BE MORE THAN 2 mm. OVER THE SIZE CALLED IN THE DRAWING.

Comp.drg.

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DRG CONVERTED INTO JHANSI ORIGINAL 25.08.99 AK9 1000	वितरण DISTRIBU. सै TRE, TRP. CQX, FBM. BAY-8 BAY-9	स्वीकृत किया = APPROVED: <i>[Signature]</i>	
		तैयार किया PREPD. <i>[Signature]</i>	जारी किया ISSUED टीजरई मानक TRE/STD
		दिनांक DATE	26.08.99