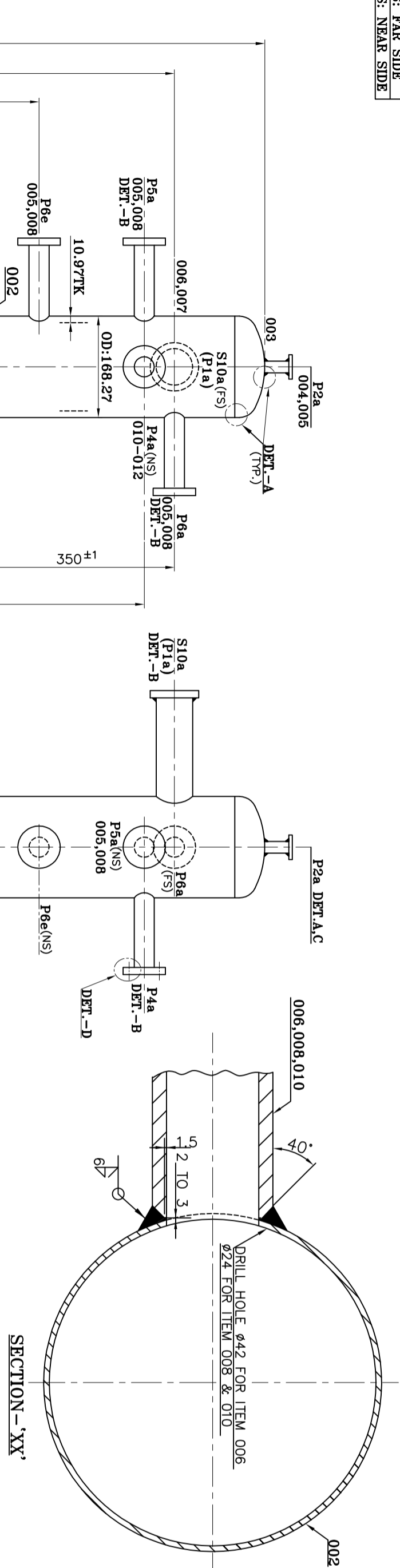


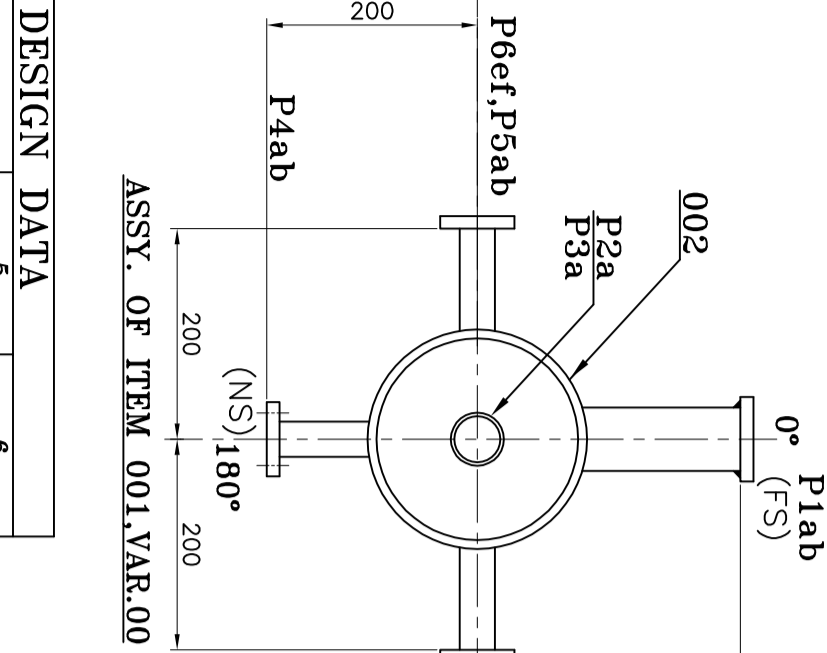
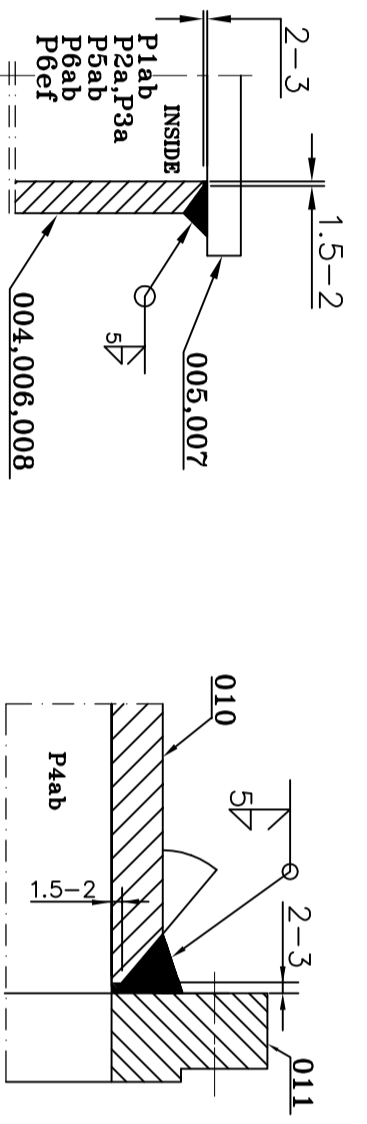
06405-50521-20N 3RD

