	<b>BHEL – Tiruchirappalli - 620014, India.</b> <b>Quality Assurance Department</b> <b>TECHNICAL DELIVERY CONDITIONS</b>	DOC No: <b>TDC:0:102</b> Rev: <b>20</b> Effective Date: <b>01/02/2024</b> Page: <b>1 of 7</b>
<b>Product: SEAMLESS STEEL TUBES (for BOILERS)</b>		

#### Revision record:

**Rev 08:** 21.09.04: UT as per BS EN 10246-7, in lieu of ASTM E 213  
**Rev 09:** 31/12/05: Cl 5.0 - mention of shape and size of tensile test specimen on TC introduces  
**Rev 10:** 29/12/07: Cl 1.0, 3.0, 6.0, 7.0, 11.0 and 12.0 modified.  
**Rev 11:** 19/05/09: Cl 8.0 – Modified. Cl 9.0 – Marking details included in line with material specification.  
**Rev 12:** 08/06/11: Cl 1.0- SA 213 T12, T92 and T23 removed from this TDC. Cl 2.0 Process of Manufacture – Clarified. Cl 9.0- Stenciling and colour coding modified. Cl 12.0- Modified.  
**Rev 13:** 04/07/11: Cl 6.0: Modified, Cl 9.0 – Marking: Correction made in the “Details to be identified”  
**Rev 14:** 26/10/12: Cl 2.0, 6.0 and 12.0 modified  
**Rev 15:** 19/02/2016: TDC: 0:124 requirements merged in this TDC. And Cl 1 modified; Cl 2 modified to include polygonization requirements; Cl 4– heat treatment temperature added for Gr 91; Cl 5– lot size for mechanical tests defined & additional requirements of Gr 23, 91 & 92 added; Cl 6, 7, 9 – modified; Cl 10 –Preservation requirements modified; Cl 11 – modified; Cl 12-changed as per latest IBR including MAWP requirements.  
**Rev 16:** 13/10/2017: Clause 1 & 12 modified to include raw material requirements and certification in IBR Form IV. Clause 5 (f) added to include creep requirements.  
**Rev 17:** Dt: 20/04/2018 - Cl 2 added to include Billet/Bloom Requirements, Cl. 3 modified, Cl. 6(f) modified, Cl. 13.3 (k) added to include mill TC certification  
**Rev 18:** Dt: 05/08/2019 – Cl 2 modified based on feedback from user departments, suppliers and internal discussions, Cl 5 modified, Cl 6 added to include shot peening requirements, subsequent clauses renumbered, Cl 7 (f) & Cl 9 modified, Cl 14.3 (l) & Cl 15 added.  
**Rev 19: Dt: 09/03/2023** – Clause 1– Code case 2328 for S30432 deleted, for T91 (Type 1/Type2 included, Clause 2 -paragraph 3 revised, Clause 5- subclause (a) added in which Grain Size requirement for TP347H and S30432 (Super 304H) specified, Clause 6- Code case 2328 for S30432 deleted, Clause 7 – In subclause (d) - for T91 (Type 1/Type2) included and Subclause(f) errata corrected, Clause 9–Hydrostatic test pressure requirement modified and DM water quality requirement also included in note, Clauses 12 and 13 modified for clarity, Clauses 14.1 & 14.2 interchanged, Clause 14.3 - In subclause (j) cross reference corrected and subclause (k) revised.  
**Rev 20: Dt:01/02/2024** – *Cl. 9 – Modified for clarity based on vendors feedback, Cl 10. Finish and repair condition is modified incorporating standard reference, Cl. 13 – existing clause renumbered as sub cl. a and modified for clarity wrt SS packing requirement. Cl.13 b added to include check for chloride, Cl.14.3 - Modified to include reporting of chloride levels, Cl. 16 – added for clarity*

## 1. MATERIALS

Specification: ASME (Latest as on the date of Enquiry/PO, whichever is earlier):

