

PSGSG/1 2-13/15	Product Specifications For CB HOUSING ASSEMBLY	Drg. No.	RD DG 4 35 0617 0210														
Date		11.06.13															
Product		GSM 420															
<p>1.0</p> <p>2.0</p> <p>3.0</p> <p>3.1</p> <p>3.2</p> <p>3.3</p> <p>3.4</p>	<p>Application : The stainless steel CB Enclosure Assembly to Drawing. No. RD DG 4 35 0617 0210 is used for gas filled applications. The gas pressure in this metal enclosure is maintained at 0.7-0.9 MPa. The CB Housing assembly shall meet following Specifications.</p> <p>Drawings :</p> <table border="0"> <tr><td>CB Housing</td><td>RD DG 4 35 0617 0210</td></tr> <tr><td>Pipe</td><td>RD DG 4 35 0617 0211</td></tr> <tr><td>Reducer-I</td><td>RD DG 4 35 0617 0212A</td></tr> <tr><td>Flange I:</td><td>RD DG 4 35 0617 0951</td></tr> <tr><td>Reducer II:</td><td>RD DG 4 35 0617 0213A</td></tr> <tr><td>Flange II :</td><td>RD DG 4 35 0617 0212B</td></tr> <tr><td>Extension-I</td><td>RD DG 4 35 0617 0214A</td></tr> </table> <p>SPECIFICATIONS:</p> <p>Material: Low Carbon Austenitic stainless steel confirming to AISI-304L.</p> <p>Standard seamless or ERW (straight/ spiral) tubular sections shall be used for construction, here ever applicable in design. Fabricated (allowing rolled and seam welded) / drawn sections can be used for other areas not conforming to standard pipe schedules.</p> <p>Drawn profiles, to size, only shall be used for direct welding with the flanges (To be machined to the drawing only after welding). No smithy is allowed for formation/ matching of profiles in view of defect inception. Pipe and flanges shall be MIG/TIG welded with suitable SS electrode.</p> <p>The welded sections shall be sized as per drawing and verified /tested using Dye Penetration (D.P.) technique at all stages of welding. Inside edges/weld shall be fused to obtain near smooth weld surface.</p>	CB Housing	RD DG 4 35 0617 0210	Pipe	RD DG 4 35 0617 0211	Reducer-I	RD DG 4 35 0617 0212A	Flange I:	RD DG 4 35 0617 0951	Reducer II:	RD DG 4 35 0617 0213A	Flange II :	RD DG 4 35 0617 0212B	Extension-I	RD DG 4 35 0617 0214A		
CB Housing	RD DG 4 35 0617 0210																
Pipe	RD DG 4 35 0617 0211																
Reducer-I	RD DG 4 35 0617 0212A																
Flange I:	RD DG 4 35 0617 0951																
Reducer II:	RD DG 4 35 0617 0213A																
Flange II :	RD DG 4 35 0617 0212B																
Extension-I	RD DG 4 35 0617 0214A																
1/3	PSGSG/12-13/15.doc		Signature														

PSGSG/1 2-13/15	Product Specifications For CB HOUSING ASSEMBLY	Drg. No.	RD DG 4 35 0617 0210
		Date	11.06.13
		Product	GSM 420
<p>3.5</p> <p>3.6</p> <p>3.7</p> <p>3.8</p> <p>3.9</p> <p>3.10</p>	<p><u>The flanges shall be manufactured to drawings after welding only.</u> The flanges shall be machined as per instructions and maintaining parallelism of faces and Perpendicularity as prescribed. To ensure parallality, it is must to machine the components after welding all the sections as prescribed. The flange sealing surfaces shall be polished to RA 0.6 or better and the bolting holes shall be machined fine, using CNC milling, and shall have uniform chamfer. The tolerances, wherever not mentioned in the drawing, shall be within 0.10. Any sharp corners shall be removed as per the drawing. Wherever not specified in the drawing, a chamfer of 0.5x45° shall be provided at the sharp corners and edges.</p> <p>All flanges of different dimensions shall be welded by maintaining parallality as per limits of manufacturing drawing.</p> <p>Weld splatter, if any, shall be removed by chipping or grinding on completion of the weld. Particular care should be taken to avoid any splatter on the inside of the chamber, at the joint or other locations.</p> <p>Dye penetration report shall be generated and submitted to BHEL.</p> <p>The tested assembly should be cleaned, degreased and prepared for pressure test. The assembly shall be tested at 9.0 bar pressure for 4 hours and pressure drop shall be recorded and communicated to BHEL. The leak shall be rectified and the test repeated to satisfaction. Components indicating drop in pressure during this test will not be accepted. The arrangement shall be kept at 20 bar for 15 minutes prior to this test to verify pressure withstanding capabilities specified in drawing.</p> <p>The supplier shall stress relieve tested component to ensure zero post supply deformation.</p>		
2/3	PSGSG/12-13/15.doc		Signature

PSGSG/12 -13/15	Product Specifications For CB HOUSING ASSEMBLY	Drg. No.	RD DG 4 35 0617 0210
Date		11.06.13	
Product		GSM 420	
<p>3.11</p> <p>3.12</p> <p>3.13</p> <p>3.14</p> <p>4.0</p> <p>5.0</p> <p>6.0</p>	<p>Stress relieved component shall be electro-polished on the inside surface using moderate current densities.</p> <p>The assemblies further shall be sandblasted on the outer surface and powder coated (> 50 Micron) as specified in drawing. During this operation all flanges shall be masked at the sealing surfaces and at the rim.</p> <p>The dimensional checks and the leak test shall be carried out in presence of BHEL inspector.</p> <p>The accepted component shall be packed in wooden boxes with suitable PVC covers on the flanges to prevent transit damages. A thick polyethylene cover shall be used to seal to component from ingress of moisture and water. For transit time higher than 2-weeks, adequate quantity of moisture absorbent shall also be placed with the component.</p> <p>Following certificates shall be furnished for acceptance of the component: 3.15.1 Material source certificate, 3.15.2 Material test certificate , 3.15.3 Stage wise DP tests, 3.15.4 Pressure drop test and pressure withstand test report, 3.15.5 Electro-polishing schedule. A certified copy of above documents shall be sent along with the delivery not.</p> <p>The components shall be guaranteed against all manufacturing defects.</p> <p>In case of doubts in specifications, the supplier shall contact BHEL for clarifications.</p> <p>Qualification requirements: The supplier shall be of national repute with proven record and should have supplied similar enclosures. Supplies reference list shall be provided along with the offer</p>		
3/3	PSGSG/12-13/15.doc		Signature