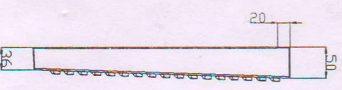
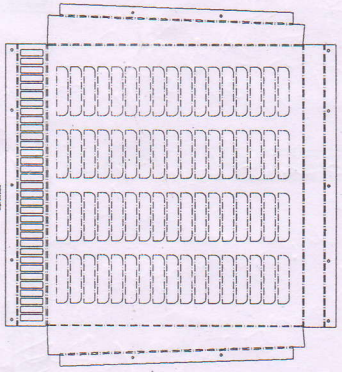
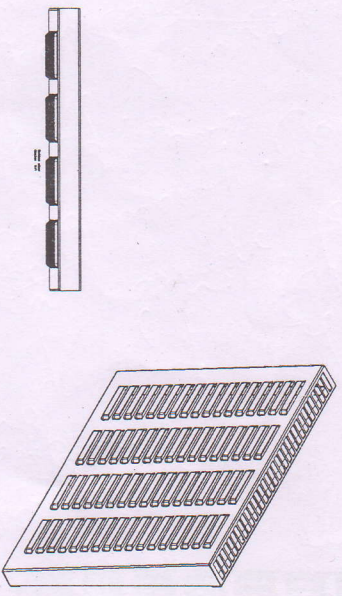
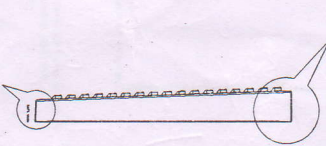
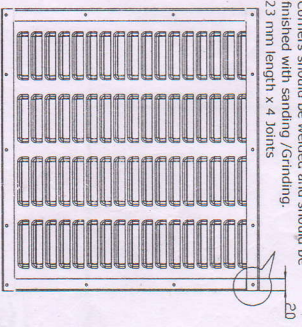


CODE	MATL	SPEC.	FIN.	SPEC.	SHEET--1 OF 1
ODC XXXXX	CRCA 1.5MM			ISSUE DATE
					MR

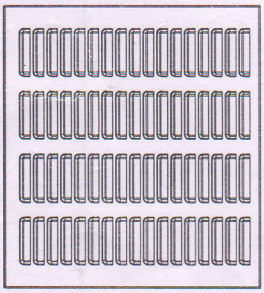


Corners should be welded and should be finished with sanding /Grinding.
23 mm length x 4 Joints



Corners should be welded and should be finished with sanding /Grinding.
53+23 = 76mm length x 2 Corners

Corners should be welded and should be finished with sanding /Grinding.
39+23 = 62mm length x 2 Corners



Note : Welding length allowance is added on actual joint length

FILTER COVER -WELD

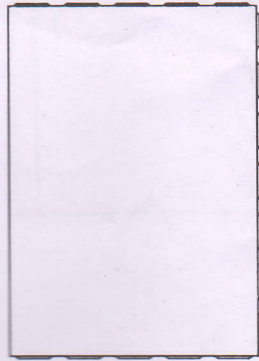
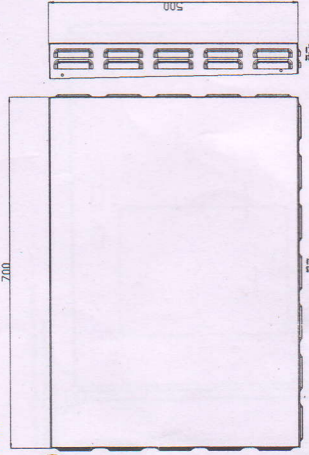
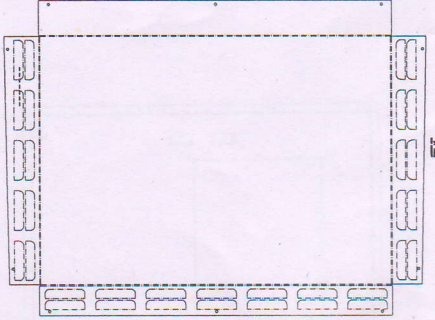
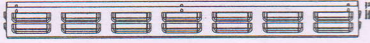
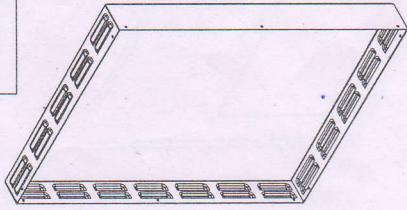
DRN	<i>[Signature]</i>	RSIL-EM	<i>[Signature]</i>	
TRD	<i>[Signature]</i>		<i>[Signature]</i>	
CHK'D	<i>[Signature]</i>			
ODC XXXXX		ITI LIMITED		A3
		BANGAL DRE -16		

