

1009F-44201-C

DRAWING No.

DESIGN SPECIFICATIONS OF COMPENSATOR :-

OPERATING PRESSURE : 1.0235bar
 OPERATING TEMPERATURE : 325°C
 MOVEMENT OF BELLOWS (mm) :
 AXIAL : 6
 LATERAL 1 : 4
 LATERAL 2 : 1
 No. OF CONVOLUTIONS : *
 ACTIVE LENGTH OF BELLOWS : *
 NATURAL FREQUENCY : *
 FREQUENCY OF BELLOW SHOULD BE AWAY FROM 50HZ. BY ATLEAST 25%.
 PERMISSIBLE LIFE : 10,000 CYCLES AT ROOM TEMP.

MATERIAL OF BELLOW & BACKING RING :-

BHEL MATERIAL GRADE AA10740 (X100C18N10T1)
 EQUIVALENT MATERIAL GRADES IS:6911 (GR:X100C18N10T1 FINISH No.1)/ASTM A240 TP321 / EN10088 PART-3 GR. H60CHN11810 (MATERIAL CODE 1.4541) ARE ALSO ACCEPTABLE.

WELD ENDS & PROTECTIVE TUBE :-

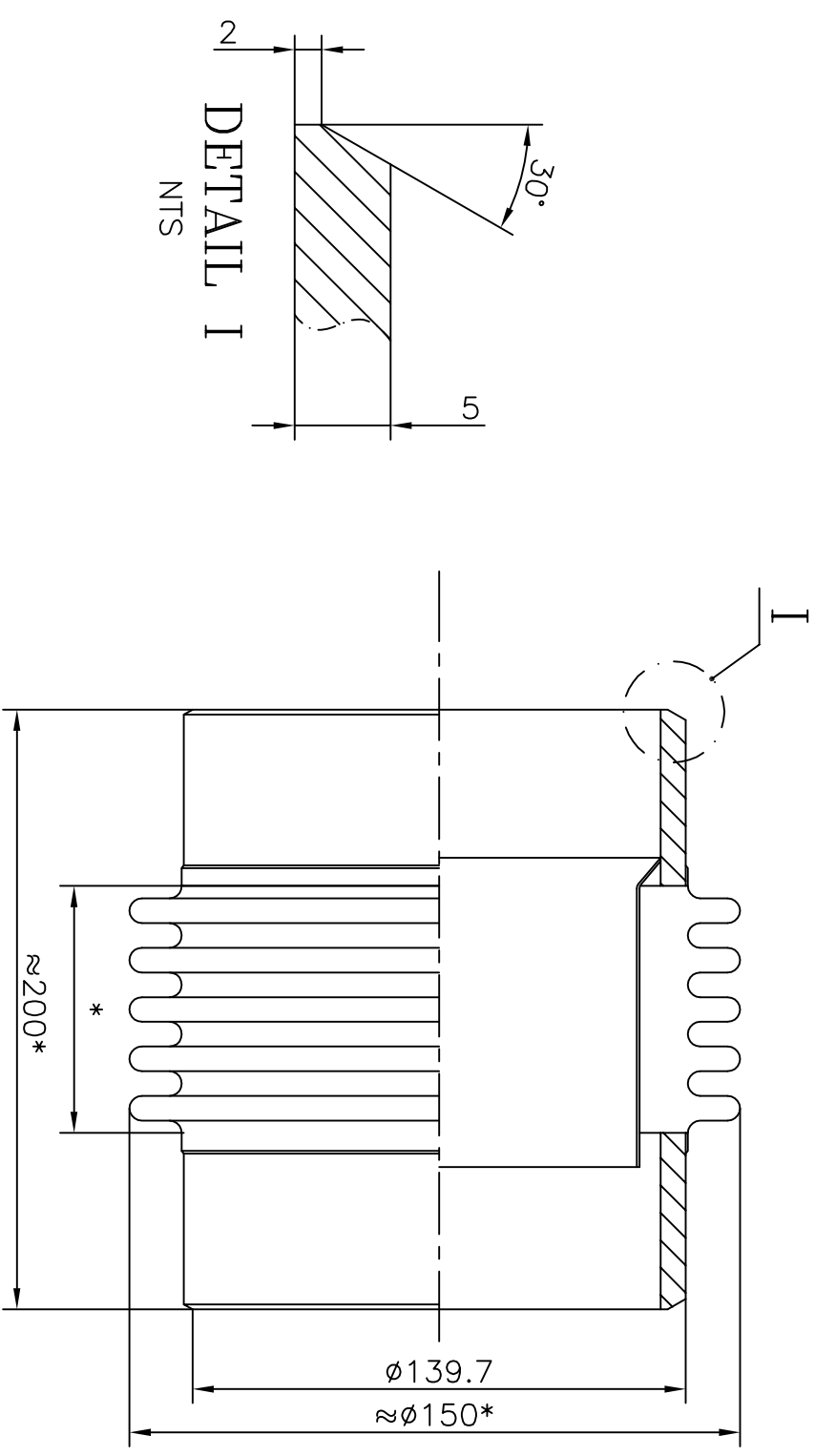
BHEL MATERIAL GRADE AA10401 BOILER QUALITY PLATE HIH.
 EQUIVALENT MATERIAL GRADES IS:2002 GR.II NORMALISED / EN 10028 PART-2 GR. P265GH (MATERIAL CODE 1.0425) PART-2 / ASTM A516 GR. 70 ARE ALSO ACCEPTABLE PROVIDED PLATES MORE THAN 12 mm ARE NORMALISED, IF ALREADY NOT DONE SO DURING ROLLING OF PLATES. OTHER EQUIVALENT MATERIALS CAN ALSO BE CONSIDERED WITH PRIOR APPROVAL OF BHEL.

