

3

2

1

DESIGN CRITERION

INSTRUCTIONS FOR EMBEDDED ARTICLES MANUFACTURING

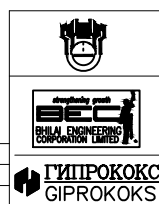
Bolts shall be manufactured with metric thread with nuts and washers. Threaded part of the bolt shall be protected from damages. The quality of welded connections of embeded articles Conforms to all normative requirements and shall be warranted by the Customer. The width of welded joints. except otherwise stated is the following

- a) at welding plates to each other – on the less thickness of welded elements
- b) at welding body of round section to plate – half of the diameter of welded body. but not less than 8mm (see unit "B" on the present drawing)
 - Outer surface of embedded articles shall be marked with indelible paint.
 - Instruction for embedded articles painting shall be as DIN 55928(Part 4).
 - Embedded articles shall be coated with primer loyer for protection against corrosion while storing.
- Covered electrodes for electric arc welding should conform to Iranian standard.

Materials

- rolled metal 5 to 20 mm thick – As per EN10029
- Rolled metal up to 20 mm thick – steel grade E-250A as per Indion standard IS:2062 (assortment IS:1730-1989)
- Equal, unequal angle bars, l-beams, channels as per European standard EN 17100.
- Steel pipes – Material as EN 10029
- Foundation bolts should conform to ESCo plant standard
- Nuts should conform to Iranian standard.
- Washers should conform to Iranian standard.
- Reinforcing rods:
- ☐– Periodical profile reinforcement bars grade Fe415 as per DIN 1045

REV. No	DATE	DESCRIPTION	REV.BY	CHK.BY



E.S.C.o.
Esfahan Steel Company

EMPLOYER
BHILAI ENGINEERING
CORPORATION LIMITED

CONTRACTOR
SE"GIPROKOKS"

SUBMITTED FOR		APPROVAL	✓	REFERENCE	
DSGN	DSGN	DSG.DATE	Coke Oven NO.2 Reconstruction DESIGN CRITERIA BUTTRESS WALL RECONSTRUCTION		
DRWN	BK	02-09-23			
CHECKED	DS	07-09-23			
APPROVED		APPD.DATE			
DRG. SIZE	A4	SCALE: - NTS	SHEET- 3 of 3	REV. - 0	
CONTR. DRG. NO.:					
PROJECT DRG. NO.- D-ES-CM-CO-11-18-CV-113-I-0					

3

2

1