

PSGSG131, REV-01	Product Specifications For CONTACTS & SHIELD		Drg. No.	
			Date	03-07-2020
			Product	GSM 420
1.0	Application : Switching Contacts for Gas Insulated Switchgear Equipment			
2.0	Configuration : 1. Sintered W-Cu (70-30 %), welded (by electron Beam welding process) to the high conductivity copper-Cr alloy.			
3.0	2. Machined to drawing dimensions.			
3.0	Quantity a. ARCING CONTACT-II : 15 pcs.			
4.0	Specifications:			
	1.Dimension Drawings: a. ARCING CONTACT-II : 35027600260			
	2. Material : Tungsten-Copper			
	(a). W-Cu			
	A sintered matrix of W-Cu (70-30 %) shall be produced by PM technique. The sintering shall be carried out in neutral or reducing atmosphere. The ingredient (powders) shall have high purity.			
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PSGSG131	Product Specifications For DS SWITCHING CONTACTS	Drg. No.	
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5.0	Electron Beam Welding (EBW): The component shall be finished to size before electron beam welding at the interface. The interface will be between High conductivity copper- Cr alloy and W-Cu Tip. The interface shall be welded to full depth. The welding joint between Cu-Cr alloy and W-Cu tip shall exhibit minimum contact resistance. The Component shall be free from dirt, grease and loose particles.		
6.0	Tests: (a). Dimensional: All dimensions shall comply to drawing measures.		
7.0	Packing: The contacts shall be packed in high density cardboard boxes, with a primary wrapped in polyethylene and packed individually in dust free boxes after degreasing. The component shall be guaranteed against all manufacturing defects.		
8.0	General: 1. Surface finish of the components shall be at least RA 1.6. 2. The component shall be free from dirt, grease and loose particles. In case of doubts in drawings or specifications the supplier shall contact BHEL for clarifications.		
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