



**NOTE ON WELDING:-**

PREHEAT THE COMPONENTS TO A TEMPERATURE OF 250°C  
FILLER MATERIAL FOR WELDING : AWS 5.4 CLASS E312-16

(OR)

ARGON ARC WELDING, ELECTRODE - BAR OF TUNGSTON  
CONTAINING LANTHANUM 2TY 48-27-77 WITH FILLER WIRE  
2CB 18XMA GOST 2246 - 70

PROTECTIVE FINISH : PHOSPATED TO SPECIFICATION. JSS : 0465-01-1988  
CLASS-I (ACCELERATED) OIL FINISH.

DIMENSIONS ARE IN mm.  
UNTOLERATED DIMNS. AS PER IS : 2102 (MED)  
MARK DRAWING No.

PART NO.	DESCRIPTIONS	NO OFF	MATERIAL	TREATMENT	REMARKS
	SIGNATURE & DATE				SCALE 1:1
TRACED					STORE DRG.NO. 30P 0000
DRAWN	<i>[Signature]</i>				OPERATION NO.
CHECKED					
HOS/D&DO					
NDM/ OFFICER FOR MGL					
OFFICER/D&DO					
AMENDMENTS	SIG. & DATE				
	APPROVED ON. 28/10/2015				

SUB: **HOUSING LAUNCHER ASSEMBLY**  
 FOR: **40mm MGL**  
 DES. REF. NO.  
 DRG. No.: **30P 1100**  
 ORDNANCE FACTORY  
 TIRUCHIRAPPALLI-16.

SHEETS: 1  
 SHEET No.: 1