

मिश्र धातु निगम लिमिटेड

(भारत सरकार का उपक्रम)

(मिनी रत्ना कम्पनी)

सूपर आलाय्स प्लांट

डाकघर : कंचनबाग, हैदराबाद - 500058. भारत

दूरभाषा : 040-24343861, 24340149, 24340136

फैक्स : 040-24340764



AN ISO 9001 : 2008 COMPANY

PURCHASE DEPARTMENT
CIN : U14292TG1973GOI001660

MISHRA DHATU NIGAM LIMITED

(Govt. of India Enterprise)

(MINI RATNA COMPANY)

SUPERALLOYS PLANT

P.O. Kanchanbagh, Hyderabad - 500 058. India

Phone : 040-24343861, 24340149, 24340136

Fax : 040-24340764

CORRIGENDUM

Date: 26/04/17

Subject: Uploading of Drawings -reg.

Ref. No.: MDNL/PUR/0470002/CG/ADVT/BPL/011/17-18 Dt. 20/04/2017

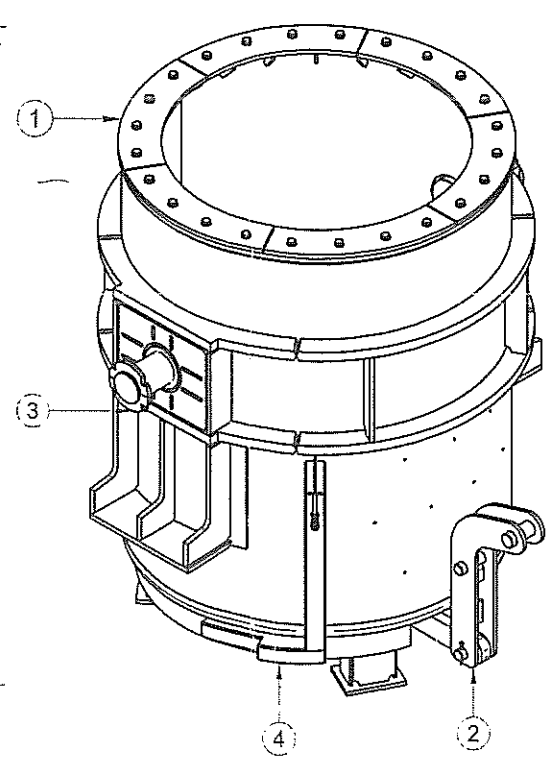
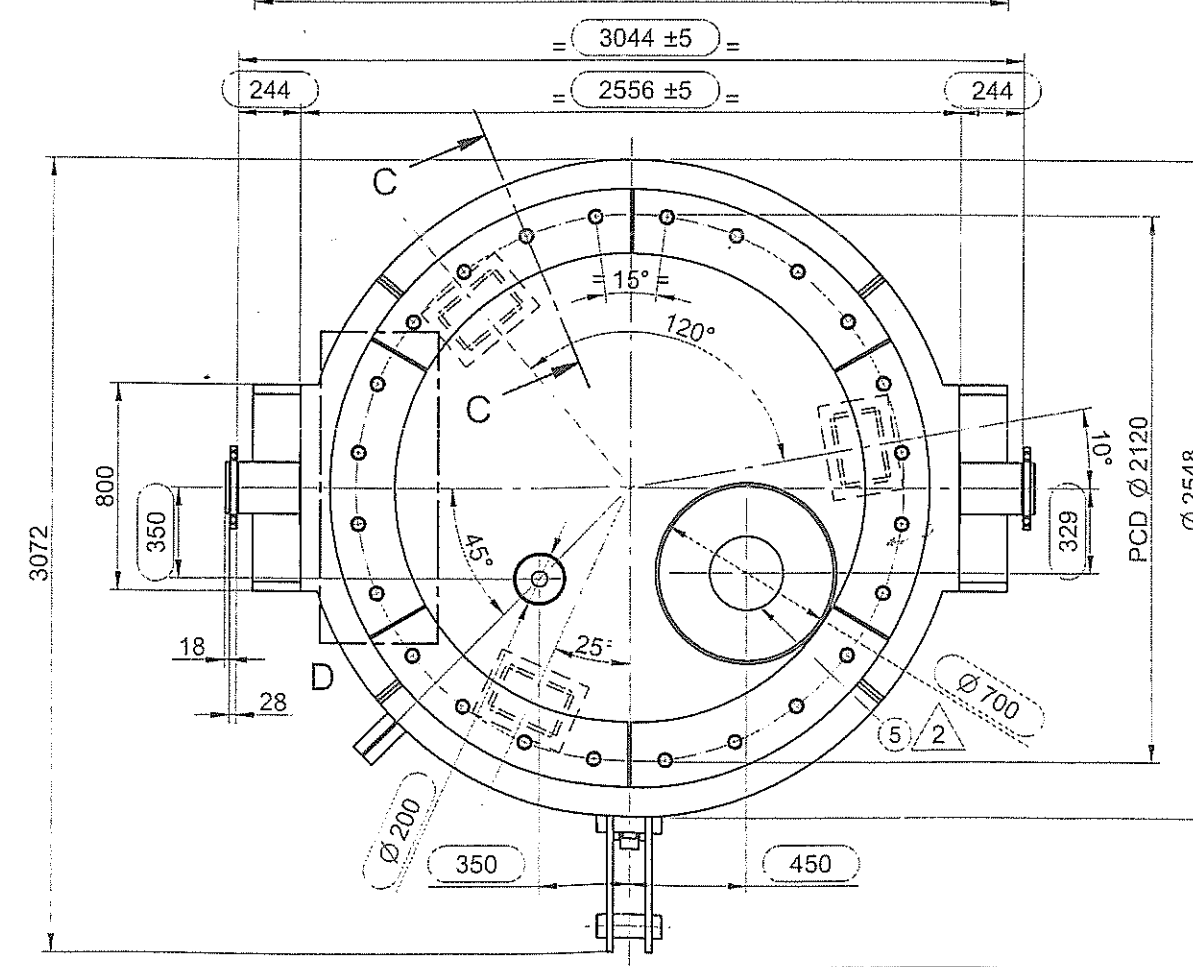
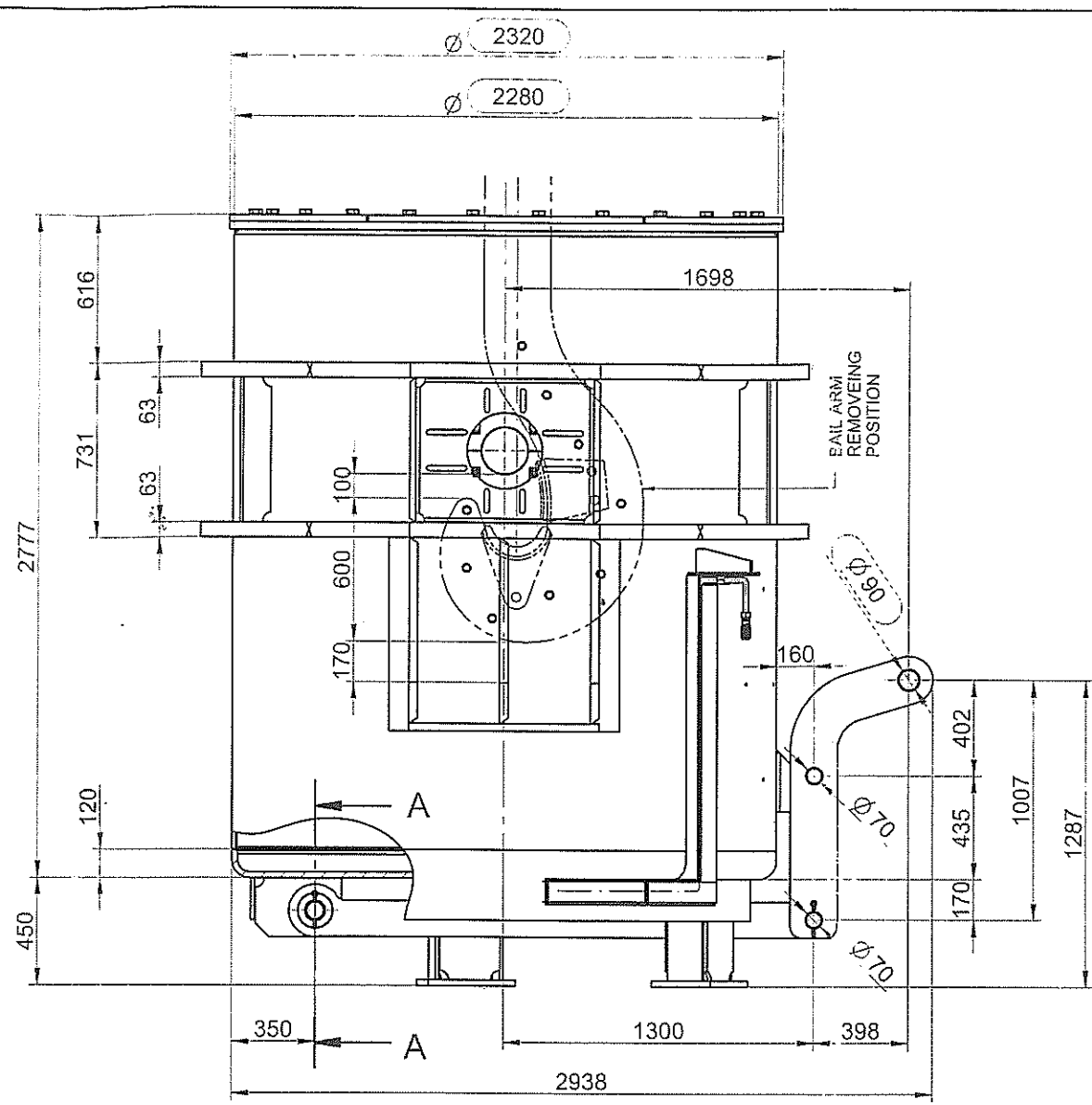
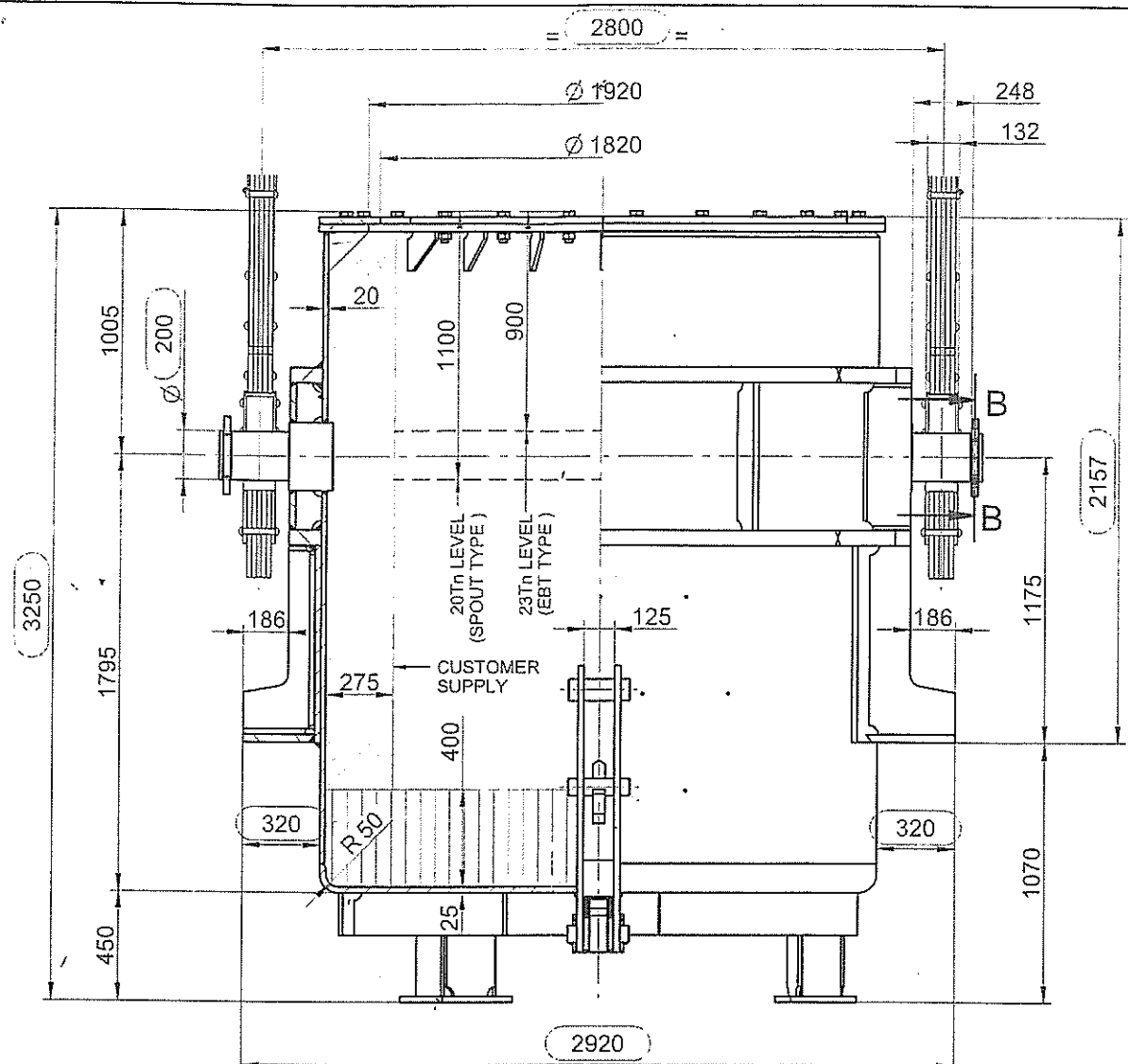
Tender Title: 23 Ton Capacity Bottom Pouring Ladle

