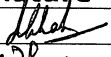
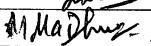
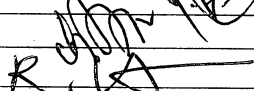
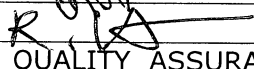


 Ranipet	Technical Delivery Condition (TDC) FOR SHROUD TUBE	Doc Ref:	TDC:RTE:251
		Rev.No.	03
		Date:	08 12 2015
		Page No	1 of 1

- 1.0 Scope:** This TDC deals with the requirements of the shroud tubes coming in emitting electrode.
- 2.0 Material:** Will be seamless tube made out of fully killed steel and fully annealed condition to a) STKM 11 A of JIS G3445 and b) DIN 2391 - C - St.35 NBK / DIN 1630 ST 37.4.
- 2.1** All the test are to be complied as per table 9 of DIN 2391 part 2 - BHEL / BHEL AIA to be witness above stage.
- 3.0 Dimension:** Outer Dia = 7 mm, Wall thickness = 2mm, Inner Dia = Min. 2.9 mm to Max. 3.2 mm.
- 4.0 Supply Condition:** To be supplied in 3-5 M long pieces. Rust preventive coating will be on OD only, after plugging the end caps. RP oil is not allowed inside the tube.
- 5.0 Packing:** All tubes shall be packed in a standard Hessian cloth to avoid transit and handling damages and each packing shall weigh 50 Kg for easy handling.
- 6.0 Test Certificates:**
- Detailed correlated Test Certificates in English, to be submitted along with the supply, for the tests conducted as required in the respective specification and in this TDC.
- 7.0** BHEL reserves the right to carry out tests and to reject the items wherever non-conformance to the contract is noticed.

Rev No	Date	Revision details
00	15 07 95	Totally reviewed and re-issued.
01	14 03 96	Clause 7.3 detailed & Clause 7.4 & 7.5 renumbered.
02	15 05 02	Totally reviewed and re-issued.
03	08 12 15	Material DIN 1630 ST 37.4 added as per the NCR Ref:No: RMS / 56/007/ Dt 20/11/15 & 2.1 added based on the feed back from QC (Proc)

Prepared by 	Reviewed by	Signature	Approved by  (Head/QA)
	ENGG(AQCS)		
	Material Planning		
	Purchase		
	QC(Proc)		
	QA		
Issued by		QUALITY ASSURANCE	