TECHNICAL REQUIREMENTS :

1. 100% RADIOGRAPHIC EXAMINATION OF LONGITUDINAL SEAM OF BELLOW BEFORE FORMING THE BELLOW .
2. 100% DPT ON OUTSIDE & INSIDE LONGITUDINAL SEAM BEFORE AND AFTER FORMING.
3. 100% DPT OF FILLET WELDS.
4. 100% RADIOGRAPHIC EXAMINATION OF ALL BUTT WELDS.
5. LEAK TEST (NEKAL TEST) WITH FOAMING MEDIUM.
6. HYDRAULIC TEST PRESSURE : 3bar FOR 10min. AT ROOM TEMPERATURE.
7. DIRECTION OF FLOW TO BE MARKED ON THE COMPENSATOR.
8. EACH COMPENSATOR TO BE PACKED SUITABLY TO AVOID DAMAGE DURING TRANSIT.
9. SUITABLE SHIPPING BRACKETS SHOULD BE PROVIDED, WHICH SHALL BE REMOVED AFTER INSTALLATION AT SIDE.

NOTE :

1. EXACT DIMENSIONS AND DATA MARKED * ARE TO BE FURNISHED AND INCORPORATED BY SUPPLIER ON THEIR DRG.
2. SUPPLIER TO FURNISH SPRING RATE, FREQUENCY, DESIGN CALCULATIONS AS PER EJMA AND DRAWING FOR APPROVAL.



210MM & 250MM ST. STEAM SUPPLY LINE TO LP SHAFT SEAL

210MM
 OPER. PRESSURE : 1.023 bar
 TEMPERATURE : 325°C (max.)

250MM
 OPER. PRESSURE : 1.023 bar
 TEMPERATURE : 391.16°C

MATERIAL CODE : W97310744128

GMS No. / 0-10744-46000	C B O M	STATUS OF DRG
AGREED DEPT	NAME	SIGN
DATE	DATE	DATE

TYPE OF PRODUCT **STEAM TURBINE**
 OR
 NAME OF CUSTOMER/PROJECT

BHARAT HEAVY ELECTRICALS LTD.
RANIPUR, HARDWAR

DRN	SUDHIR	SD/-	24.03.07	NO. OF VAR
CHD	N.VERMA	SD/-	24.03.07	
Appd	A.SHAH	SD/-	24.03.07	73 74

DEPT	STE	SCALE	WEIGHT (KG)	REF. TO ASSY. DRG.	ITEM No.	NO. OF ITEMS
CODE	4011	1:2	3.50	0-10744-46000	75	77

TITLE : **COMPENSATOR Dn 125**

CARD CODE : **3-10744-46001**

Inventory No	Sign & Date	Ref.Drawing No>
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REV	DATE	ALTERED	CHECKED

GRADE OF UNTOL. DIM	REV	DATE	ALTERED	CHECKED
M/CG.- AA0230208 m				
WELDING-CLASS 'B' OF AA0621104				
GAS CUTTING-TABLE 3 OF AA0621101				

REV	DATE	ALTERED	CHECKED

DRAWING NO.	3-10744-46001	22 23 24
SHEET No.	1	No. OF SHEETS 1

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