



PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)

FF 05009 Rev 07

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FERRO MOLYBDENUM

1. SCOPE

This specification governs the quality of Ferro Molybdenum with the following requirements.

2. APPLICATION

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

3. CONDITION OF DELIVERY

The size should be in the range of 10-50 mm. However oversized material should not exceed 10% by weight and undersize material should not exceed 5% by weight.

4. COMPLIANCE WITH NATIONAL STANDARDS

The specification in general is based on Indian standards specification IS 1469-1993 (Reaffirmed 1999); Grade: FeMo63C10.

5. FREEDOM FROM CONTAMINATION

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

6. CHEMICAL COMPOSITON

The material shall conform to the following chemical composition when it is analyzed in accordance with IS:12614 or equivalent international standard /instrumental analysis traceable to International standard.

The sampling shall be done as per IS: 1472.

ELEMENT	% MIN	%MAX
Carbon	-	0.10
Molybdenum	60	65
Silicon	-	2.0
Sulphur	-	0.10
Phosphorus	-	0.05

RMI	ARUN AGARWAL		WORKED BY	M.K.SAHU	
MPIC	ROHIT VARSHNEY		CHECKED BY	B K BEDI	
CHAIRMAN CPSC	G M VERMA		APPROVED BY	RANJAN KUMAR	
			APPROVED : PLANT STANDARDS COMMITTEE		
			PREPARED : SMS TECH	ISSUED : Steel Melting Shop	DATE : 13-09-18



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7. INSPECTION AT SUPPLIER'S WORKS:

- 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.
- If any specific inspection requirements are written in purchase order, the same shall be applicable.
- CFFP may, at its discretion, test the material after receipt and acceptance of the material will be based on the CFFP'S test results.
- For result of analysis and properties of material the decision of CFFP shall be final and binding on the supplier.

8. TEST CERTIFICATES

One Original and three copies of Test Certificate from the **Manufacturer** containing the following information **along with test result of clause 3,5 and the chemical composition as per clause 6** should be provided.

Manufacturer's Name

Name of the material

Batch/Lot No.

Lot Quantity.

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.

9. PACKING AND MARKING

The material shall be packed in **tamper proof metallic drum** such as to prevent loss/deterioration in quality during handling, transportation and storage. Preferred packing size shall be 50 Kg drums however drums with weight up to 250 Kg will be acceptable with 5 packs of 50 kg each in one drum. It should be in the manufacturer's packing. Each drum should be marked with the following details.

Name of the material

Manufacturer's Name / Trade mark

Batch/Lot No.

Net weight.

10. REFFERED STANDARDS

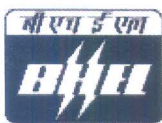
IS: 1469 -1993, IS: 12614, IS: 1472 and AA 11311 (Corporate specification BHEL)

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REVISION RECORD SHEET

SN	Revision No.	Revision date	Nature of Changes
01.	04	07.09.2009	-Clauses 8 and 9 revised incorporating requirement of manufacturer's packing and Test certificate.
02	05	30.07.2010	- Clause 3: Size range redefined. - Clause 6: Testing and sampling shall be done as per IS 12614 & 1472. Limit for Sulphur content has been increased from 0.05% to 0.10%. - Clause 8: Clause 5 included in the T.C. - Clause 9: Size of the pack and tamper proof metallic drum incorporated as per SP-0612 dated 11.03.2010. -Clause 6: Analysis with international standard /instrumental analysis traceable to international standard added.
03	06	14.08.2017	
04	07	12/09/2018	-Clause 9: Preferred packing size shall be 50 Kg drums however drums with weight up to 250 Kg will be acceptable with 5 packs of 50 kg each in one drum.

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