This has reference to subject tender. The Corrigendum to the subject tender is hereby issued. All participating bidders are requested to note the changes in respect of the above subject tender.

Sl. No.	Existing Document Reference	Clarification
1	Drawings Not uploaded	Drawings uploaded- 3 Pages

It is advised that the above may please be taken into consideration while submitting your offer and other tender stipulations remains unchanged. You are advised to submit your offer accordingly.


ADDL. GENL. MANAGER
(PURCHASE)



44P001-10-00-A3
 sh 1 of 3

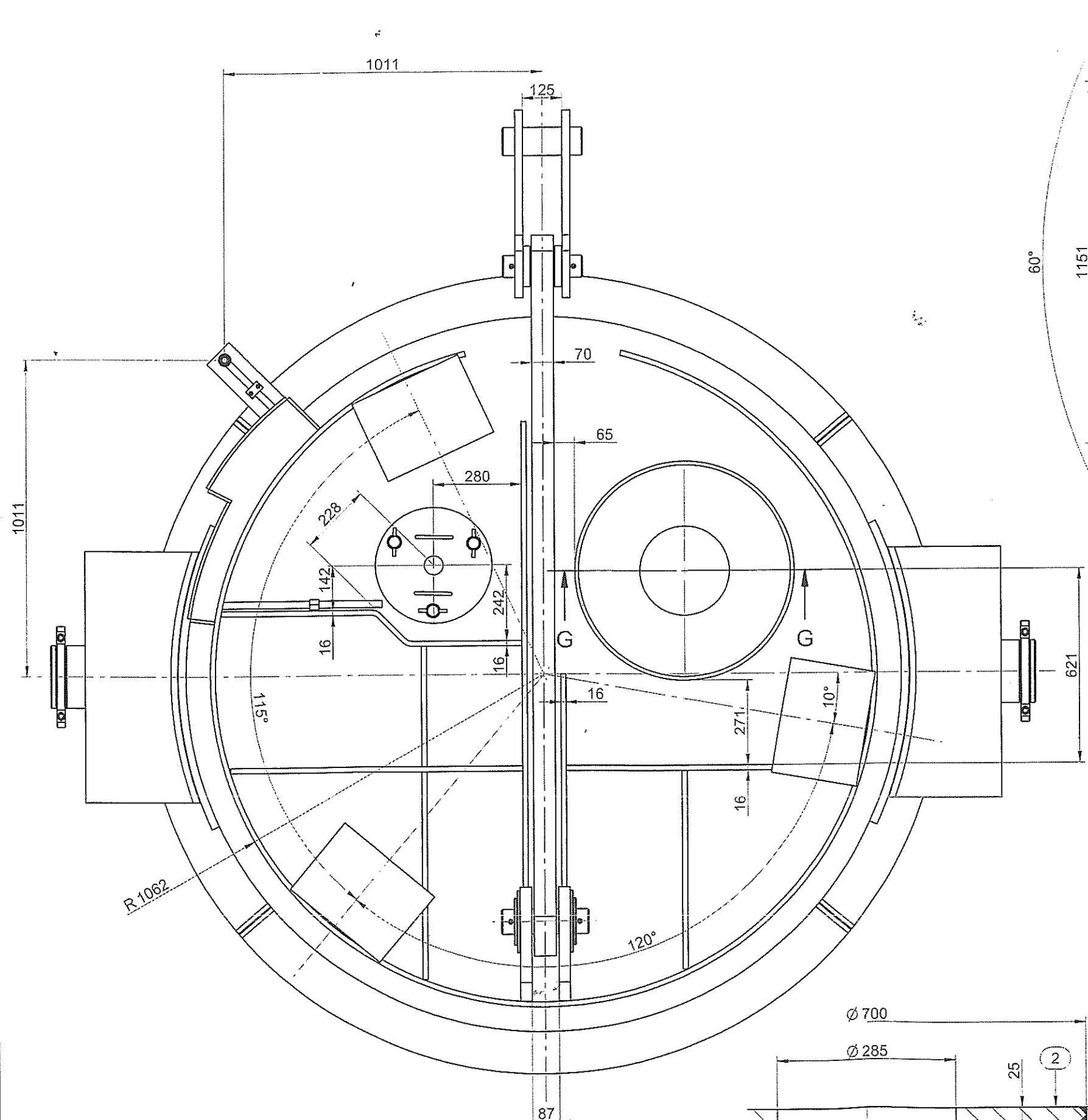
N°	Part N°	Description	Material	Q.	Weight (Kg)	Weight T (Kg)	Comments
5	4100.01.001	PLATE OF 700 x 700 x 25	IS 2002 Gr2	61.7	61.7		
4	4225.01.000	LADEL ARGON SUPPLY		1	52.6	52.6	
3	4200.01.000	HOOK SUPPORT ASSEMBLY		2	11.6	23.2	
2	4175.01.000	LADLE TILTING SYSTEM		1	346.6	346.6	
1	4125.01.000	LADLE BODY ASSEMBLY		1	7481.0	7481.0	
	4100.01.000	LADLE ASSEMBLY 23Tn			7965.1	7965.1	

STRUCTURE GENERAL TOLERANCES ACCORDING TO	STRUCTURE GENERAL TOLERANCES ACCORDING TO	INDEX	DATE	NAME	CUSTOMER INFORMATION	DRAWING NO.
ISO 13920	ISO 13920	02	25/02/2013	SUBH/S	SLIDE GATE DETAIL ADDED.	Page 1 of 3
		01	09/10/2012	SUPRIYA	BOM UPDATE & LADEL ARGON SUPPLY ADDED	
DESIGN GENERAL TOLERANCES ACCORDING TO	DESIGN GENERAL TOLERANCES ACCORDING TO	DRAWN	28/06/2012	SUBH/S		
		CHECKED	28/06/2012	V. Raghugatruni		
ISO 2768	ISO 2768	APPROVED	29/08/2012	L.Arroj		100173.4100.01.000, _R02

