

TILLARI W.S.SCHEME, DIST: SINDHUDURG

TECHNICAL DATA SHEET FOR DISMENTALLING JOINTS

(G.A.D) @ SASOLI HEAD WORKS

**Providing, erecting, commissioning & giving satisfactory test & trial of
Pumping Machinery at Sasoli Head works Pumping Station**

**MS Fabricated Dismantling Joint
(Sasoli PM Specs I. No. 8 P. No. 301 - 302)**

Sr.No.	Details	As per A/T	As per Contractor QAP & Drawings	Remarks
1]	Make	Non Mentioned	Anant Steel fabricators	
2]	Size	500 mm	500 mm	301 ✓
3]	Length	Not Specified	475 mm ³⁵⁰	✓
4]	IS to which flange drilling is done	Not Specified	IS-2062 ✓	✓
5]	Flange thickness	22 mm	28 mm ✓	301 ✓
6]	Squeezing length	Not Specified	20 mm ✓	302 ✓
7]	Test Pressure	35 Kg/Sqcm	78 Kg/Sqcm ✓	301 ✓
8]	Free Movement	20 mm	20 mm ✓	302 ✓
9]	Diameter of long bolts			
	i) at bottom of threads	Not Specified	26 mm	
	ii) at top of threads	Not Specified	26 mm	
10]	Scope of Third Party inspection	As per NIT & MJP Procedure	As per NIT & MJP Procedure	302 ✓

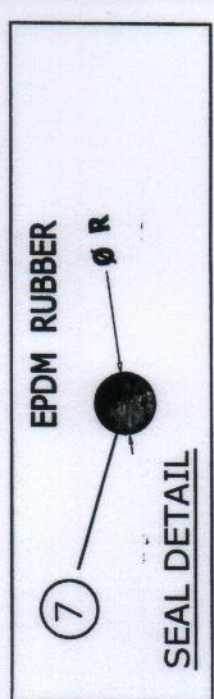
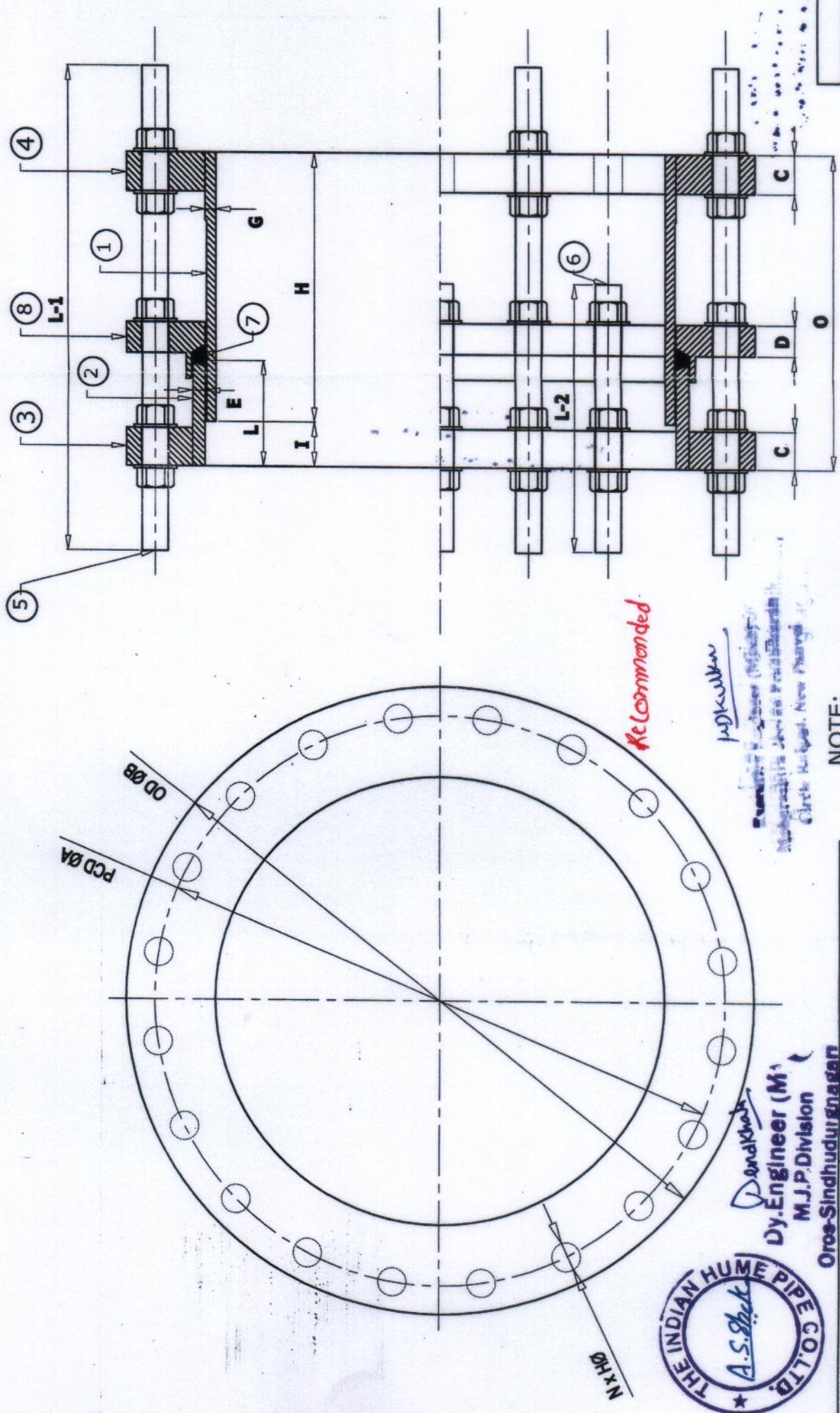


