



CORPORATE PURCHASING SPECIFICATIONS

AA 10119

Rev. No.13

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STRUCTURAL STEEL - WELDABLE QUALITY (PLATES, SECTIONS, STRIPS, FLATS AND BARS)

ORDERING DESCRIPTION

1.0 GENERAL:

The material shall conform to the latest version of IS 2062, Grade. E250 Gr.BR (With impact test) DIN EN 10025, Gr.: S275J2G3 and comply with following additional requirements.

2.0 APPLICATION:

For general engineering purposes, suitable for welding.

3.0 CONDITION OF DELIVERY:

3.1 Bars & Sections: Hot rolled in straight lengths without twists and bends.

3.2.1 Plates:

Plates as per IS: 2062 E250 Gr.BR (with mandatory impact test)

3.2.2 All plates up to 10mm thickness shall be free from mill scales and shall be suitably protected with rust preventive coating at the time of supplies.

3.2.3 Any other additional requirement as per BHEL Purchase order.

4.0 DIMENSIONS AND TOLERANCES:

4.1 Sizes:

Material shall be supplied to the dimensions specified in BHEL Order.

4.2 Tolerances:

The tolerances on hot rolled material shall comply with IS: 1852 or any other equivalent National standard.

4.3 Straightness for hot rolled bars:

Unless otherwise specified, the permissible deviation in straightness shall not exceed 5 mm in any 1000 mm length.

5.0 TEST SAMPLES :

5.1 Tensile Test Pieces :

One tensile test sample shall be made from finished steel of each melt per size for each class of product viz. plates, sections, strips, flats and bars size of the product.

5.2 Bend Test Pieces :

Bend test piece shall be made from finished steel of each melt per size of the product.

Revisions: As per 34.6.1 of 34th MOM of S&GPS

APPROVED:
INTER PLANT MATERIAL RATIONALISATION
COMMITTEE – MRC(S&GPS)

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6.0 ULTRASONIC EXAMINATION:

Plates shall be ultrasonically examined in accordance with BHEL standard M 085 01 20 (or ASTM-A 435) as detailed below and shall comply with the acceptance standards specified therein.

6.1 For plates above 40mm thick:

Shall be ultrasonically examined unless otherwise specified in order.

7.0 TEST CERTIFICATES:

Unless otherwise specified, three copies of test certificates shall be supplied.

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

The test certificate shall bear the following information:

M 101 19-Rev. No.13/IS : 2062-Gr:E250 BR (With impact test) or DIN EN 10025 Gr.

S275J2G3 , BHEL order No,

Melt No, Size & Quantity, Batch No with heat treatment details , Results of Chemical analysis, Mechanical tests & NOT, Suppliers name, Identification No, TC No, Signature of Competent authority, etc.

8.0 RUST PREVENTION:

(Refer CI.3.2.2)

9.0 PACKING AND MARKING:

Plates shall be transported suitably to avoid damage during transit.

Each plate shall be marked with Melt No. Material grade and specification, BHEL Order No, Supplier's Name Identification No, Size & weight. on anyone comer and encircled with paint preferably of white color.

10.0 REJECTION AND REPLACEMENT:

If the material does not comply with the requirements of this specification during receipt inspection at BHEL or if any defect is found during further processing of material. BHEL reserves the right to reject the whole consignment and the supplier shall replace the material free of cost. The rejected material shall be taken back by the supplier after fulfilling the commercial terms and conditions.