Carbon Steel (CS) : SA 192; SA 210 Gr. A1 & Gr. C  
Alloy Steel (AS) : SA 209 Gr.T1, SA 213 Gr. T11, T12, T22, T23 (Code case: 2199), T91 (Type 1/Type 2) and T92 (UNS K92460 Code Case: 2179).  
Stainless Steel (SS) : SA 213 TP 304H, 316, 321, 321H, 347H; UNS No: S30432 (Super 304H).  
Additional Requirement : As listed below (Supplementary to above material specifications)  
Size and Quantity : As per Purchase order

## 2. BILLET/BLOOM REQUIREMENTS:

The billets/blooms shall be fully killed.

For carbon steel and alloy steel, billets/blooms shall be made by vacuum degassing. For Stainless steel, billets/blooms shall be made by vacuum degassing or argon oxygen decarburization (AOD).


Ladle analysis is required for all steels. Chemistry shall be controlled as given below for below specified grades.

For all other grades, it shall be as per applicable material specifications:

- Carbon Steel: Max. Carbon: SA 210 Gr.A1: 0.25%, SA 210 Gr.C: 0.30%
- For SA 213 T12: Aluminum: 0.025% max; Silicon: 0.20%min. on product analysis and the values shall be reported in the test certificate.
- Stainless Steel (SS): Boron: 0.01% max., Vanadium: 0.10% max.

The billet/bloom shall conform to the chemical and process requirements of respective tube specifications. The billet/bloom shall be sourced from IBR well known steel makers or with inspection and certification by



	<b>BHEL – Tiruchirappalli - 620014, India.</b> <b>Quality Assurance Department</b> <b>TECHNICAL DELIVERY CONDITIONS</b>	DOC No: TDC:0:102 Rev: 20 Effective Date: 01/02/2024 Page: 2 of 7
<b>Product: SEAMLESS STEEL TUBES (for BOILERS)</b>		

IBR authorized Inspecting Authority in case the mill is not approved by IBR. Mill test and IBR Form IV certificate shall be submitted to BHEL.

### 3. CHEMICAL COMPOSITION AND PROCESS OF MANUFACTURE OF TUBES

a) **Carbon Steel & Alloy Steel:** Tubes shall be seamless and made by processes specified below:

1. All tubes shall be cold formed in case of "t/D" ratios > 0.15, where "t" is the specified nominal wall thickness and "D" is the specified nominal OD of the tube.
2. Tubes may be cold formed or hot formed in case of "t/D" ratios upto and including 0.15.
3. The degree of polygonization (P), measured as indicated in Fig.1 & calculated using the below formula, shall not exceed 15% in both the above cases:

$$P = \{[\sum S_B - \sum S_A] / [0.135*(3D - \sum S_A)]\} * 100$$

where, P is the degree of polygonization in %

D is the specified nominal OD of the tube

$\sum S_B$  is the sum of maximum tube wall thicknesses measured at 6 locations 60 degrees apart and

$\sum S_A$  is the sum of minimum tube wall thicknesses measured at 6 locations 60 degrees apart.

Wall thickness shall be measured using profile projector/shadowgraph/digital scanner/any other suitable instrument meant for this purpose.

Definition of the measure points:

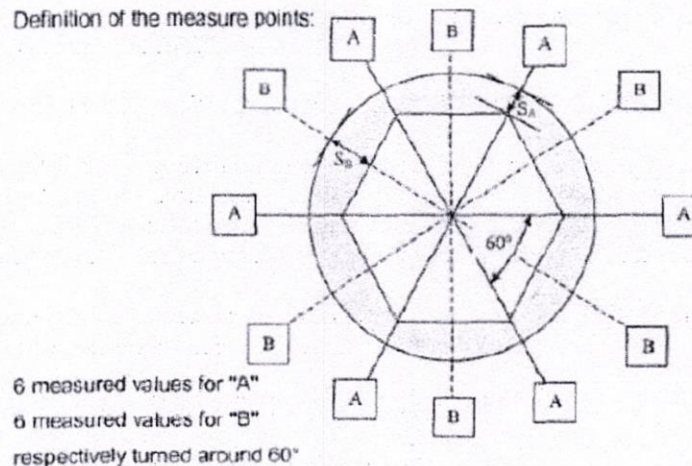


Fig. 1

**Stainless Steel:** Tubes shall be seamless and cold finished. All raw materials used in steel making including incoming scrap shall be checked by supplier to ensure freedom from radioactivity (Applicable for SS materials only).


b) **Product analysis** on tubes is required for all steels. Chemistry shall be controlled as per applicable material specifications and the elements including carbon for carbon steel, Aluminium (for T12), Boron & Vanadium (for Stainless steel) as indicated in Clause 2 shall also be reported in the product analysis.

### 4. DIMENSIONAL TOLERANCES

a) For Cold finished tubes: CS: as per SA 450; for AS & SS shall be as per SA 1016.

Tolerance on thickness shall be: For OD ≤ 38.1 mm: -0% to +20% and For OD > 38.1 mm: -0% to +22%



	<b>BHEL – Tiruchirappalli - 620014, India.</b> <b>Quality Assurance Department</b> <b>TECHNICAL DELIVERY CONDITIONS</b>	DOC No: <b>TDC:0:102 Rev: 20</b> Effective Date: <b>01/02/2024</b> Page: <b>3 of 7</b>
<b>Product: SEAMLESS STEEL TUBES (for BOILERS)</b>		

b) For hot finished tubes the tolerance shall be as follows:

For Outside Diameter:  $\pm 0.4\text{mm}$ .

For Thickness:  $-0\%$  to  $+22\%$   $t > 4.5\text{ mm}$

$-0\%$  to  $+24\%$   $t$  between  $3.6$  and  $4.5\text{ mm}$  (both inclusive)

$-0\%$  to  $+28\%$   $t < 3.6\text{mm}$

## 5. HEAT TREATMENT

**CS Hot finished:** No Heat Treatment required.

**CS Cold finished:** Subcritical annealed (temperature  $\geq 650^\circ\text{C}$ ), fully annealed or normalized.

**AS:** Normalized and Tempered. For SA213 T91 & T92: Normalizing:  $1050-1080^\circ\text{C}$  & Tempering:  $750-780^\circ\text{C}$ .

For SA213 T23: Normalizing:  $1050-1080^\circ\text{C}$  & Tempering:  $750-775^\circ\text{C}$ .

(The total thickness of the decarburized material (Both on ID & OD of the tube together) shall be measured once per Heat treatment lot. The measurement shall be determined from a representative sample that has been sectioned, polished, etched and examined at  $100\times$ . The total decarburization thickness shall not exceed  $7\%$  of the specified minimum wall thickness and shall be reported in the test certificate.)

**SS:** Solution Annealed condition as per material specification.

a) The average grain size shall be controlled as given below for the below specified grades (determined as per ASTM E112):

SA 213 TP 347H : 4 - 7

SA 213 S30432 (Super 304H) : 6 - 9

The values shall be reported in the test certificate.

## 6. INSIDE SHOT PEENING FOR ALL STAINLESS STEEL TUBES OF SA213 TP347H and SA213 UNS No: S30432 (Super 304H):

6.1 Shot peening shall be carried out inside the stainless steel tubes after solution annealing, unless specified otherwise in Enquiry/Purchase order

### 6.2 Qualification:

a) The qualification for tube inside shot peening shall be performed according to the below described test steps. The range of qualification covers tube internal diameters ( $D_i$ ) in the range of  $D_i \pm 2\text{mm}$  as well as the specific material grade and qualifies the shot peening process based on the used machine settings (peening parameters). Stainless Steel shots shall be used.