REF:ODC-4G

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CODE	MATL.	SPEC.	FIN.	SPEC.	SHEET:-1 OF 1
ODC XXXXX	CRCA 1.5MM				ISSUE APP
					01 DATE MR



Corners should be welded and should be finished with sanding /Grinding.
2 x 75mm length

Corners should be welded and should be finished with sanding /Grinding.
2 x 65mm length

Note : Welding length allowance is added on actual joint length

REF: ODC 4G

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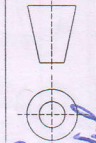
U.D:

DRN
TRD.
CHKD

APPROVED
Chamara

ODC XXXXX

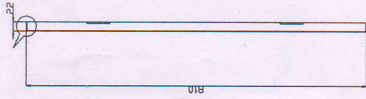
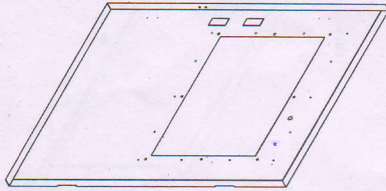
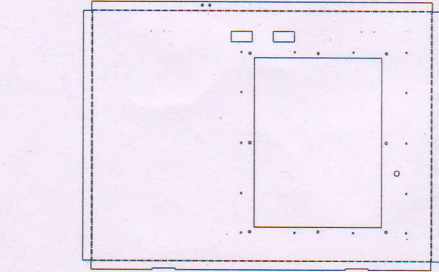
ITI LIMITED
BANGALORE - 16



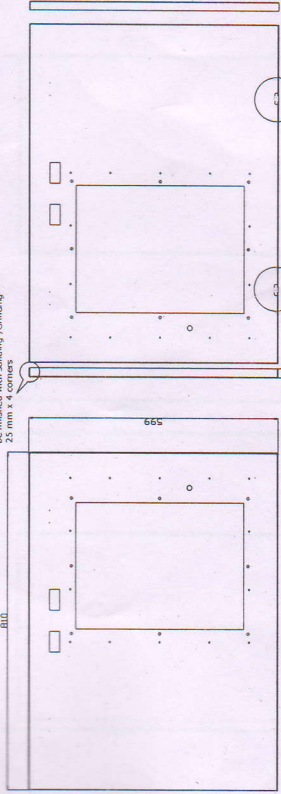
TOP COVER /CANOPY - WELD

A3

CODE	MATL.	SPEC.	FIN.	SPEC.	SHEET-1 OF 1	
					ISSUE	APP
ODC XXXXX	CRCA 1.5MM	-----			01	DATE
						MR



All 4 corners should be welded and should be finished with sanding /Grinding to 1mm x 45 degree



Note: Welding length allowance is added on actual joint length

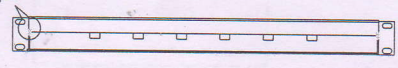
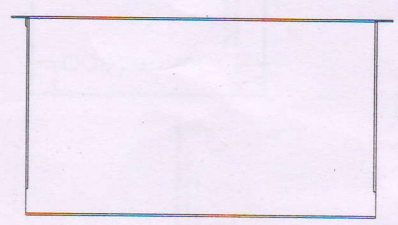
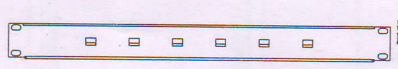
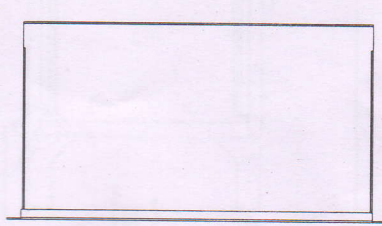
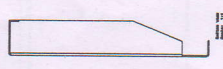
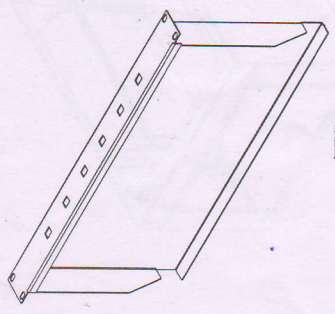
REF: ODC 4G

