



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

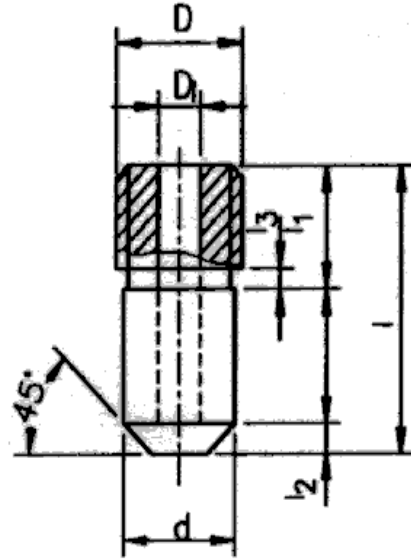


TABLE-1

| 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.