b) Qualification evaluations (hardness test and microstructure) shall be performed on at least one (1) sample tube, with evaluations at sections cut from the beginning, middle and end of the tube.

i) Metallographic examination for proof of thickness of cold worked microstructure across the entire tube circumference and a minimum depth of  $70\text{ }\mu\text{m}$  from the inner surface shall be carried out and documentation of representative shot peened conditions at  $500\times$  magnification shall be submitted.


ii) Hardness test shall be carried out at a distance of  $40\text{ }\mu\text{m}$  from the inner surface at quarter points ( $4 \times 90^\circ$ ) spread around the tube circumference. Acceptance criteria: hardness values of the shot peened zone shall be a minimum of  $100\text{ HV}0.1$  above the average hardness of the unaffected base material ( $2\text{mm}$  from outer surface).

iii) Almen strips representing acceptable shot peening conditions shall be produced during the qualification.

General requirements- Almen testing shall be in conformance with SAE J442 – Almen testing reading tolerances shall be in conformance with SAE AMS 2430 § 3.7.

For SS tube shot peening, where SS shots shall be used, C type Almen strip in conformance with SAE AMS 2431/4C shall be used.



	<b>BHEL – Tiruchirappalli - 620014, India.</b> <b>Quality Assurance Department</b> <b>TECHNICAL DELIVERY CONDITIONS</b>	DOC No: <b>TDC:0:102 Rev: 20</b> Effective Date: <b>01/02/2024</b> Page: <b>4 of 7</b>
<b>Product: SEAMLESS STEEL TUBES (for BOILERS)</b>		

**6.3 In-process tests** – Quantum of test shall be one test per heat no. and tube internal diameter

- Hardness test shall be executed in accordance with the prior performed qualification at the beginning or end of tube {see point 6.1 (b) (ii)}.
- The Almen test (alternative test instead of the hardness test) shall be executed in accordance with the previously performed qualification {see point 6.1 (b) (iii)}. Almen test readings shall not be lower than the established "Minimum" shot peening intensity.

#### **6.4 Marking & Certification:**

- After shot peening treatment, all tubes shall be marked with the letters "SP" for "shot peened".
- Certification for Shot peening shall be done in Material Test Certificate (MTC).
- Results of qualification shall be submitted as one time exercise for each internal diameter and material grade which shall include Almen test, Metallographic examination and Hardness test.
- Results of In-process tests shall also be submitted for each heat and tube internal diameter.


### **7. MECHANICAL TESTS**

- As per specification. Quantum of test: As per specification – For each nominal size per heat per heat treatment batch (Minimum 2 tubes for first 100 tubes and 1 per 100 or part thereof for tubes over 100 numbers, as per IBR).
- Tension test required for SA 192. **Acceptance:** explanatory note in Specification. Hardness for SA 192: 120 HBW (max).
- For tension tests, the shape and size of the specimen shall be mentioned on the Test Certificate (viz., Full tube tensile or strip tensile or round tensile).
- Additionally, the material supplied shall meet the requirements as below:  
**T91 (Type 1/ Type2)** -Tensile strength:Min: 630MPa, Max: 850MPa; Yield Strength: Min: 450MPa; Hardness (HBW): Min: 195/Max: 250  
**T92**-Tensile strength: Min: 620 MPa, Max: 850 MPa; Hardness (HBW): Min: 190 / Max:250  
**T23**-Tensile strength: Min: 510 MPa, Max: 730 MPa; Hardness (HBW): Min: 150 / Max:220
- Charpy Impact V-Notch Test at the mill as per SA 370 for SA 213 T23:**
  - Impact testing frequency** - minimum of two tubes per each heat treatment lot produced.
  - V-Notch Impact test procedure & specimen size as per ASME SA 370.**
  - Test temperature:** 20°C.
  - Acceptance:** All specimens shall absorb energies at or above 40 ft-lb (55Joules) for a full size specimen (10mm thickness). The energy requirement is proportionally reduced for sub-size specimens as specified in ASME SA 370, Table 9.
  - The fracture surfaces on all specimens must exhibit 100% ductile appearance regardless of the absorbed energy values obtained.
  - Any specimen exhibiting an absorbed energy less than 40 ft-lb (55Joules) or less than 100% ductile behavior shall constitute permanent rejection of the entire lot of tubing.
- Creep testing shall be carried out for all alloy steel and stainless steel tubes as per SIP:RM:01 (latest revision).