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DRN	<i>RITIL EM</i>	ODC XXXXX	ITT LIMITED BANGALORE-16	A3
TRD.	<i>Ram Lal</i>			
CHKD	<i>Ram Lal</i>			
FRONT DOOR - WELD				

CODE	MATL.	SPEC.	FIN.	SPEC.	SHEET--1 OF 1
ODC XXXXX	CRCA 1.5MM				ISSUE
					APP
					MR
					DATE



Note : Welding length allowance is added on actual joint length

REF: ODC 4G
 W.D:
 U.D:

ODF

ODC XXXXX

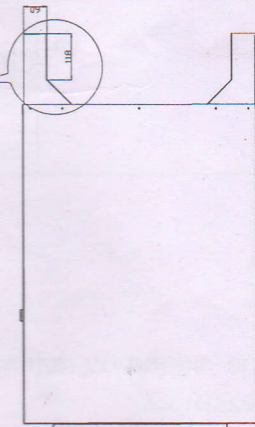
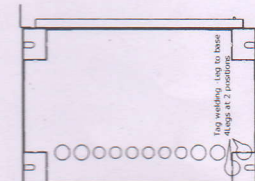
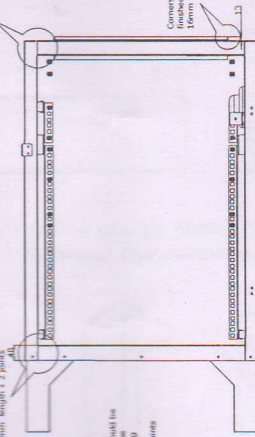
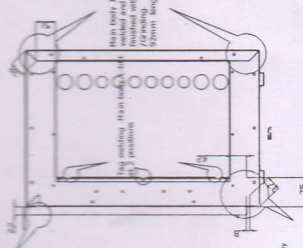
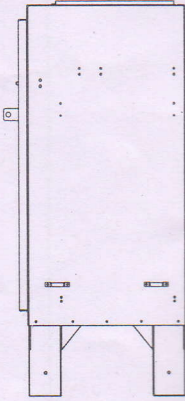
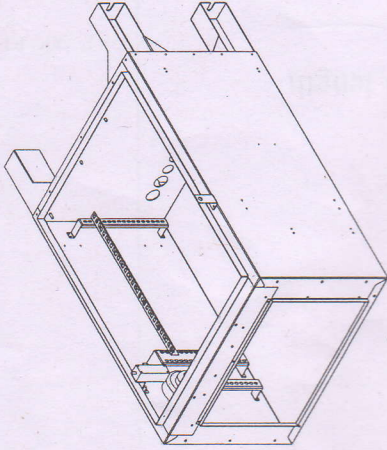
ITI LIMITED
BANGALORE - 16

A3

DRN: *[Signature]*
 TRD: *[Signature]*
 CHKD: *[Signature]*

RITILEN
[Signature]

CODE	MATL	SPEC.	FIN.	SPEC.	SHEET-1 OF 1
ODC XXXXX	CRCA 1.5 & 2.0mm		-----	-----	ISSUE
					APP
					MR
					01 DATE



Leg corner and leg to base assembly joints should be welded and should be finished with sanding/Grinding. 180 mm length x 4 legs (Corner Bracket Assembly)

Main body bracket top to main body assembly welding joints should be welded and should be finished with sanding/Grinding. 45mm length x 2 joints

Main body bracket bottom to main body assembly welding joints should be welded and should be finished with sanding/Grinding. 45mm length x 2 joints

Main body joints should be welded and should be finished with sanding/Grinding. 92mm length x 2 joints

Corners should be welded and should be finished with sanding/Grinding. 45mm length x 4 corners

Leg welding, leg to base 4legs at 2 positions

Main body bracket bottom to main body assembly welding joints should be welded and should be finished with sanding/Grinding. 17mm length x 2 joints

REF: ODC-4G

W.D:

U.D:

Main body assembly welding		DRN	RJILEM		ITI LIMITED BANGALORE -16 A3
		TRD.	<i>Chandra</i>		
		CHKD	<i>Chandra</i>		
			ASC XXXXX		

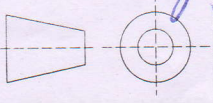
Note: Welding length allowance is added on actual joint length

