

SCOPE OF WORK FOR WELDING, STRESS RELIEVING, NDT TESTING  
AND RADIOGRAPHY OF TRIANGULAR STAY WELDING ASSY.

- Following components will be supplied by MPF :

Sr. No	Nomenclature	Drq. No.	Nos. per set	Total Nos. for 2 set
1	Tube	5 160 392	2	4
2	Yoke	4 071 919	1	2
3	Lug	4 071 920	2	4
4	Welding fixture	JP 2985	1	1

- TIG / MIG welding of components mentioned at sl. No. 1,2 & 3 as per drq. no : 4 071 918.
- TIG or MIG welding is to be carried out with ESAB make electrode grade mentioned on the drawing no. W/20-8
- Dye penetration test to be carried out stage wise on full length of weld.
- Radiography test to be carried out on full length of weld.
- After finishing of welding, structure to be stress relieved at the temperature of  $590^{\circ}\text{C} \pm 20^{\circ}\text{C}$  for appropriate time.
- To avoid distortions during stress relieving, necessary care to be taken by providing additional stiffeners.
- Dimensions and geometry of welding structure to be checked after stress relieving. If any irregularities, the same would be rectified.
- All relevant documents related to process carried out and inspection reports to be submitted along with welding assy.
- Welding fixture to be returned along with supply.
- Transportation will be arranged by MPF.
- The entire work will be carried out in the supervision of MPF staff.
- Final inspection will be carried at MPF on receipt. Rectification, if any will be carried out free of cost including to & fro transportation.
- Payment will be cleared against bill after job completion and final acceptance at MPF.

  
AVM/RC

  
HOS/MAN