### **8. NON DESTRUCTIVE TEST (In-house Automated Online Testing Only)**

- Each tube shall be examined full section over its entire length.  
**Ultrasonic Testing:** For thickness  $\geq 3.6$  mm to be conducted as per ASTM E213. Calibration: 2 axial 50mm long notches, one in outer surface and the other in inside surface. For OD  $< 30$  mm, one notch in outer surface only. Notch depth: 5% of wall thickness (Min. 0.3 mm, Max: 1.5 mm). Scanning: clockwise & anti-clockwise.



	<b>BHEL – Tiruchirappalli - 620014, India.</b> <b>Quality Assurance Department</b> <b>TECHNICAL DELIVERY CONDITIONS</b>	DOC No: <b>TDC:0:102</b> Rev: <b>20</b> Effective Date: <b>01/02/2024</b> Page: <b>5 of 7</b>
<b>Product: SEAMLESS STEEL TUBES (for BOILERS)</b>		

**Eddy current Test:** For thickness < 3.6mm, as per ASTM E309 /E426 as applicable,  
Calibration: Longitudinal notch depth: 5% of wall thickness (Min. of 0.3 mm) or drilled hole as per SA 106.

- b) SS: Finished tubes shall be checked for radioactive contamination and reported. Survey meter shall be used to measure at 5cm near the surface. **Acceptance limits:** Shall be less than 0.1 milli Rontgen (mR) per hour or 1 micro Sievert per hour.
- c) The residual magnetism in all finished tubes, measured with field indicator, shall be limited to 5 gauss maximum.

## 9. HYDROSTATIC TEST

Extent of test: On all tubes of thickness < 3.6 mm:

Hydrostatic test pressure shall be calculated as follows:

- i) for Carbon and low alloy steel tubes : as per clause no. 23.3 of SA-450
- ii) for Ferritic alloy steels and Austenitic stainless Steels : as per clause no. 26.3 of SA-1016

The tube wall stress, "S", shall be determined as follows:

For Carbon steel, Low Alloy Steel and Ferritic Alloy steels:

S = 40% of the minimum specified tensile strength at room temperature.

For Austenitic SS:

S = 80% of the minimum specified yield strength at room temperature

The test pressure shall be held for a minimum of 5s.

For others (tubes of thickness  $\geq$  3.6 mm): if specified in Purchase Order.

Acceptance: No leak shall be permitted.

Note:- For Hydrotest of *Stainless Steel tubes*, DM water shall be used and the water shall meet the following requirements:

1. The halide content (chlorides and fluorides combined) shall not exceed 25 ppm and
2. Conductivity shall not exceed 10 microsiemens/cm

## 10. FINISH AND REPAIR

*Tubes inside and outside surface shall meet SA213 and SA1016 surface condition requirement. Tubes shall be free from defects like laps, seams, folds, cracks, pitting etc. Repairs by welding are prohibited. Surface defects can be removed mechanically, ensuring smooth curved surface and maintaining specified minimum thickness without affecting the workman like finish.*


## 11. MARKING: (in English only)

- a) **Details to be identified:** Tubes shall be marked repeatedly & continuously along its entire length with the following details as indicated below:

(1) PO Number, (2) Maker's emblem/code, (3) Specification & grade, (4) Code case (if applicable) (5) Heat number, (6) Size (OD x Thickness x Length, in mm), (7) No. of tubes, (8) Inspector's seal, (9) Condition: Hot finished or Cold Finished, (10) Tube Minimum Wall Thickness Designation (For SA 213 Spec only).