FS: FAR SIDE  
NS: NEAR SIDE



DETAIL 'A'  
ASME SEC. VIII DIVN. 1  
FIG. UW 13.2 (D)

DETAIL 'B' (TYPICAL)  
(ASME SEC. VIII DIVN. 1)  
FIG. UW 16.1 (C)



DESIGN DATA

H.P. HEATER No.	5	6
DESIGN PRESSURE Kg/sq.cm	18.0	46.3
DESIGN TEMPERATURE °C	235	285
HYDROSTATIC TEST PRESSURE Kg/sq.cm	27	69.5

ASSY. OF ITEM 001, VAR. 00

REV.	DATE	APPROVED	ZONE
1			
2			
3			
4			
5			
6			
7			
8			
9			
10			
11			
12			

**TECHNICAL REQUIREMENTS (TR)**

- STAND PIPE TO BE CONSTRUCTED IN LINE WITH IBR-1950. WELDERS TO BE QUALIFIED AS PER INDIAN BOILER REGULATION-1950.
- ALL BUTT WELDS TO BE CHECKED BY FULL RADIOGRAPHY EXAMINATION AS PER UW-51 OF ASME SEC. VIII DIV. 1; 2010.
- ALL WELDS TO BE CHECKED BY DYE PENETRATION EXAMINATION AS PER APPENDIX-8 OF ASME SEC. VIII DIV. 1; 2010.
- HOLES FOR ITEMS 004, 006 & 008 TO BE DONE BY DRILLING.
- ITEM No. 009 TO BE HELD IN POSITION BEFORE WELDING NOZZLE CONNS. ON PIPE ITEM 002.
- TOLERANCE AS PER HE-04002 UNLESS OTHERWISE SPECIFIED.
- POST WELD HEAT TREATMENT (STRESS RELIEVING)-NOT REQUIRED
- STAND PIPE TO BE CHECKED BY HYDROSTATIC TEST AT PRESSURES INDICATED IN DESIGN DATA FOR 30 MINUTES (MINIMUM) AS PER HE-74033.
- INTERNAL SURFACE TO BE LEFT UNPAINTED AFTER ACID PICKLING AS PER BP-0690096.
- EXTERNAL SURFACES TO BE PAINTED WITH MINIMUM TWO(2) COATS OF HEAT RESISTANT AIR DRYING ALUMINUM PAINT TO AA-56134. DFT: 100 MICRONS (MINIMUM)
- ITEM No.004,006 & 008 INCLUDES SITE CUTTING ALLOWANCE OF 25 mm.
- IMPORTANT: ITEMS MARKED THUS (X) ARE FOR HYDROSTATIC TESTING & ITEM MARKED THUS (●) ARE NON-PRESSURE PARTS. HENCE IBR INSPECTION NOT REQUIRED.

ISSUED BY	CHECKED BY	APPROVED BY

NO.	DESCRIPTION	QTY.	UNIT	WT.	NO.	DESCRIPTION	QTY.	UNIT	WT.
01	00:250 ID:170								
02	118								
06	118								
07	12 TK.								
08	BRANCH PIPE:50NB S10ab 60.3 ODx8.74 TK.(P1ab)								
09	BRANCH PIPE:25NB P5ab P6ab,P6ef 00:33.4x4.55TK. P4ab 12TK.								
02	BLANK P2a,P3a, P6ab,P6ab 12 TK. (P1ab)								
02	BRANCH PIPE:50NB S10ab 60.3 ODx8.74 TK.(P1ab)								
08	BLANK P2a,P3a, P6ab,P6ab 25 NB ANSI 6000#								
02	COUPLING P2a,P3a								
02	END CAP								
01	STAND PIPE 168.3 O.D.X10.97TK.								
01	STAND PIPE ASSY. NO. 51/61								

28 - CARD TYPE-3

64	65	78	79	25	27	29	59	60	77	29	31	34	45	55	56	59	69	72	
VARO QTY-Nos.	REMARKS	VAR. NO.	ITEM NO.	DESCRIPTION	DRAWING NO.	VAR.	MATL. SPCN.	C	VAR.	MATL. SPCN.	SA	516	GR.60/70	NO	SA	105	N	A	NO

10.04.12 21750540397

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DESIGN DATA

H.P. HEATER No.	5	6
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DESIGN TEMPERATURE °C	235	285
HYDROSTATIC TEST PRESSURE Kg/sq.cm	27	69.5

ASSY. OF ITEM 001, VAR. 00

DETAIL 'C'

DETAIL 'D'

ISSUED BY

CHECKED BY

APPROVED BY

ADDITIONAL INFORMATION

DRG. LIST NO. 4-17500-40093

STATUS OF DRAWING C-141-39/40

W.O. No. 15020/24-C-141-39/40

DISTRIBUTION OF PRINTS

CODE-1 HCM-4

H.P. HEATER No. 5 & 6

STAND PIPE ASSY. No. 51/61

2-17505-40490 00