



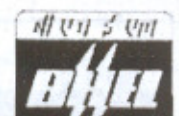
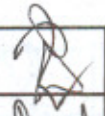

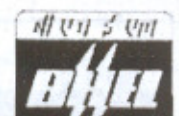
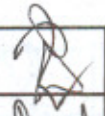

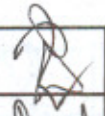

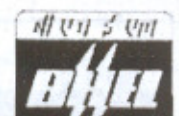
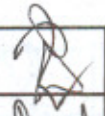

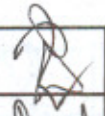

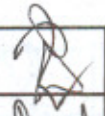




हस्ताक्षर एवं तिथि SIGNATURE & DATE			संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हरिद्वार) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		FF77185 Rev 05 पृष्ठ का Page 1 of 4																																											
	GOUGING ELECTRODE FOR USE IN FOUNDRIES CONTROLLED COPY - 2																																															
सुपरसेड्स INVENTORY NO. सामग्री सूची संख्या को अधिकृत करता	1. General: This specification covers the requirement of gouging electrodes for use in Steel Foundry.																																															
	2. Application: The gouging electrode will be used for removal of metal/localised defects from casting maintained in temperature range of 30°C to 350°C with the help of Gouging arc holder.																																															
COPYRIGHT AND CONFIDENTIAL The information on this documents is the property of Bharat Heavy Electrical Limited It must not be used directly or indirectly in any way detrimental to the interest of the company	3. Compliance with national standard: There is no national standard available for this item.																																															
	4. Properties: 4.1 Size : Diameter 9 mm X length 350 mm Diameter 12 mm X length 350 mm Diameter 18 mm X length 430 mm Tolerance on Diameter shall be +1 mm / -0.2 mm and on length will be ±2 mm. 4.2 Density: 1.65 gm/cc ± 0.1 without copper coating. 1.90 gm/cc ± 0.1 with copper coating. 4.3 Specific Resistance: 2.5x10 ⁻³ ohm-cm max. without copper coating. 4.0x10 ⁻⁴ ohm-cm max. with copper coating. 4.4 Chemical Composition: Fixed Carbon content : 98% minimum Ash: 2% maximum 4.5 Electrode should be able to work with air pressure of 5-8 kg/cm ² . 4.6 The gouging electrode should have copper coating of thickness 0.25 ± 0.05 mm, with smooth finish. The copper coating should not have any crack/discontinuity.																																															
स्वतंत्रताधिकार एवं गोपनीयता इस प्रलेख में सूचना भारत हेतु इलेक्ट्रिकल्स की सम्पत्ति है इसका प्रयोग एवं अप्रत्यक्ष रूप से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हानिकारक हो न किता जाए।	<table border="1"> <tr> <td>RMI</td> <td>SN GHOSH</td> <td>अनुवादक</td> <td>TRANSLATED BY</td> <td></td> <td></td> </tr> <tr> <td>MPIC</td> <td>SHYAM BABU</td> <td>निर्माणकर्ता</td> <td>WORKED BY</td> <td>T DAVE</td> <td></td> </tr> <tr> <td>CHAIRMAN CPSC</td> <td>KB SUBRAMANYAM</td> <td>जांचकर्ता</td> <td>CHECKED BY</td> <td>VK AGARWAL</td> <td></td> </tr> <tr> <td>सहमत विभाग AGREED DEPTT</td> <td>नाम NAME</td> <td>खतबोंक एवं हस्ताक्षर DATE & SIGNATURE</td> <td>पर्यवेक्षणकर्ता SUPERVISED BY</td> <td>AFC</td> <td></td> </tr> <tr> <td colspan="3"></td> <td colspan="3"> स्वीकृति : संस्थान मानक समिति APPROVED : PLANT STANDARDS COMMITTEE </td> </tr> <tr> <td colspan="3"></td> <td colspan="3"> निर्माण : जारी : फाउण्ड्री टेक्नालॉजी PREPARED : FOUNDRY TECH ISSUED : FOUNDRY TECHNOLOGY </td> </tr> <tr> <td colspan="3"></td> <td colspan="3"> तिथि : DATE 31.8.09 </td> </tr> </table>						RMI	SN GHOSH	अनुवादक	TRANSLATED BY			MPIC	SHYAM BABU	निर्माणकर्ता	WORKED BY	T DAVE		CHAIRMAN CPSC	KB SUBRAMANYAM	जांचकर्ता	CHECKED BY	VK AGARWAL		सहमत विभाग AGREED DEPTT	नाम NAME	खतबोंक एवं हस्ताक्षर DATE & SIGNATURE	पर्यवेक्षणकर्ता SUPERVISED BY	AFC					स्वीकृति : संस्थान मानक समिति APPROVED : PLANT STANDARDS COMMITTEE						निर्माण : जारी : फाउण्ड्री टेक्नालॉजी PREPARED : FOUNDRY TECH ISSUED : FOUNDRY TECHNOLOGY						तिथि : DATE 31.8.09		
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सुपरसेड्स INVENTORY NO. सामग्री सूची संख्या को अधिकतम करता	<div style="text-align: right; color: cyan; font-style: italic;">CONTROLLED COPY</div> <p>6. Acceptance:</p> <p>The material can be accepted on the basis of TC/GC for the supplier who has supplied the material continuously for 2 years troublefree service. However, testing shall be done on surveillance basis.</p> <p>In case of other suppliers, testing as per Cl. No. 4 and sample approval will be additional.</p>				
COPYRIGHT AND CONFIDENTIAL The information on this documents is the property of Bharat Heavy Electrical Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company	<p>7. Marking</p> <ul style="list-style-type: none"> (a) Each electrode should bear supplier's name, trademark, if any and size near the holding end together with batch no. (b) The supply should have BHEL PO No. (c) TC and GC (d) Date of manufacturing and Lot No. <p>8. Inspection, Deviation and Replacement:</p> <p>7.1 BHEL reserves the right to inspect material at site before despatch. The supplier shall intimate in advance about readiness of material enclosing a copy of test certificate of the material offered for inspection. However inspection at BHEL shall be final. The supplier shall offer BHEL representative all reasonable test facilities without charge to satisfy the latter that the material being furnished is in accordance with this specification. The supplier shall prepare and provide necessary test specimens for testing to be carried out at his premises. If facilities are not available at his works, the supplier shall make necessary arrangements for carrying out the prescribed tests elsewhere.</p> <p>7.2 If the material received at CFFP is not found in accordance with the requirements, it shall be liable to be rejected and the supplier will have to replace it free of cost at the earliest.</p> <p>7.3 For any deviation from the specification sought by the supplier, prior approval of BHEL must be obtained in writing.</p>				
स्वत्वाधिकार एवं गोपनीयता इस पृष्ठ पर सूचना आता है की हरिद्वार के श्रमिकों के अलावा अन्य कर्मियों को इस दस्तावेज का उपयोग नहीं करना चाहिए। कम्पनी के हित में हरिद्वार को ही दे दिया जाए।					
हस्ताक्षर एवं दिनांक SIGN & DATE					
सामग्री सूची संख्या			निर्माणकर्ता WORKED BY	T DAVE	
			जांचकर्ता CHECKED BY	VKA	

