



CORPORATE PURCHASING SPECIFICATION

AA 113 01

Rev. No. 03

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PIG IRON GENERAL PURPOSE

1.0 GENERAL:

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

2.0 APPLICATION:

Used for the production of ordinary and high duty irons.

3.0 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.

4.0 SIZE AND SHAPE:

Size and shape of the Pig Iron shall conform to fig.2 of IS: 13502 having a single notch in the middle and weighing 22.5 kg (approximately).

5.0 GENERAL APPEARANCE:

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

6.0 CHEMICAL COMPOSITION:

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

Grade	% Si	% Mn	% S	% P
PG Si 3 Mn 3P40	1.25 to 1.75	0.50 to 1.0	0.06 max.	0.40 max.

As an alternate to the above composition due to non-availability etc., the following compositions can also be procured.

Alternative I

PG Si 2 Mn 1P40	0.75 to 1.25	< 0.50	0.06 max.	0.40 max.
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Alternative II

PG Si 1 Mn 1P40	< 0.75	< 0.50	0.06 max.	0.40 max.
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Revisions :

As per E-mail Dt: 19-09-2008 from HW

APPROVED:

INTERPLANT MATERIAL
RATIONALISATION COMMITTEE-MRC (FN)

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BHOPAL

Corp. R&D

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**7.0 SAMPLING:**

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

8.0 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.

9.0 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 clearance of the material.

The test certificates shall bear the following information:

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BHEL Order No.

Manufacturer's/Supplier's Name.

Trade mark, if any.

Consignment /Identification No.

Grade of pig iron

Test results of chemical analysis.

10.0 PACKING AND MARKING:

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

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BHEL Order No.

Manufacturer's/Supplier's Name.

Heat No.

Consignment /Identification No.

Weight

11.0 REFERRED STANDARDS (Latest Publications Including Amendments):

1) IS: 12308

2) IS: 13502