

BHARAT HEAVY ELECTRICALS LIMITED, BHOPAL

FOUNDRY DIVISION	DS NO : FYM/018
DEPARTMENT PURCHASING SPECIFICATION	REV. NO : 02
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DEGASSER FOR COPPER

(I) GENERAL :

This specification governs the technical requirement of carbonate based Degasser for Copper base alloys.

The material is equivalent to LOGAS – 50 2B of FOSECO.

(II) APPLICATION :

The material will be used in Non Ferrous melting for degassing pure Copper and Copper-base alloy melt, for removing Hydrogen and other harmful dissolved gases in melt to produce gas free castings. This will eliminate pin holes in the castings.

(III) COMPLIANCE WITH NATIONAL STANDARD :

There is not national standard covering this type of material.

(IV) SHAPE AND SIZE :

The material shall be in cylindrical shape to size : 55 mm OD x 25 mm ID x 70 mm height, Weight of each tube shall be 150 gms. minimum.

(V) TESTING AND APPROVAL :

Trial shall be done by checking minimum 2 minutes reaction time of the material during degassing of liquid metal before breaking off. For new source, mechanical properties of test bars shall be verified for establishing quantity of product in shop.

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(VI) PACKING AND MARKING :

1. The material shall be packed in closed cardboard tubes, 4 to 5 nos. in each tube. The tubes shall be externally packed in paper board crates. Care shall be taken to avoid damage during transits.
2. The material shall be marked in the external crates with the following :-
 - i. Suppliers name / Trade mark, if any
 - ii. Quantity supplied
 - iii. Date of manufacture
 - iv. Batch no.

PREPARED BY	
SIGN.	<i>[Signature]</i>
DATE	26-7-13

CHECKED BY	
SIGN.	<i>[Signature]</i>
DATE	26/7/13

APPROVED BY	
SIGN.	<i>[Signature]</i>
DATE	27/7/13