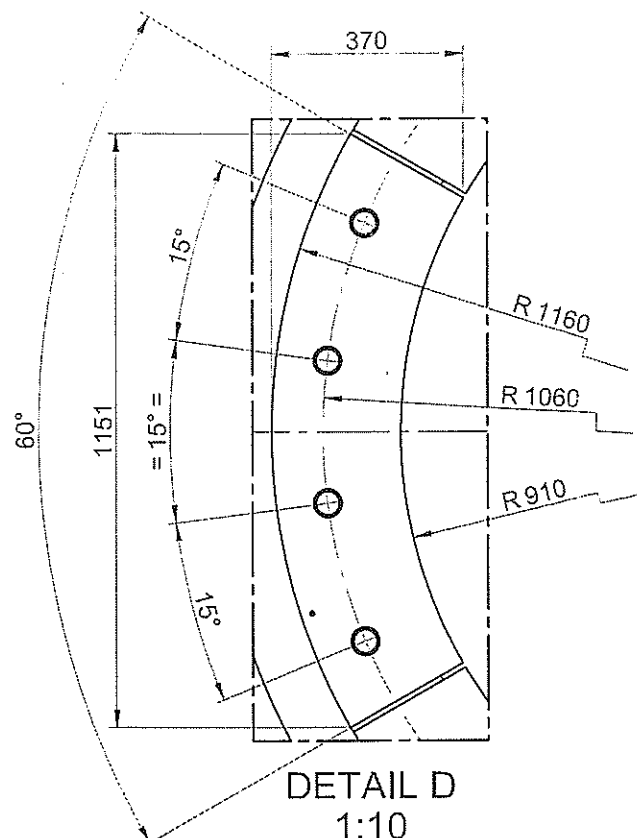
SCALE	TITLE	Customer
1:20	4100 - LADLE ASSEMBLY LADLE ASSEMBLY 23Tn ASSEMBLY	Mishra Dhatu Nigam

Sarralle India
 NH-8, P.O. MAHISREKHA, MOUZA - MADHAPUR
 P.S. ULUBERIA, DIST. HOWRAH-711303
 (W.B.) INDIA
 Tel: (0091) 33-26210830
 REPLACING TO

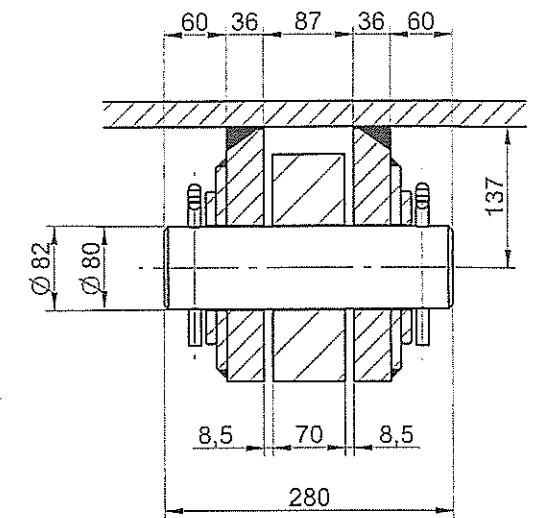
The non dimensioned weldings will be welded with a = 0.5 x minimum thickness. Control plan a/doc. 100173.4100.01.000-CF.



