



CORPORATE PURCHASING SPECIFICATION

AA 536 10

Rev. No. 01

PREFACE SHEET

FLUOR SPAR FOR USE IN FOUNDRIES

**FOR INTERNAL USE ONLY
REMOVE THIS PREFACE BEFORE ISSUE TO SUPPLIERS**

Comparable Standards:

1. INDIAN : IS : 4574-1989, Gr.: 2

Suggested / Probable Suppliers and Grades :

1. China
Refer plant vendor directory

User Plant References:

1. HYDERABAD :
2. CFFP, HARDWAR :

Revisions :

Cl: 18.6.43 of MOM of MRC (FN).

APPROVED :

**INTERPLANT MATERIAL
RATIONALISATION COMMITTEE-MRC (FN)**

Rev. No. 01

Amd.No.

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BHOPAL

Corp. R&D

JULY, 1985

**FLUOR SPAR FOR USE IN FOUNDRIES****1.0 GENERAL:**

This specification governs the quality requirements of Fluor Spar used in foundries.

2.0 APPLICATION:

Used for making reducing slag mixture for deoxidation after killing of steel melts.

3.0 COMPLIANCE WITH NATIONAL STANDARDS:

The material shall comply, in general, with the following national standards and also meet the requirements of this specification:

IS: 4574 –1989, Gr.:2 : Fluor spar for use in Metallurgical Industries.

4.0 CONDITION OF DELIVERY:

As pellet/gravels or as specified on BHEL order.

5.0 SIZE: The size shall be between 6 and 25mm.**6.0 SAMPLING:**

A composite sample shall be prepared from each consignment of 10 tonnes or part thereof..

7.0 CHEMICAL COMPOSITION:

The sand, when analysed shall comply with the following:

Calcium fluoride Ca F ₂	: 85 %, min.
Silica SiO ₂	: 6 %, max.
Effective CaF ₂	: 72 %, min
CaCO ₃	: 3 %, max
Mixed Oxides (R ₂ O ₃)	: 3.5 %, max
Sulphur	: 0.3 %, max
Phosphorus	: 0.3 %, max

8.0 ACCEPTANCE TEST:

Each consignment shall be accepted on the basis of tests carried out as per clause 4.0, 5.0 and 7.0. Analysis of Ca CO₃ mixed oxides S & P is not mandatory and shall be carried out as and when required.

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**9.0 INSPECTION AT SUPPLIER'S WORKS:**

BHEL reserves the right to inspect the material at site before despatch. 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.

10.0 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 despatch documents to facilitate quick clearance of the material.

The certificates shall bear the following information

AA 53610, Rev.No.01 : Fluor spar for use in foundry

BHEL Order No.

Manufacturer's/Supplier's Name.

Trade mark, if any

Grade and size of material

Test results of clauses 4.0 , 5.0 and 7.0.

11.0 PACKING AND MARKING:

The material shall be supplied in gunny bags of 50 kg each.

Each bag shall be legibly marked with the following information:

AA 53610, Rev.No.01 : Fluor spar for use in foundry

BHEL Order No.

Manufacturer's/Supplier's Name.

Trade mark, if any

Material grade and size

Net weight and Gross weight.

12.0 REFERRED STANDARDS (Latest Publications Including Amendments):

1) IS: 4574