



BHARAT HEAVY ELECTRICALS LIMITED
TIRUCHIRAPALLI-620 014
WELDING TECHNOLOGY CENTRE

WCPI – 010
Revision No.: 05
Date: 28.09.2015

WELDING CONSUMABLE PURCHASE INSTRUCTION FOR
SAW WIRE AS PER ASME.SEC.II.C SFA-5.23, EB91

1.0 GENERAL:

1.1 The wire shall comply with requirements specified in the latest edition and addenda (applicable on the date of issue of purchase order) of ASME Sec.II.C.SFA-5.23, EB91. All tests, acceptance criteria shall be in accordance with this. Additional requirements specified in this document shall also be complied.

1.2 The wire shall be supplied in size and quantity as specified in the purchase order.

1.3 The wire is intended to be used in submerged arc welding of circumferential seam butt welds in high pressure super critical boiler headers and piping of SA335P91 material.

2.0 CHEMICAL COMPOSITION:

The chemical composition of the wire shall conform to ASME Sec II C SFA-5.23, EB91.

3.0 SIZE:

The wire shall be supplied in diameter as specified in the purchase order. The tolerance on diameter shall be as per ASME SEC IIC, SFA-5.02. Net weight of each coil shall be 25Kg or 30 Kg.

4.0 FORM :

The wire shall be appropriately wound in basket rim B450 as per SFA-5.02 as mentioned in the purchase order and shall meet the requirements of 4.3.4 of SFA-5.02.

5.0 FINISH AND UNIFORMITY:

The wire shall meet the requirements of clause 16.2 of SFA-5.23.

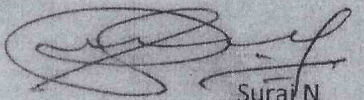
6.0 WINDING REQUIREMENTS:

The wires shall meet the requirements of clause 16.4 of SFA-5.23.

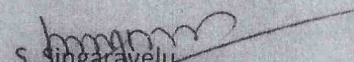
7.0 IDENTIFICATION :

The wires shall meet the requirements of clause 4.5.2, 4.5.4 and 4.5.5 of SFA-5.02.

Prepared:


Suraj N
Engineer/WTC

Reviewed and approved:


S. Singaravelu
SDGM / WTC



8.0 MARKING:

The wire shall meet the requirements of clause 4.6 of SFA-5.02.

9.0 PACKAGING:

9.1 The wire coils shall be completely devoid of moisture or any other foreign material that is adequately sealed in suitable cartons to ensure no deterioration in the wire quality during transportation through sea or long duration storage.

9.2 The cartons shall be packed in waterproof boxes with crates to ensure no damage during shipment and normal storage conditions. Weight of each crate shall not exceed 1000kg.

9.3 The cartons shall have product information as per clause 4.6 of SFA-5.02

10.0 TESTING & CERTIFICATION:

10.1 Each consignment of wire supplied shall be from one batch only.

10.2 Batch or lot classification shall be Class S1 as per SFA-5.01 Filler metal procurement guidelines of ASME Sec.II.C. (latest edition and addenda).

10.3 The level of testing shall be Schedule J as per SFA-5.01 Filler metal procurement guidelines of ASME Sec.II.C. (latest edition and addenda).

10.4 Three copies of original test certificates in English countersigned by the manufacturer giving details of the tests in compliance with this purchase instruction and ASME Sec.II.C, SFA-5.23, EB91 shall be sent.

10.5 The testing authority shall certify that supplies made against the batch conform to the requirements of the latest edition and addenda (applicable on the date of issue of purchase order) of ASME Sec IIC SFA-5.23, EB91.