LEG - WELD

ODC xxxxxx

ITL LIMITED
BANGALORE-16
A3

CHKD.	<i>[Signature]</i>	DRN.	<i>[Signature]</i>
TRD.	<i>[Signature]</i>		
			RIDIL EM

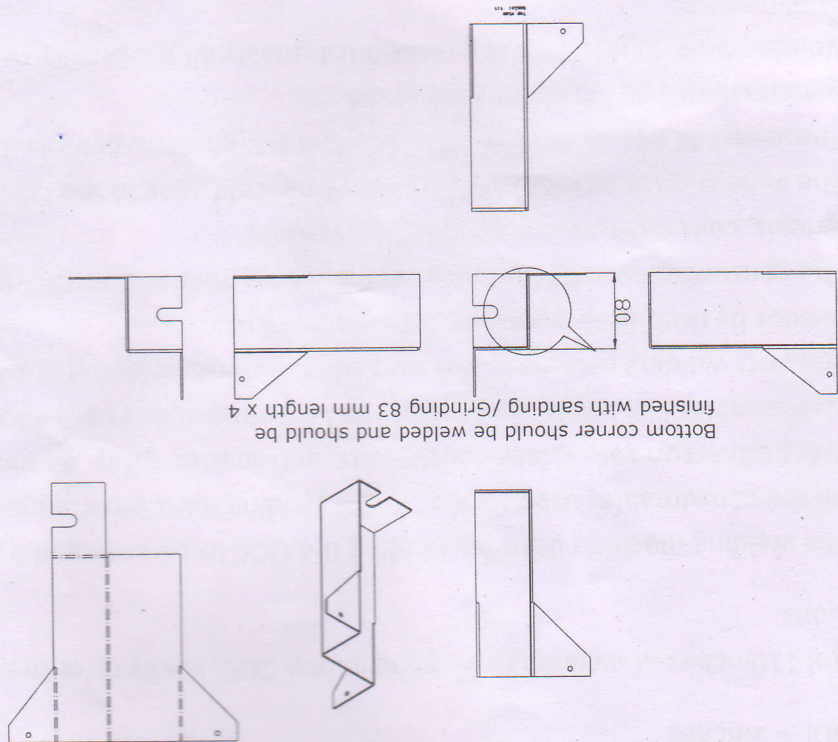


Note :
legs 4 numbers per ODC assembly
Welding length allowance is added on actual joint length

REF: ODC 4G

U.D:

W.D:



CODE	MATL.	SPEC.	FIN.	SPEC.	-----
ODC XXXXXX	CRCA 2 MM				
		ISSUE	DATE	MR	
		APP			
		SHEET: -1 OF 1			

Scope of work :

1. Welding of complete outdoor cabinet(ODC) using CO2/MAG welding machine.
2. Details of weld dimensions in each part of ODC is as follows :
- a. Top Cover – 11inches
- b. Front door - 4inches
- c. Hood – 15inches
- d. Legs(4) – 13inches
- e. Main body – 65inches
- f. ODF – 2inches

In total 110inches of welding to be done in one ODC, kindly refer the drawing for weld positions.

3. The welding machine used for welding the ODC to be arranged by the vendor.
4. All the consumables used for CO2/MAG welding must be arranged by vendor i.e copper coil, CO2/Argon gas, Safety equipments, anti spatter spray. All the welding machine consumables like torch, liner, nozzle to be arranged by the vendor.
5. The post welding processes like sandering, buffing, chipping must be carried out by vendor by their own manpower and equipment.
6. The consumables used for angle sandering machine like sandering wheel, buffing wheels, coils must be arranged by the vendor.
7. The vendor must ensure clean spatter free weld zone in the ODC.
8. There should not be any porosity, crack, misalignment, pinhole, burn, undercut, excess penetration, overlap etc in weld areas.
9. Vendor must ensure that the racks must qualify all the quality requirements listed by ITI quality team.
10. The power supply required to carry out welding and post welding process will be provided by ITI.
11. The required insurance or ESI facilities are provided to the workers working inside ITI premises by the vendor only.
12. ITI will not be responsible for any injury, harm occurred to the workers while working at ITI premises.
13. The vendor must bear the travel, food and stay expenses of the workers.
14. The movement of racks, sub assemblies must be done safely without any dents/damage to the racks.
15. Movement of any material, machine, accessories in/outside the factory premises must be done as per ITI material movement procedures.

Savitri Kumbhar
PM-FAB

8/27/14
Kumbhar