- Below OD 31.8mm. (Excl.) – Sl Nos:1 to 10 to be stamped on metal/plastic tag attached to bundle.
- OD 31.8-76.1mm. (Incl.) - Sl Nos: 1 to 6, 9 and 10 to be paint stenciled, repeatedly through the entire length of each tube. Also Sl.No:1 to 10 to be stamped on Metal/Plastic tag attached to bundle.



	<b>BHEL – Tiruchirappalli - 620014, India.</b> <b>Quality Assurance Department</b> <b>TECHNICAL DELIVERY CONDITIONS</b>	DOC No: <b>TDC:0:102</b> Rev: <b>20</b> Effective Date: <b>01/02/2024</b> Page: <b>6 of 7</b>
<b>Product: SEAMLESS STEEL TUBES (for BOILERS)</b>		

- OD > 76.1 mm- SI Nos: 2 to 6 & 8 to be hard stamped with round edge stamp at 100mm from both ends and SI No:1 to 6, 9 and 10 to be paint stenciled on each tube.

b) **Colour Coding:** Continuous longitudinal colour coding shall be done on the entire length of all tubes, without masking stenciling. If more than one color is to be applied on the tubes then, colour bands shall be adjacent. Colour coding scheme as per Procedure SIP: PP: 21 (latest).

## 12. PRESERVATION:

All tubes, except SS, shall have Rust Preventive Fluid (RPF) coating on the external surface as follows: The Tubes shall be coated with suitable RPF with minimum DFT of 50 microns. RPF coated steel surfaces shall be capable of withstanding salt spray corrosion test for minimum 1000 hours. The RPF coating should be sea worthy, ensuring freedom from corrosion when transported through sea voyage. The RPF coating shall get dried and shall be a transparent coating, so that it is possible to see the tube surface clearly as well as read any stenciled matter on tube surface. The inside surface of the tube shall be protected with volatile corrosive rust inhibitor. Rust preventive coating shall withstand at least one year storage at open yard from receipt of materials. The supplier shall stand guarantee for this. SS tubes to be surface treated as per ASTM A380 both inside and outside. After surface treatment, the tubes shall be rinsed with demineralised water and dried. Tube ends shall be closed with push type plastic end caps/plugs secured tightly to avoid entry of water during transportation and storage.

## 13. PACKING:

- a) Tubes of thickness  $\leq 2.5\text{mm}$ , shall be packed in boxes and others in bundles. Tubes of thickness  $\geq 6.5\text{mm}$  and OD  $\geq 88.9$  can be shipped loose. Bundles to be  $\leq 4$  tons of equal no. of tubes, fastened with galvanized strap (1x25mm.min.) or annealed wire for CS & AS and by Nylon strap for SS at both ends & at 1m interval in between. The stainless steel tubes shall be protected from coming into contact with carbon steel in any form. *All SS tube bundles shall be wrapped with polythene.* Wooden pallets/cardboard to cover tubes are not permitted.
- b) *For SS materials, check for presence of residual Chloride as per method IS 3025 Part 32. The residual chloride salt contamination of the inside and outside surface of the tubing at the time of packing for shipment from the mill shall not exceed a concentration of 10.7 mg/m<sup>2</sup> of tube surface as per ASTM A 688.*  
*Test frequency: As a minimum, one tube in each five hundred pieces shall be checked immediately prior to packing for shipment for chloride salt contamination*

## 14. INSPECTION AND CERTIFICATION:

14.1 Certification in IBR Form III-B for finished tubes from “IBR-Well Known Tube Maker” or “Inspecting Authority (refer to clause 14.2 below)”, as applicable, shall be submitted to BHEL.

Also, certification in IBR Form IV for the raw material signed by “IBR-Well Known Steel Maker” or “Inspecting Authority”, as applicable, shall be submitted to BHEL.


