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संस्थान क्रय विनिर्देश ( सी.एफ.एफ.पी - हरिद्वार)

FF77190 Rev 03

पृष्ठ का  
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**PLANT PURCHASE SPECIFICATION**  
(CFFP - HARDWAR)

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**6.0 Mechanical Properties**

The following mechanical properties shall be obtained after stress relieving at 600 ± 10° C

- Yield Strength (0.2 % offset) - 550 Mpa min.
- Tensile Strength - 760 Mpa min.
- % Elongation - 15.0 min.
- Charpy V notch (ISO-V) - 50.0 J avg. of 3 specimens at + 20° C  
45.0 J avg. of 3 specimens at 0° C

**7.0 Selection of Test Samples**

The selection of test samples for acceptance for chemical composition and mechanical properties shall be done as follows

- 7.1 Electrodes shall be drawn from one or more than one packet from each batch no. for carrying out chemical and mechanical properties.
- 7.2 Test Sample for chemical analysis shall be made according to ASME Sec. II (c).
- 7.3 Electrode shall be deposited on carbon steel plates for radiography and mechanical properties in accordance with ASME Sec. II (c).

**8.0 Preparation of Test Samples**

Tensile and Impact specimen shall be prepared in accordance with ASME Sec. II (c).

**9.0 Freedom from Defects**

Weldment on the test plate made as per ASME Sec. II (c) shall be free from inclusions, cracks and lack of fusion etc , on radiography, as per recommendation of ASME Sec. II (c).

**10.0 Acceptance**

- 10.1 Each batch of electrodes supplied by approved vendor shall be accepted on the basis of properties given in Cl. 5.0 and properties as per Cl. 6.0 shall be checked on surveillance basis.
- 10.2 For a new vendor the initial approval will be done on the basis of properties (given in Cl. 5.0, 6.0 and 9.0) obtained on the test samples prepared from the test plate made as per ASME Sec. II (c) at BHEL

**11.0 Test Certificates**

The supplier shall submit five copies of test certificates giving the following information along with delivery

- 11.1 BHEL REFERENCE
  - 11.1.1 PO Number
  - 11.1.2 Specification No.

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निर्माणकर्ता WORKED BY	Sushant Panday		25/08/09
जांचकर्ता CHECKED BY	Anil Kumar		25/08/09



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SUPERSEDES  
INVENTORY NO.

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**11.2 SUPPLIER REFERENCE**

- 11.2.1 Supplier Name and Emblem.
- 11.2.2 Chemical Analysis
- 11.2.3 Result of Mechanical Properties
- 11.2.4 Diameter of core wire and length of electrodes
- 11.2.5 Batch No.
- 11.2.6 Date of manufacture
- 11.3 Party shall certify that the electrodes have been manufactured in accordance with FF77190 Rev 02.

**12.0 Marking**

Each electrode shall be marked by imprint of Plant Standard No./ AWS No. and brand name of supplier near to the gripping end. Ink used for imprinting shall provide sufficient contrast with the electrode covering, so that it is legible before and after normal welding operation. Party shall imprint following information on each carton.

- Brand Name
- Size of electrode
- Batch no. and Date of Manufacture
- Quantity and net weight.

निर्माणकर्ता WORKED BY	Sushant Panday	<i>Sushant</i>	25/08/09
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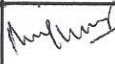
सामग्री सूची संख्या को	SUPERSEDES INVENTORY NO.	RECORD OF CHANGES
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REV CODE	NO. OF CHANGES	DOCU. NO.	SHEET NO.	SIGN	DATE
02	Clause No. 5.0 Lower limit of Si deleted		1 of 4		20.10.06
	Clause No. 6.0 SR specified , 23 ± 5 changed to 20		2 of 4		20.10.06
	Clause No. 7.4 deleted		2 of 4		20.10.06
	Clause No. 9.0 Radiography added		2 of 4		20.10.06
	Clause no. 10.0 added		2 of 4		20.10.06
	Clause No. 12.0 AWS No. added		3 of 4		20.10.06
03	Clause No. 6.0 YS , UTS & % El values changed in line with material specification		2 of 4		25.08.09

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सामग्री सूची संख्या INVENTORY		निर्माणकर्ता WORKED BY	Sushant Panday		25/08/09
		जांचकर्ता CHECKED BY	Anil Kumar		25/08/09