



**PLANT STANDARD
HYDERABAD**

HY 731 66 63

REV. NO: 01

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**WELDING-ON EXTENSION PIECE FOR PRESSURE GAUGES
CONNECTIONS NOMINAL PRESSURE (NP) 640**

DESIGNATION: EX: WELDING ON EXTN PIECE M20X1.5L

MATERIAL CARBON STEEL: IS1570 C40(N), AA 10208
STAINLESS STEEL : IS 6603, AA10721 (20 Cr 13)

STANDARD : HY 7316663
DIMENSIONS : C SN 137528
THREADS : IS 42186G

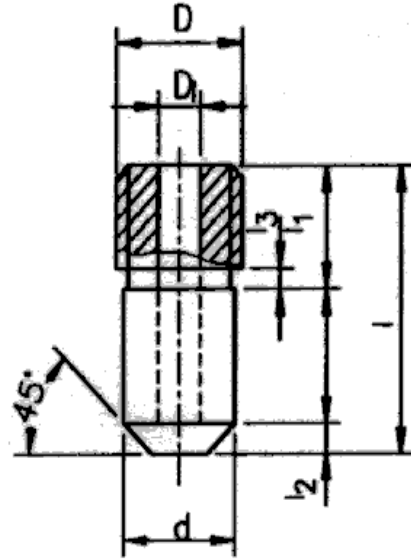


TABLE-1

SIZE D	d	d ₁	l	l ₁	l ₂	l ₃	WEIGHT PER PIECE (kg)	MATER IAL	NEW CODE
									OLD CODE
M 12X1.5L	11	5.5	50	12	3	2	0.034	CS	HY 731 66 63 014
									787 52 80 032
M20X1.5L	19	7	80	20	5	3	0.160	CS	HY 731 66 63 022
									787 52 80 042
M20X1.5L	19	7	80	20	5	3	0.160	SS	HY 731 66 63 111
									-

Revisions:
1. SS Material added

Issued :
**STANDARDS ENGINEERING
DEPARTMENT**

Rev.No.	Rev.Date:	Revised:	Prepared:	Approved:	Date:
01	MAR '88		KSN.	KLM	NOV 85'

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RESTRICTED USE





TABLE 2: RAW MATERIALS

SIZE	RAW MATERIAL SIZE	RAW MATERIAL CODE	SUPER SEEDED DRG. NO.	SUPER SEEDED OLD CODES
M12x1.5 L	Ø 16 X 55	AA 1020208082	5-11-1671	787 52 80032
M20 x 1.5 L	Ø 25 X 83	AA 1020208120	5-11-0745	787 52 80042
M 20 x 1.5 L	Ø 25 X 83	AA 107 02 21120	--	-

- NOTES:
1. RAW MATERIAL AS PER BHEL PLANT RATIONLISED SIZES.
 2. DESIGNERS SHALL INDICATE 'M' AND RAW MATERIAL CODE IN THE PIECE LIST.
 3. IN THE CASE OF SUB CONTRACTED ITEMS SPECTROSCOPIC ANALYSIS BY METASCOPE SHALL BE DONE AT THE IGI STAGE.
 4. WEIGHTS INDICATED IN THE STANDARD ARE APPROXIMATE.