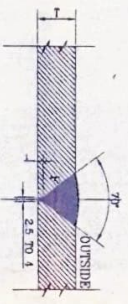


DETAIL AT "Y"

TOTAL LENGTH = 73575



TUBE WELDING DETAIL
AS PER I.B.R. FIG NO.28 IX (a)

DESIGN DATA :-
INTENDED WORKING PRESSURE -- 53.50 KG./CM.² S.O.G
HYD. TEST PRESSURE (AT SITE) -- 80.25 KG./CM.² S.O.G
S.H. OUTLET TEMPERATURE -- 450°C
MAX METAL TEMP. 1) PRIMARY COIL :- 400°C

HEATING SURFACE OF S.H. COIL-

E OF S.H. COIL-

- 1) ALL PRESSURE PARTS ARE DESIGNED AND MANUFACTURED AS PER INDIAN BOILER REGULATION, 1950 AS AMENDMENTED UP TO DATE
- 2) MEAN BENDING RADII OF S.H. COLL. 75 mm
- 3) ——— INDICATE SHOE WELDING & $\frac{1}{2}$ " ϕ INDICATE SITE WELDING
- 4) POSITION OF SHIP FEND MAY GET CHANGED ACCORDING TO MATERIAL AVAILABILITY
- 5) BUTT WELD JOINTS ARE TO BE RADIOGRAPHED AS PER PER 5904
- 6) DISPATCH INSTRUCTIONS, AND PLATING INSTRUCTIONS SHOULD BE AS PER S.S.-RI-1644'S, RI-165 RESPECTIVELY
- 7) THINNING IN THICKNESS FOR BENTON FEND ALLOWED AFTER BENDING OF TUBE IS 22% OF T.H. THICKNESS

**THERE IS NO EXTRA MATERIAL/MARGIN FOR
SITE/SHOP ADJUSTMENT**

STD B - REMOVE SHARP EDGES AND ROUNDS NOTE: A - ALL DIMENSIONS ARE IN MILLIMETERS UNLESS OTHERWISE SPECIFIED		BT NO.-44	
CUSTOMER:- CSEB		QUALITY	
DESCRIPTION		MATERIAL SIZE	
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TITLE		C/D	
PRIMARY AND SECONDARY S.H. COILS		C/D	
SCALE		APPRO	
1:30		APPRO	
DATE		REF. DESG. NO.	
02/01/04		DESG. NO.	
		2BL-42365	
		MALCHANDANAGACH INDUSTRIES LTD. MALCHANDANAGACH INDIA 413114	
		REV	