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PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)

FF 05069 Rev 1

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NITRIDED L.C FERRO CHROMIUM

1. SCOPE:

This specification governs the quality of **Nitrided L.C Ferro Chromium** with the following requirements.

2. APPLICATION:

The material shall be used as an alloying addition for manufacturing of steel.

3. CONDITION OF DELIVERY:

The material shall be supplied in 10-50 mm size. However oversized shall not exceed 10% by weight and undersized material shall not exceed 15% by weight.

4. COMPLIANCE WITH NATIONAL STANDARDS:

The material in general shall conform to Indian standards specification IS 1170-1992;
Grade: **Fe Cr 64 N 300**

5. FREEDOM FROM CONTAMINATION:

The material shall be free from extraneous contamination such as slag.

6. CHEMICAL COMPOSTION:

The material shall conform to the following chemical composition when it is analyzed in Accordance with IS: 1559-1961/or any other international standards /instrumental analysis traceable to international standards.

ELEMENT	% MIN	%MAX
Chromium	60	67
* Nitrogen	2.0	-
Silicon	-	1.0
Carbon	-	0.10
Sulphur	--	0.05
Phosphrous	-	0.05
Aluminum	-	0.1

- **Actual Percentage of Nitrogen to be reported.**

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			PREPARED : SMS TECH	ISSUED : Steel Melting Shop	DATE :



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7. SAMPLING AND METHOD FOR CHEMICAL ANALYSIS:

Each batch of the material shall be sampled in accordance with IS 1472: 1977. All the test results are to be rounded off as per IS 2-1960.

8. INSPECTION

- CFFP reserves the right to witness the testing of the material at supplier works and therefore the supplier shall notify the readiness of the material in advance.
- CFFP may test the material after receipt on random sample basis and acceptance of the material will be based on the CFFP's test results. *In case of any dispute in chemical analysis referee method shall be IS.*
- For any deviation from this specification prior approval shall be taken by the supplier.
- For result of analysis and properties of material the decision of CFFP shall be final and binding on the supplier.

9. TEST CERTIFICATES :

One Original and three copies of Test Certificate from the original manufacturer packing containing the following information should be provided.

- Manufacturer's Name
- Name of the material
- Batch/Lot No.
- Lot Size
- Packing Size details
- Date of manufacturing
- All parameters mentioned in Clause 3, 5, and 6.

Note:

- A manufacturer supplying directly to BHEL should include BHEL's P.O. No. and Challan No. also in the TC.
- Any other supplier should provide a covering letter along with original Manufacturer's TC as above mentioning BHEL's P.O. No. and Challan No.

10. PACKING AND MARKING:

Packing should be such as to prevent loss / deterioration in quality during handling, transport and storage and should be in the **original manufacturer's packing**. Each package should be marked with the following details.

- Name of the material
- Manufacturer's Name / Trade mark
- Batch/Lot No.
- Net weight.
- Date of manufacture.
- Packing Size details.

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REVISION RECORD SHEET

SN.	Revision No.	Revision date	Nature of Changes
1	01	25/12/2017	<ul style="list-style-type: none"> • Clause no-6: analysis with international standard/ instrumental analysis traceable to international standard added. • Higher limit of Nitrogen removed.

ISSUED BY:	SMS	WORKED	M.K.SAHU 
REVISION	DATE: 15/12/2017	CHECKED	B K BEDI 
AGREED	PLANT PUR. SPEC.COMMTTEE	APPROVED	P.P.S.C.