

PSGSG / 2014-15/008	Product Specifications For FIXED ARCING CONTACT FOR GCB		Drg. No.	RD DG 435 1351 1611A
			Date	15.07.2014
			Product	CGSM 145
1.0	Application	: Fixed Arcing contacts for Gas Insulated Circuit breaker		
2.0	Configuration	:		
3.0	Specifications:	1) Sintered W-Cu (70-30 %), welded (by electron Beam welding process) to the high conductivity copper. 2) Machined to drawing dimensions.		
	1. Dimension Drawings	: Refer Drg No. RDDG 4 35 1351 1611A		
	2. Material:	: Tungsten-Copper, ETP copper		
	(a). W-Cu	A sintered matrix of W-Cu (70-30 %) shall be produced by PM technique. The sintering shall be carried out in neutral or reducing atmosphere. The ingredient (powders) shall have high purity.		
	(b). ETP Copper	ETP copper shall have the following specifications: The specified copper material shall have minimum conductivity of 95 % IACS. Supplied material will be tested at BHEL for conductivity and the same will be rejected in case they do not meet specified conductivity. The material shall be good for brazing, soldering and for electrical applications where high current transfer is involved.		
	Electron Beam Welding (EBW):	The component shall be finished to size before electron beam welding at the interface. The interface will be between High conductivity copper and W-Cu Tip. The interface shall be welded to full depth. The welding joint between high conductivity copper and W-Cu tip shall exhibit minimum contact resistance. The Component shall be free from dirt, grease and loose particles.		
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PSGSG / 2014-15/008	Product Specifications For ES MOVING CONTACTS	Drg. No.	RD DG 435 1132 3104
		Date	27.07.2012
		Product	CGSM 145
4.0	<p>Tests: (a). Dimensional : All dimensions shall comply to drawing measures. (b). The component shall be subjected to micro-ohm measurement test, using 100 A DC source and shall measure less than one micro-ohm at the welding interface.</p>		
5.0	<p>Qualifying Requirements: The supplier shall be of national / International repute with proven record and should have supplied arcing contacts for electrical applications at least for last three years. The supplier must submit along with the quotation a few references to whom the supplier has supplied a similar material.</p>		
6.0	<p>General : 1. Surface finish of the components shall be at least RA 1.6. 2. The component shall be free from dirt, grease and loose particles.</p>		
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