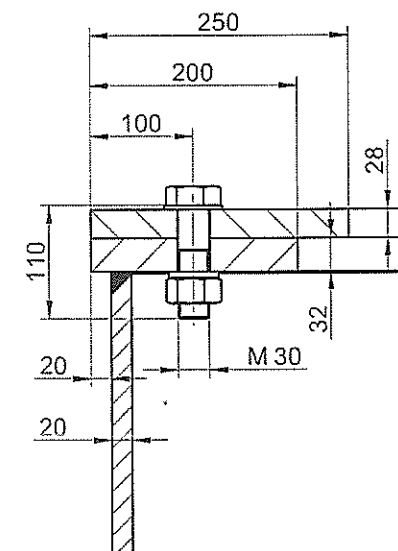
LADLE BOTTOM VIEW
1:10



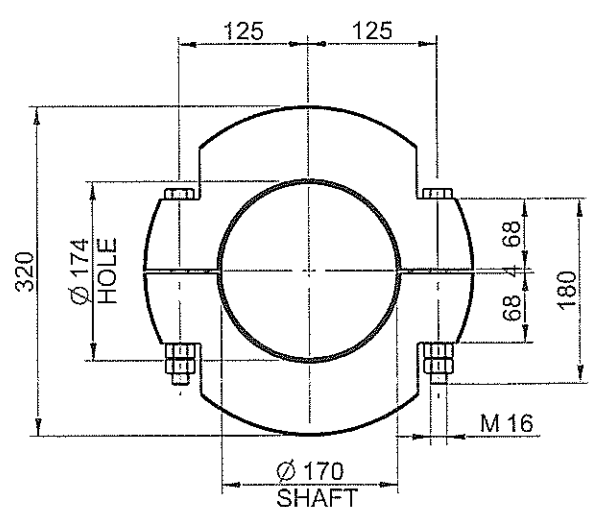
DETAIL D
1:10



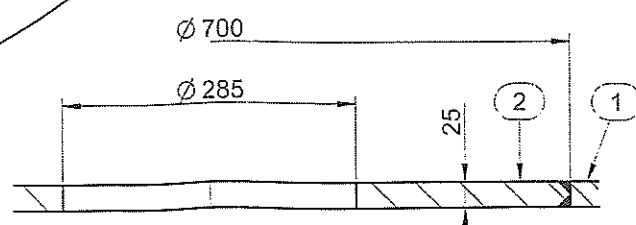
SECTION A-A
1:5



SECTION C-C
1:5



SECTION B-B
1:5



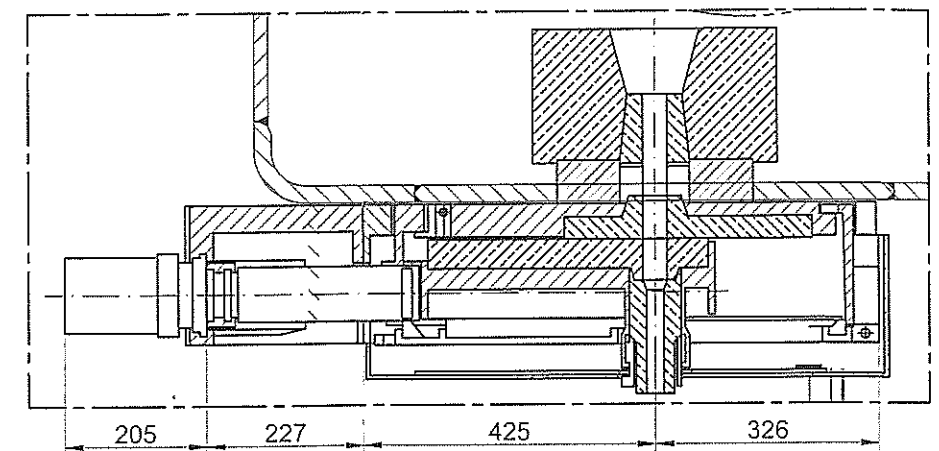
SECTION G-G
1:5

44P001-10-00-A3
sh 2 of 3

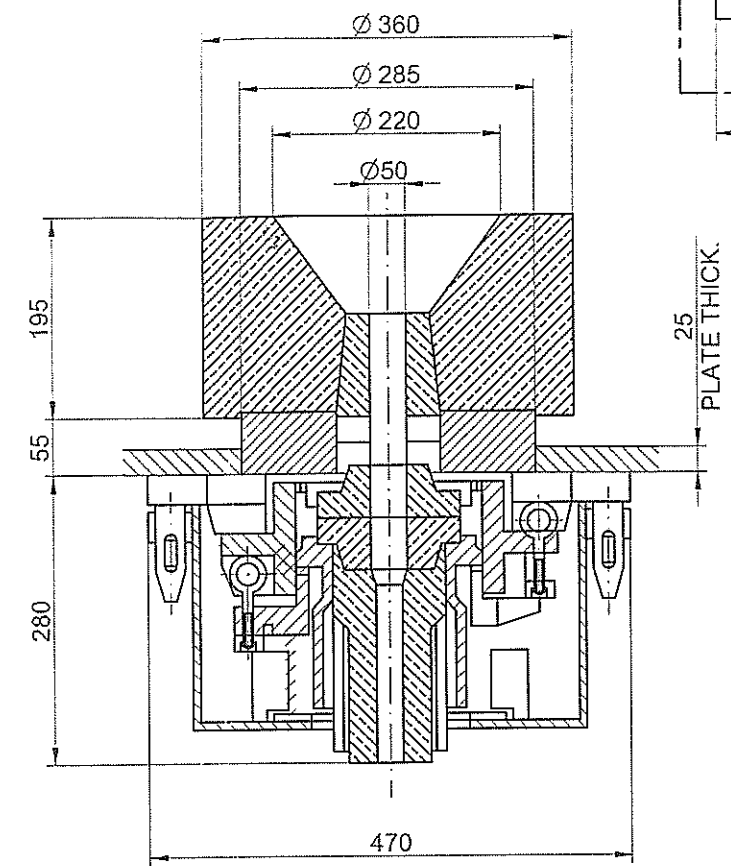
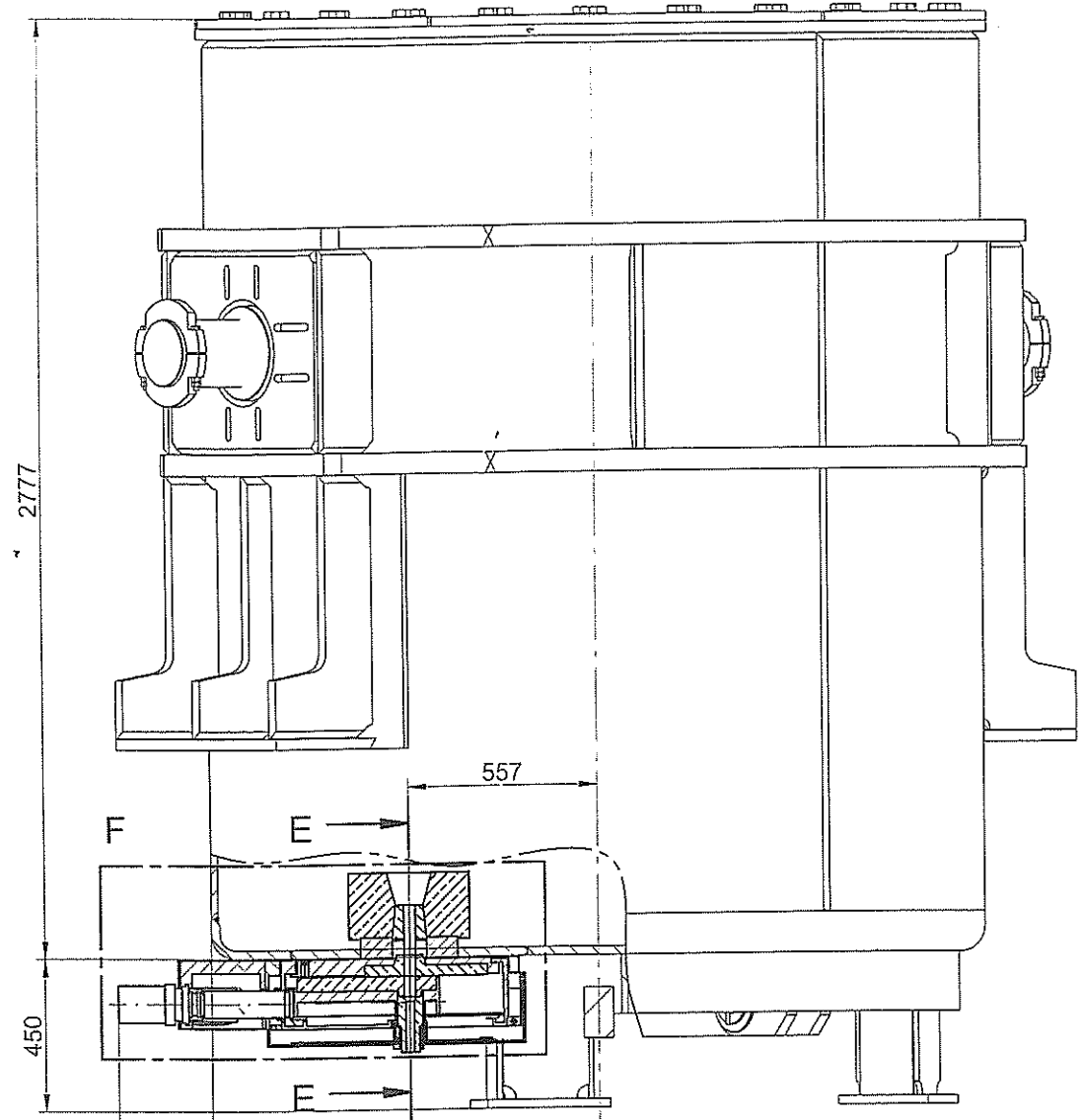
STRUCTURE GENERAL TOLERANCES ACCORDING TO	STRUCTURE GENERAL TOLERANCES ACCORDING TO				
ISO 13920	ISO 13920	02	25/02/2013	SUBHAS	SLIDE GATE DETAIL ADDED.
		01	09/10/2012	SUPRIYA	BOM UPDATE & LADEL ARGON SUPPLY ADDED
DESIGN GENERAL TOLERANCES ACCORDING TO	DESIGN GENERAL TOLERANCES ACCORDING TO	DRAWN	29/05/2012	SUBHAS	CUSTOMER INFORMATION
ISO 2768	ISO 2768	CHECKED	29/06/2012	V. Raghupatruni	
		APPROVED	29/06/2012	L Arregi	
SCALE	TITLE	DRAWING NO.			
1:20	4100 - LADLE ASSEMBLY LADLE ASSEMBLY 23Tn ASSEMBLY	100173.4100.01.000-2_R02			
Projection Rule DIN 34-1	Customer	Mishra Dhatu Nigam			
					Page 2 of 3 Tel. (0091)33-26210930 REPLACING TO

The non dimensioned weldings will be welded with a = 0.5 x minimum thickness. Control plan a/doc. I00173.4100.01.000-CF.