Dendekhal
Dy.Engineer (M)
M.J.P.Division
Oros-Sindhudurgnagar.

Pradikaran
Superintending Engineer (Mech.)
Maharashtra Jeevan Pradhikaran
CIDCO Bhavan, Navi Mumbai

Countersign
ul
Chief Engineer
Maharashtra Jeevan Pradhikaran
Thane

SR. NO.	NOMI SIZE & PRES	Ø A	Ø B	C	D	E	G	H	I	L	N	O	BOLT		LONG STUD		SHORT STUD		HOLE		Ø R	QTY
													SIZE	L1 X Q	L2 X Q	DIA						
1	200	295	340	24	18	8.5	7	160	35	70	8	195	M-20	310	4	180	4	22		9	3	
2	500 ✓	620	670	28	22	14	12	300	50	120	20	350	M-24	475	10	250	10	26		14	2 ✓	



APPROVED STAMP & SIGN

Third party inspection as per NTP procedure

Recommended

erstephoe

combray

Chief Engineer

Superintending Engineer (Mech.)

Maharashtra Jeevan Pradhikaran

CIDCO Bhavan, Navi Mumbai

BILL OF MATERIAL		PROJECTION SCALE		TITLE: -	
NO.	DESCRIPTION	QTY	MATERIAL	DRN.	SWAPNI.
8	SLIDING/THRUST FLANGE	1	IS-2062 E250 BR	CHD.	26-06-2020
7	PACKING RING (RUBBER 65 RC)	1	EPDM RUBBER	APPD.	26-06-2020
6	SHORT STUD,NUTS (M.S)	N/2	4.6 Gr.GI PLATED		
5	LONG STUD,NUTS (M.S)	N/2	4.9 Gr.GI PLATED		
4	FOLLOWER FLANGE	1	IS-2062 E250 BR		
3	ADAPTOR FLANGE	1	IS-2062 E250 BR		
2	PRESSING SHELL	1	IS-2062 E250 BR		
1	MAIN SHELL	1	IS-2062 E250 BR		

ANANT STEEL FABRICATORS
D-36,MDC AHMEDNAGAR 414111
PH.NO-0241-2778440/6602681
FAX NO-0241-2777440
EMAIL ID-sales@anantengg.com
Web Site-www.anantengg.com

DISMANTLING JOINT

ISSUED TO:-
SHRI MAHAVIR
ELECTROMECHANICAL
PVT.LTD.

DRG NO-ASF/001/DJ/20-21 (PN-16)

NOTE:

1) PRESSURE RATING PN-16.30

2) ALL HARDWARE 4.6 Gr.GI PLATED

3) FLANGE DRILLING AS PER YOUR JUPITER NRV.

