

	CORPORATE PURCHASING SPECIFICATION			AA11301 Rev No.04 PREFACE SHEET		
	PIG IRON GENERAL PURPOSE FOR INTERNAL USE ONLY REMOVE THIS PREFACE BEFORE ISSUE TO SUPPLIERS					
	Equivalent/Comparable Standards: 1) INDIAN : IS 13502 – 1992					
User Plants and Replaced Plant Specifications/References:						
Revisions: As per clause no. 27.6 of MOM of MRC-FN			APPROVED: INTERPLANT MATERIAL RATIONALISATION COMMITTEE – MRC(FN)			
Rev No.04	Amd No.	Reaffirmed	Prepared	Issued	Dt. of 1 st Issue	
Dt:19-08-2015	Dt:	Year:	HEP, Bhopal	Corp.R&D	July, 1981	

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	CORPORATE PURCHASING SPECIFICATION	AA11301
		Rev No. 04
		PAGE 1 of 2

PIG IRON GENERAL PURPOSE

1 GENERAL:

This specification governs the quality requirements of foundry grade Pig Iron for General purpose.

2 APPLICATION:

Used for the production of ordinary and high duty irons.

3 COMPLIANCE WITH NATIONAL STANDARDS:

This specification is generally based on the following national standard and also meet the requirements of this specification.

IS 13502 – 1992 : PIG IRON.

4 SIZE AND SHAPE:

The mass of pig shall be either 45 kg (approx.) having two notches or 22.5 kg (approx.) having one notch subject to mutual agreement between the purchaser and the manufacturer.

5 GENERAL APPEARANCE:

The material shall be clean and free from excessive sand or Kish.

6 CHEMICAL COMPOSITION:

Material when tested in accordance with IS: 12308 shall conform to the following:

Grade	Designation	% Si	%Mn	%S	%P
Grade 1	PG Si 2 Mn 3P12	0.75 to 1.25	0.5 to 1.0	0.06 max	0.08 to 0.12
Grade 2	PG Si 2 Mn 1P40	0.75 to 1.25	< 0.50	0.06 max	0.40 max
Grade 3	PG Si 1 Mn 1P40	< 0.75	< 0.50	0.06 max	0.40 max
Grade 4	PG Si 3 Mn 3P40	1.25 to 1.75	0.50 to 1.0	0.06 max	0.40 max

7 SAMPLING:

Three representative samples shall be drawn from each consignment of 25 MT or part there off and a composite sample shall be made for testing and approval.

8 INSPECTION AT SUPPLIER'S WORKS:

BHEL reserves the right to inspect the material at site before dispatch. The supplier shall intimate in advance enclosing a copy of test certificate of the material offered for inspection.

If the material received is not found suitable to our requirements, it shall be replaced free of charge by the supplier. Final tests shall be carried out at BHEL and material will be accepted or rejected based on this result. For any deviation demanded by the supplier from the specification, prior approval of BHEL must be obtained in writing.

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9 TEST CERTIFICATES:

Unless otherwise specified, three copies of test certificates shall be supplied along with each consignment.

In addition the supplier shall ensure to send one copy of test certificates along with the dispatch documents to facilitate quick change of the material.

The test certificates shall bear the followings information:

- AA11301, Rev. No.04: PIG IRON GENERAL PURPOSE
- BHEL Order No.
- Manufacturer's/Supplier's Name.
- Trade mark, if any.
- Consignment /Identification No.
- Grade of pig iron
- Test results of chemical analysis.

10 PACKING AND MARKING:

The material shall be supplied in truck/wagon loads in loose condition but shall be protected from moisture, rain during transit.

- AA11301: PIG IRON GENERAL PURPOSE
- BHEL Order No.
- Manufacturer's/Supplier's Name.
- Heat No.
- Consignment /Identification No.
- Weight

11 REFERRED STANDARDS (Latest publications including amendments):

- 1) IS: 12308