NOTE-
SLIDE GATE DETAIL (INTERMETAL ENGINEERS (I) PVT. LTD.) VENDER
DRG. NO.-IE-IM-021, IE-IM-103, IE-IM-104 & IE-IM-105



DETAIL F
1:7.5



SECTION E-E
1:5

FRAME & CENTERING RING WELDING DETAIL

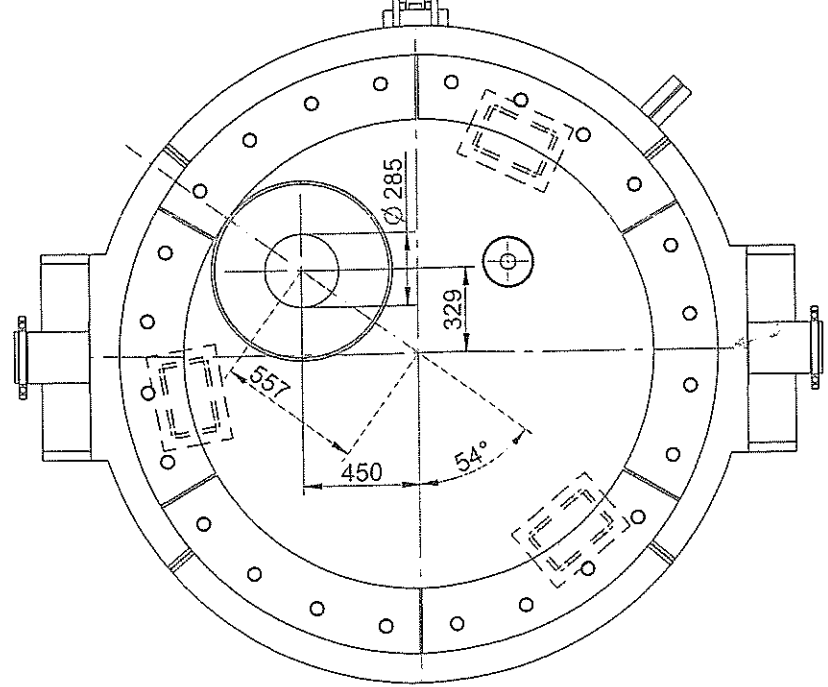
Centering ring	-0007
Jig	-0008

- CUT HOLE (ØA) IN LADLE BOTTOM, PREASSEMBLY OF FRAME, JIG & CENTERING RING.
- ALIGN AND TACK-WELD
- REMOVE JIG. PREHEAT LADLE BOTTOM AND CENTERING RING UPTO 150°-200°C. WELD CENTERING RING ALTERNATIVELY ONE LAYER INSIDE, ONE OUTSIDE.

MATERIALS
 FRAME : C-45
 CENTERING RING ST-37
 ELECTRODES :
 DEPENDING LADLE BOTTOM MATERIAL, e.o.
 - ELECTRODES FOR HIGH TENSILE STEELS (BOILERS)
 DIN 1913: KB XII RESPLY. kb
 ISO : E 515 B 20
 BS 1719 (1969) : E 616 H
 AWS : E 7018, RESPLY.
 E 9018 - G
 - AUSTENITIC ELECTRODES FOR HIGH STRENGTH CONNECTIONS
 DIN 8556 : E kb 188 Mn 620 +
 AWS : E 307 - 15

LADLE BOTTOM SHELL WELDING

- HOUSING**
 - THE 4 CONTACT SURFACES MAY BE OF THE THEORETICAL PLANE BY NOT MORE THAN 2mm CHECK, CLAMP HOUSING ON PLATE TABLE WITH GAUGES UNDER 3 CONTACT SURFACES, THEN CHECK DISTANCE ON FOURTH SURFACE.
 - INTERIOR WIDTH MUST NOT BE LESS THAN 0.5mm UNDER THE MANUFACTURING MINIMUM DIMENSION. CORRECT BY COLD ALIGNING OR RE-MACHINING.
 - INNER LENGTH MUST NOT BE MORE THAN 1mm LONGER THAN MANUFACTURING MAXIMUM DIMENSION. CORRECT BY COLD ALIGNING OR BUILT UP WELDING & RE-MACHINING.
- BOTTOM PLATE**
 - THE FLATNESS OF THE CONTACT SURFACE FOR THE REFRACTORY PLATE MUST BE CHECKED BY MEANS OF A STRAIGHT EDGE. FOR A ADMISSIBLE DEVIATIONS SEE TABLE. CORRECT BY RE-MACHINING



44P001-10-00-A3
sh 3 of 3

STRUCTURE GENERAL TOLERANCES ACCORDING TO ISO 13920	STRUCTURE GENERAL TOLERANCES ACCORDING TO ISO 13920	INDEX	DATE	NAME	CUSTOMER INFORMATION	DRAWING NO.	Page 3 of 3
		02	25/02/2013	SUBHAS	SLIDE GATE DETAIL ADDED.	100173.4100.01.000-3_R02	
		01	09/10/2012	SUPRIYA	BOM UPDATE & LADEL ARGON SUPPLY ADDED		
DESIGN GENERAL TOLERANCES ACCORDING TO ISO 2768	DESIGN GENERAL TOLERANCES ACCORDING TO ISO 2768	DRAWN	29/06/2012	SUBHAS			
		CHECKED	29/06/2012	V. Raghupatram			
		APPROVED	29/05/2012	L.Arregl			
SCALE	TITLE	4100 - LADLE ASSEMBLY					
1:20	LADLE ASSEMBLY 23Tn						
ASSEMBLY							
Protection Rule DIN 34-1	Customer	Mishra Dhatu Nigam					
<p>Sarralle India NH-6, P.O. MAHSREKHA, MOUZA - MADHAPUR P. S. ULUBERIA, DIST. HOWRAH-711303 (W.B.) INDIA Tel. (033) 333-25210830</p>							

The non dimensioned weldings will be welded with a = 0.5 x minimun thickness. Dimensions (XXXX) to be controled Control plan a/doc. 100173.4100.01.000-CF.