4) MATERIAL OF CONSTRUCTION IS-2062 E250 BR.

5) PAINTING:- GREY EPOXY SPRAY PAINT.

TOLERANCE :-

FLANGE OD :- ±2MM.

FLANGE PCD :- ±1MM.

FLANGE THK :- ±2MM.


HOLE Ø :- ±1MM.

P.O.NO:-TWSS -006

P.O.DT:-27/06/2020.

PROJECT:- BEED WSS

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	M/s. ANANT HYDRO ENGINEERS LLP, D/37,1ST FLOOR MIDC AHMEDNAGAR-414 111	QUALITY ASSURANCE PLAN				Agency- THE INDIAN HUME PIPE LTD				
						PROJECT: -TILARI WSS				
		ITEM : M.S. Fab.Dismantling Joint				Client- EXECUTIVE ENGINEER MJP SINDHDURGNAGARI				
		QAP No-								
Page- 01 of 01	Drg.No-ASF/001 /DJ/20-21 (PN-16)	SIZE	500							
		PN	16				MFG- Anant Hydro Engineers LLP.			
		QTY	02 Nos							

SL.NO	COMPONENT & OPERATIONS	CHARACTERISTICS	CLASS	TYPE OF CHECK	QUANTUM OF CHECK	REFERENCE DOCUMENT	ACCEPTANCE NORMS	FORMAT OF RECORD	AGENCY			REMARKS
									M	C	N	
1	2	3	4	5	6	7	8	9	10	11	12	13
1 RAW MATERIAL												
1.1	HR COIL / PLATE	CHEMICAL COMPOSITION	MAJOR	CHEMICAL ANALYSIS LAB TEST	1 SAMPLE/ HEAT	IS:2062 E250 BR	IS:2062 E250 BR	MTC/LAB	R	R	R	Mill TC Valid for 3 Years & Lab TC Valid for 2 Years
		MECHANICAL PROPERTIES (T.S, YS, % ELONGATION)	MAJOR		1 SAMPLE/ HEAT	IS:2062 E250 BR	IS:2062 E250 BR	MTC/LAB	R	R	R	
1.2	WELDING CONSUMABLE	CHEMICAL COMPOSITION & MECHANICAL PROPERTIES	MAJOR	MTC	EACH BATCH	E-7018 for SAMW	IS-814:2004	MFG TC	R	R	R	Consumable TC Valid for 18 months
2 INPROCESS INSPECTION												
2.1	NDT TEST	DPT On Flange Weld Joint	MAJOR	DPT CHECK	100%	ASME SEC VII	ASME SEC VII	DPT REPORT	P	R	R	NDT TC valid for 12 Months
		UT On Flange Weld Joint	MAJOR	NDT (UT)	100%	ASME E-164	ASME E-164	UT REPORT	P	R	R	
3 FINAL INSPECTION												
3.1	FINISHED DISMANTLING JOINT	DIMENSION (OD, THICKNESS, LENGTH, ETC.)	MAJOR	MEASUREMENT	10%	AS PER P.O. & APPROVED DRAWING	AS PER P.O. & APPROVED DRAWING	FINAL INSPECTION REPORT	P	R	R	
3.2		HARDWARE	MINOR	MECH. & PHYSICAL TEST	100%	M.S.4.6/4.8 Gr GI Plated	M.S.4.6/4.8 Gr GI Plated	MFG TC / LAB TC	P	R	R	
3.3	PRODUCT TESTING	HYDROSTATIC TEST	CRITICAL	LEAK TEST FROM RUBBER RING	100 % Inter-Factory Test	1.5 Times at Pressure.i.e.15 Kg/Cm2 for PN 10	Visual Check for Leakage from Ruber & weld Joints	HYDROSTATIC TEST REPORT	P	R	R	counter signed 5 min Hold
3.4	FINISH PAINTING	SURFACE FINISH & PAINTING	MAJOR	Painting & Preservation	100%	Inside Black & Outide Grey Epoxy Paint		-	P	R	R	Chief Engineer



Demokha
Dy.Engineer (M.)
M.J.P.Division
Oros-Sindhudurgnagar.

Recommended

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Chief Engineer
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Thane

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