



## CORPORATE PURCHASING SPECIFICATION

AA54406

Rev No. 02

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### ACETYLENE GAS - DISSOLVED

#### 1 GENERAL

This specification governs the quality requirements of Acetylene Gas, dissolved.

#### 2 APPLICATION

Used in gas welding, flame cutting of metals, etc.

#### 3 COMPLIANCE WITH NATIONAL STANDARDS

The material shall comply with the requirements of the following national standard and also meet the requirements of this specification.

IS 308-1988: Dissolved Acetylene gas

#### 4 TEST SAMPLES

One gas cylinder from each consignment shall be taken for testing and approval.

#### 5 PROPERTIES

When tested as per Appendix A-3 of IS 308, the total impurities insoluble in acetone shall not be more than 4% by volume.

#### 6 TYPE TEST

##### 6.1 Sulphur Compounds (as $H_2S$ ) – (Appendix A-4 of IS 308)

0.02%, max. by volume.

##### 6.2 Phosphorous Compounds (as $pH_3$ ) (Appendix A-5 of IS 308)

0.01%, max. by volume.

##### 6.3 Moisture (Appendix A-6 of IS 308)

0.25%, max. by mass.

#### Revisions:

As per clause 44.5.a) of MOM of MRC-CPO+NM

#### APPROVED:

INTERPLANT MATERIAL RATIONALISATION  
COMMITTEE – MRC(CPO+NM)

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Amd No.

Reaffirmed

Prepared  
HPEP, Hyderabad

Issued  
Corp.R&D

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01-08-1988

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**7 TEST CERTIFICATES**

Three copies of test certificates shall be supplied along with each consignment, giving the following information:

In addition, the supplier shall ensure to enclose one copy of the test certificate along with the despatch documents to facilitate quick clearance of the material.

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BHEL Order No.

Batch / Lot No.

Supplier's/ Manufacturer's Name & Grade

Test results of clause 5

**8 PACKING & MARKING**

The gas shall be supplied compressed in cylinders. The design of cylinders, pressure of gas in cylinders, packing, marking, painting, labelling and transport of cylinders shall be in accordance with the 'Gas Cylinder Rules - 1940' of the Government of India with such modifications as may be ordered from time to time by the Chief Inspector of Explosives, Government of India or other duly constituted authority.

The cylinders shall also be marked with the BIS certification mark.

The cylinder shall be painted with Maroon colour (Colour code No 541 of IS 5).

All cylinders shall be securely tagged with the following information:

AA54406: ACETYLENE GAS - DISSOLVED

BHEL Order No.

Supplier's / Manufacturer's Name & Grade

No. of Cylinders

Net and Gross weight

**9 ENVIRONMENTAL REQUIREMENTS**

The supplier shall furnish Material Safety Data Sheet (MSDS) covering all information relating to human safety and environmental impacts of the hazardous materials particularly during their transportation, storage, handling and disposal along with each supply.

Each container shall be marked with corresponding symbol and minimum worded cautionary notice for flammable / corrosive / toxic / harmful / irritant and oxidizing etc. as applicable.

**10 REFERRED STANDARDS (Latest Publications Including Amendments)**

- 1) IS 5