Refer to Drawing: 4-03-000-00061 (Latest Rev) and the drawings referred therein for MAWP values for various material grades & sizes at various temperatures.

14.2 IBR Form(s) must be countersigned by the Inspecting Authority as indicated below:

Imported Items: Inspecting Authority approved by IBR for the Country of origin (To be concurred by BHEL before placing PO).

Indigenously Supply: Director of Boilers/Chief Inspector of Boilers/Inspecting Authority approved by IBR, for the respective state.



	<b>BHEL – Tiruchirappalli - 620014, India.</b> <b>Quality Assurance Department</b> <b>TECHNICAL DELIVERY CONDITIONS</b>	DOC No: <b>TDC:0:102 Rev: 20</b> Effective Date: <b>01/02/2024</b> Page: <b>7 of 7</b>
<b>Product: SEAMLESS STEEL TUBES (for BOILERS)</b>		

14.3 Additionally, Manufacturer's Test certificate(MTC) (ORIGINAL in ENGLISH) with following details shall be submitted to BHEL:

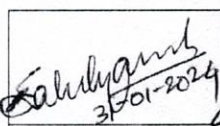
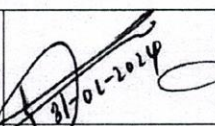
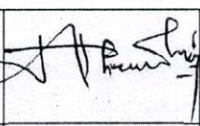
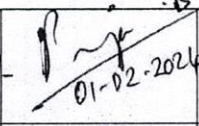
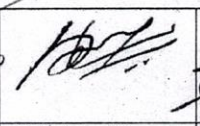
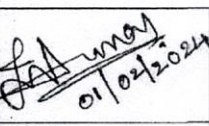
- Purchase Order No. (BHEL), TDC No and its Rev No, Test certificate No., Size and Quantity-Melt wise.
- Specification and Grade with year of code, Code case number (if applicable), Heat Number, Steel & Tube making process, chemistry including incidental elements-Ladle and product Analysis.
- Heat Treatment details with actual temperature and soaking time
- Mechanical test results
- Detailed NDE report with reference norms, acceptance standards and test results.
- Grain size as applicable
- Decarburization layer thickness
- Certification for compliance to residual magnetism
- Certification for minimum DFT of rust preventive coating
- Creep test report for a minimum of 1,000 hours as per Cl. 7(f) (only for IBR applications).
- Mill test certificate and IBR Form IV of the raw material (billets/blooms) as per Cl. 2.
- Certification for Shot peening, as applicable. Also, results of Almen test, metallographic examination and hardness shall be reported along with acceptance norms on shot peened SS tubes as per Cl 6.4.

In the MTC a clause for Certificate of Compliance (as per SA 1016) shall be added stating that: All materials/components supplied to Purchase Order meet all requirements contained in the PO, this Technical delivery conditions and applicable ASME specifications.

For SS: *Measured chloride levels (Ref. Cl. 13 b of this TDC) shall be reported.* Measured Radioactivity levels shall also be reported in the Mill Test Certificate and shall be submitted to BHEL.

15. End use: These tubes are meant for use in subcritical and supercritical Boilers. These tubes shall be capable of undergoing forming, bending and welding operations necessary for the application without developing defects.

16. In case of NTPC projects, the specific approval conditions (mentioned in the approval letter) by NTPC shall also be complied with by the vendor.

 31-01-2024	 31-01-2024	 01-02-2024	 01-02-2024	 01-02-2024	 01-02-2024
A Sakthi Ganesh Manager/QA	Deepesh V DGM/QA	N Nirmal Raj DGM/PE/FB	Priya Balaji Sr. DGM/MM	S Krishna Kumar Sr. DGM/QC	JVV Aruna Kumar AGM/QA & BE
<b>Prepared By</b>	<b>Reviewed by</b>				<b>Approved By</b>