



BHARATH HEAVY ELECTRICALS LIMITED
TIRUCHIRAPALLI-620 014
WELDING TECHNOLOGY CENTRE

WCPI – 012

Revision No.: 04

Date: 01.07.2014

WELDING CONSUMABLE PURCHASE INSTRUCTION FOR
SAW WIRE AS PER ASME.SEC.II.C SFA-5.9,ER-410

1.0 GENERAL:

- 1.1 The wire shall comply with requirements specified in the latest edition and addenda (applicable on the date of issue of purchase order) of ASME Sec.II.C.SFA-5.9, ER-410. All tests, acceptance criteria shall be in accordance with this. Additional requirements specified in this document shall also be complied.
- 1.2 The wires shall be supplied in sizes and quantities as specified in the purchase order.
- 1.3 The wires are intended for over lay welding for high pressure boiler valves and its components.

2.0 CHEMICAL COMPOSITION:

The chemical composition of the wires shall conform to ASME SECII.C SFA-5.9, ER-410.

3.0 SIZE:

The wire shall be supplied in diameter 2.4mm or 2.5mm & 3.2 mm as specified in the purchase order. The tolerance on diameter shall be as per SFA-5.02. Net weight of each coil shall be 25Kg or 30 Kg.

4.0 FORM :

The wires shall be appropriately wound in coils with suitable liners and shall meet the clause 4.3.3 of SFA-5.02 with dimensions 450mm maximum OD, 300mm ID and 100 mm width. Alternatively wires shall be appropriately wound in basket rim B450 as per SFA-5.02.

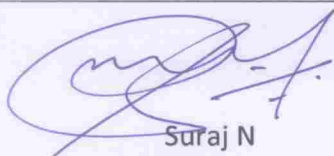
5.0 FINISH & UNIFORMITY:

The wires shall meet the requirements of clause 12.1 and 12.2 of SFA-5.9.

6.0 WINDING REQUIREMENTS:

The Wires shall meet the requirements of clause 14 of SFA-5.9.

Prepared:


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7.0 IDENTIFICATION :

The wires shall meet the requirements of clause 4.5.2, 4.5.4 & 4.5.5 of SFA-5.02.

8.0 MARKING:

The wires shall meet the requirements of clause 4.6 of SFA-5.02.

9.0 PACKAGING:

- 9.1 The wire coils completely devoid of moisture or any other foreign material shall be adequately sealed in suitable cartons to ensure against any deterioration in the wire quality during transportation by sea or long duration storage.
- 9.2 The liners shall meet the requirements of 4.3.3 of SFA-5.02 or the basket rim shall meet the requirements of 4.3.4 of SFA-5.02.
- 9.3 The cartons shall be packed in waterproof boxes with crates so as to ensure no damage during shipment and normal storage conditions. Weight of each crate shall not exceed 1000kg.
- 9.4 The cartons shall have product information as per clause 4.6 of SFA-5.02

10.0 TESTING & CERTIFICATION:

- 10.1 Each consignment of wires supplied shall be from one batch only.
- 10.2 Batch /lot classification shall be Class S1 as per SFA-5.01 filler metal procurement guidelines of ASME Sec.II.C. (Latest Edition and Addenda).
- 10.3 The level of testing shall be Schedule J as per SFA-5.01 Filler metal procurement guidelines of ASME Sec.II.C. (Latest Edition and Addenda).
- 10.4 Three copies of original test certificates in English countersigned by the manufacturer giving details of the tests done in compliance with this purchase instruction and ASME Sec.II.C, SFA-5.9, ER410 shall be sent.
- 10.5 The testing authority shall certify that supplies made against the batch conform to the requirements of the latest edition and addenda (applicable on the date of issue of purchase order) of ASME Sec.II.C.SFA-5.9 ER410.

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