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BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

FOUNDRY DIVISION DEPARTMENTAL PURCHASING SPECIFICATION	DS NO. : FYM/072
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LIMESTONE, GR:2 FOR USE IN FOUNDRIES

1.0 GENERAL :

The specification governs the requirements of Limestone for use in Foundries.

2.0 APPLICATION

Used as one of primary fluxes in Iron and Steel melting.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

There is no National standard covering this type of material.

4.0 SHAPE AND SIZE :

The material shall be hard and lump form, free from dirt and other foreign matter conforming to the following sizes :

For Foundries : 50 to 100 mm

5.0 CHEMICAL COMPOSITION :

The material when analysed in accordance with IS:1760 shall comply with the following :

Calcium Oxide (CaO) : 50% minimum

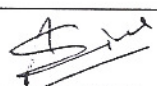

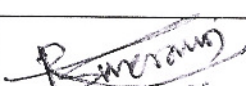
Silica (SiO₂) : 3% maximum

6.0 OPTIONAL TEST :

As and when required, the following test shall be carried out.

Sulphur : 0.05% maximum

Phosphorus : 0.05% maximum

PREPARED BY		CHECKED BY		APPROVED BY	
NAME	ASHWANI SINGH	NAME	VIPIN K. DHALLE	NAME	R.S. MERAWI
SIGN.		SIGN.		SIGN.	
DATE	20/9/16	DATE	20/9/16.	DATE	20/9/16

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7.0 INSPECTION AT SUPPLIERS WORKS :

Whenever specified tests and inspection are to be conducted in the presence of BHEL's representative.

The supplier shall offer BHEL's representative all responsible facilities, without charge to satisfy the latter that the material is being furnished in accordance with this specification. The supplier shall prepare and provide necessary test specimens for testing to be carried out at his premises. If facilities are not available at his works, the supplier shall make necessary arrangements for carrying out the prescribed test elsewhere. The supplier shall notify BHEL in advance about the readiness of the material for inspection and testing.

BHEL reserves the right to test the material at BHEL's works and the final acceptance of the material shall be based on these test results.

8.0 ACCEPTANCE :

Acceptance based on shop trial & TC given by Supplier. BHEL decision will be final and binding on the supplier.

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

DS: FYM/072(Rev. No. 0): Limestone, Gr:2 for use in foundries

BHEL Order No.

Manufacturer's/Supplier's Name.

Trade mark, if any

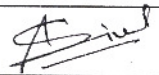
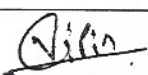
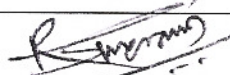
Shape & Size

Quantity supplied

Test results of clause 4 and 5

10.0 REFERRED STANDARDS (Latest Publications Including Amendments):

1) IS : 1760

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