



NO.	DATE	REVISION	BY	CHKD.
1	19/09/95	THREAD SIZE CORRECTED	S.R.	
2	23/09/95	TESTING NOTE REVISED & FOLLOW PA-436754	S.R.	
3	23/09/95	DRG. REVISED AS PER LETTER # BF/2406/95	S.R.	
4	14/12/97	ITEM 2 & MAT. SPEC. CORRECTED	S.R.	
5	10/06/96	ITEM 2 & 3 INCORPORATED & PIPE LENGTH CHANGED	S.R.	
6	20/05/96	PIPE LENGTH ALTERED AS PER DISCUSSION	S.R.	

NOTE:-  
ALL PIPES ARE SEAMLESS.

MAT. SPEC.:- FOR ITEM 1, 2, 3 & 4  
ITEM No. 1, 2, 3 & 4 UNS S30815 (AISI-310)  
COMPOSITION:-  
C=0.05 TO 0.1  
Mn=0.8  
p=0.04  
s=0.03  
si=1.4 TO 2  
Ni = 14 TO 210-12  
Cr = 20 TO 22 %  
N = 0.14 TO 0.2  
C<sub>eq</sub> = 0.03 TO 0.08

OR

AISI 310 STABILISED CERUM & NITROGEN  
USE FOR HIGH TEMP. APPLICATION OF 1150 °C.

MAT. SPEC. AISI 310 SEAMLESS TUBE CUT,  
SOLUTION ANNEAL AND MIC.

ITEM NO.	DESCRIPTION	LENGTH	MATERIAL	UNIT	TOTAL WT. IN KGS.	STOCK/STAND.
7	REDUCER	15.18 75	0.1			
6	PIPE OD. 17.15, ID 6	250	15.18 75	0.1		
5	COVER	90	0.2	0.2		
4	PIPE - 34 O/DIA. X 2.95 THK	20	0.2	0.2		
3	PIPE - 33.4 O/DIA. X 3.38 TH.	2490	5.5	5.5	4.5	
2	SH-3X4 TH. ROUND #3	425	0.4	0.4		
1	PIPE O.D 17.15X3.2 THK	2560	2.6	2.6	2.1	
A	PIPE WITH STIFFENER	2287				

WORKS DESIGN TATA STEEL		TOTAL WT. 8.97.4 KGS.
SCALE 1:1 & 2:1	DEPT. BL FCE. A&B	DEVIATIONS FOR UNTOLERANCED DIMENSIONS: 15/102-65 (MEDIUM)
JOB No. 0593/95	SUB DWN. TAR INJECTION PLANT	SYMBOL SELECTED ROUGHNESS GRADE No. IN MICRONS. (Rz/100)
DRN. 21.7.95	DETAIL LANCE PIPE & ANNULAR PIPE FOR TAR INJECTION.	~ N12 50
CHKD. 21.7.95		▽ N11 25
DY.MGR. 21.7.95		▽ N9 6.3
MGR.		▽ N6 0.8
D.D.M/D.M		▽ N3 0.1
DRG. No. PA43783		REV.