



CORPORATE PURCHASING SPECIFICATION

AA11314

Rev No. 03

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ALUMINIUM NOTCHED BARS AND SHOTS

1 GENERAL:

This specification governs the quality requirements of Aluminium Notched Bars and Shots for use in steel melting shops.

2 APPLICATION:

Used as a deoxidiser of steel, in steel melting process.

3 CONDITION OF DELIVERY:

When supplied as notched bars, the weight of each bar shall be 1 to 1.5 kg or mutually agreed upon by BHEL and supplier.

4 SHOTS:

When supplied as shots, the grain size of each shot shall be 3 to 8 mm.

5 FREEDOM FROM DEFECTS:

The material shall be free from dress, slag and other harmful contaminants. The surface of the material shall be free from heavy oxidised coating.

6 TEST SAMPLE:

As per IS: 1817

7 CHEMICAL COMPOSITION:

The material, when analysed in accordance with IS: 504, shall have the following composition.

Aluminium : 99% minimum

Zinc : 1% maximum

8 INSPECTION AT SUPPLIER'S WORKS:

- 8.1** BHEL reserves the right to witness the testing of the material at supplier works and therefore the supplier shall notify BHEL in advance about the readiness of the material for inspection and testing.
- 8.2** BHEL may also opt for third party inspection. If so, BHEL may either specify a third party or else give a list of third party inspection agencies, out of which supplier may select one of his choice.
- 8.3** The supplier shall offer BHEL's representative all reasonable 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 tests elsewhere.
- 8.4** BHEL may, at its discretion, test the material after receipt and acceptance of the material will be based on the BHEL's test results.

Revisions:

As per Clause 27.2 of MOM of MRC-FN

APPROVED:

INTERPLANT MATERIAL RATIONALISATION
COMMITTEE - MRC(FN)

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Prepared
CFFP, Haridwar

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- 8.5** Supplier shall ensure that the material is free from extraneous material. The material shall be rejected if it is not free from extraneous material.
- 8.6** For result of analysis and properties of material the decision of BHEL shall be final and binding on the supplier.
- 8.7** If the material received is not found suitable according to the requirements, it shall be replaced free of cost by the supplier.
- 8.8** For any deviation, demanded by the supplier from the specification, prior approval of BHEL must be obtained.

9 TEST CERTIFICATES:

Unless and otherwise stated, one original and three copies of certificates from the original manufacturer shall be supplied along with each consignment.

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

Manufacturer supplying material directly to BHEL should include BHEL PO No. in the Test Certificate. Any other supplier should provide a covering letter along with original manufacturer Test Certificate as above mentioning BHEL PO No.

The test certificates shall bear the followings information:

- AA11314, Rev. 03: ALUMINIUM NOTCHED BARS AND SHOTS
- BHEL order no.
- Manufacturer's / supplier's name.
- Batch no.
- Quantity Supplied.
- Test results of clause 4 and 7

10 PACKING AND MARKING:

The material shall be packed in HDPE/Gunny Bags of 50 kg each. Original Manufacturer packing is acceptable. Each container shall be legibly marked or labelled with the following information.

- AA11314 : ALUMINIUM NOTCHED BARS AND SHOTS
- BHEL Order No.
- Manufacturer's / supplier's name.
- Batch no.
- Net weight of each packing.

11 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 the material, BHEL reserves the right to reject the whole consignment not withstanding any previous certification of satisfactory testing and / or inspection. The supplier shall undertake to replace the rejected material at his own cost and the rejected material shall be taken back by the supplier after fulfilling the commercial terms and conditions.

12 REFERRED STANDARDS (Latest publications including amendments):

1) IS: 504

2) IS:1817