

X 10.10.04 JM

**MINUTES OF MEETING HELD AT BASL, UNIT - II, NANJANGUD,  
BETWEEN M/s BASL & M/s BHEL HYDERABAD, PSSR ON 02.11.04**

**Members present.**

M/s BASL

Mr. R. Ram Gopal

Mr. AM. Sengottaiyyan.

Mr. M. Jayadhara Rao

Mr. KB. Ranga Swamy

Mr. RN. Swamy

Mr. CV Hari Prasad

M/s BHEL PSSR

Mr. PN. Krishna

Mr. RS. Nair

Mr. AS. Raghavendrachar

(27.10.04 to 30.10.04)

M/s BHEL, Hyd.

Mr. S. Sundara Rao

(Up to 19.10.04)

Mr. Md. Babu.

Mr. K. Kesavalu

1. M/s BHEL Hyderabad engineers reached site on 05.10.04 and taken up the 20 MW turbine steam leakage job.
2. In the process the following jobs were carried out.
  - a) Total turbine opened.
  - b) Scrapping on parting plane carried out and blue matching done. Got contact surface up to 90%. With out tightening of parting plane bolts checked with feeler gauge and 0.03mm size could not be inserted.
  - c) Rotor centering work carried out. Readings enclosed.
  - d) After through inspection and cleaning of bottom, top casing and rotor turbine Boxed up.
  - e) After turbine box up, turbine aligned with gear box. Alignment readings enclosed.
  - f) Both the balancing pipes cut, re welded and assembled with new gaskets.
  - g) Control oil supply flexible hose pipe of LP servomotor replaced with new one.
  - h) Front oil gland aluminum fins replaced.
  - i) Oil flushing carried out for 24 hrs.
  - j) Turbine rolled on 27.10.04
3. TG rolled and tried to load up to 20 MW. As the steam flow was not going beyond 90 TPH, throttle valve adjusted locally and loaded up to 19.4MW.
4. TG rear bearing temperature observed going up to 90deg.
5. Leakages checked and found leakages at the following places.
  - a) Turbine rear, right side from guide pin hole and from jack bolts.

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- b) Turbine rear, left side from the hole of the parting plane tightening bolt.
- c) Turbine front, left side from the studs
- d) Turbine middle, right side from the parting plane.
6. Load through of test carried out on 29.10.04. During this TG tripped on over speed (6149rpm), with trip oil pressure very low indication.
7. On 01.11.04 casing bolts re tightened. Leakages on turbine rear side attended by putting plug for guide pin bolt, and the hole in the stud is seal welded.
8. Regarding the TG tripping during load throw test BHEL site incharge had taken up the matter with their HO at chennai. As per the suggestions settings in wood wards governor changed.
9. TG rolled on 01.11.04 loaded up to 19.3 MW and load throw test carried out. TG tripped with HP actuator fault.
10. Steam leakages checked and found minor leakages at the following places.
  - a) Turbine front, left side from the studs
  - b) Turbine middle, right side from the parting plane.
11. It was observed a minor droplets of oil leak @ 1 drop / min near front oil gland.
12. M/s BHEL Hyderabad engineers are leaving site on 02.11.04. They informed that they will furnish an action plan for rectifying the persisting steam leak after consulting their engineering department.
13. M/s BHEL informed that TG set can be run continuously up to 14 MW of load with temporary insulation at present condition.
14. M/s BHEL site incharge confirmed, regarding the governor adjustment, matter will be taken up with their HO at chennai and the same will be resolved at the earliest.

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