दिनांक एवं हस्ताक्षर SIGN & DATE	SUPERSEDES INVENTORY NO	सामग्री सूची संख्या or आवधिकार संख्या	COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electrical Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.	स्वतंत्राधिकार एवं गोपनीयता इस दस्तावेज पर सूचना भारत भारती लिमिटेड की संपत्ति है। इसका प्रयोग एवं प्रसारण केवल ही भारती लिमिटेड द्वारा ही किया जा सकता है। अन्यथा इसका प्रयोग करने से भारती लिमिटेड को नुकसान हो सकता है।	हस्ताक्षर एवं दिनांक SIGN & DATE	सामग्री सूची संख्या	<table border="1"> <tr> <td data-bbox="183 156 457 312">  </td> <td data-bbox="457 156 1260 312"> संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हरिद्वार) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR) </td> <td data-bbox="1260 156 1587 312"> FF 77185 Rev 05 पृष्ठ 3 का 4 Page 3 of 4 </td> </tr> <tr> <td colspan="3" data-bbox="183 312 1587 351"> 8 Test Certificates: </td> </tr> <tr> <td colspan="3" data-bbox="183 351 1587 972"> <p>8.1 Unless otherwise specified, one original and three copies of original manufacturer's test certificates shall be supplied with each consignment bearing the following information. In order to facilitate quick clearance of material, the supplier shall ensure to send a copy of test certificate along with despatch document.</p> <ul style="list-style-type: none"> a. BHEL PO No. with Date b. Specification No. c. Supplier reference / trade mark d. Identification No. / Batch No. e. Properties as per Clause 4 f. Date of manufacture g. Any other specific information which the supplier would like to convey. <p>8.2 Suppliers other than the original manufacturer shall ensure providing original manufacturer's test certificates with linkage to supplier's invoice stating the batch No., lot No., etc of the supply.</p> </td> </tr> <tr> <td colspan="3" data-bbox="183 972 1587 1011"> 9 Packing and Marking: </td> </tr> <tr> <td colspan="3" data-bbox="183 1011 1587 1236"> <p>The electrodes should be supplied in original manufacturer's packing, suitably in paperboard box after encased in polythene sheet. These paper board boxes should be housed in cardboard carton to avoid any damage during handling, transit and storage.</p> </td> </tr> <tr> <td colspan="3" data-bbox="183 1236 1587 1945"> </td> </tr> <tr> <td colspan="3" data-bbox="183 1945 1587 2063"> <table border="1"> <tr> <td data-bbox="183 1945 457 2004"> निर्माणकर्ता WORKED BY </td> <td data-bbox="457 1945 784 2004"> T DAVE </td> <td data-bbox="784 1945 1587 2004">  </td> </tr> <tr> <td data-bbox="183 2004 457 2063"> जांचकर्ता CHECKED BY </td> <td data-bbox="457 2004 784 2063"> VKA </td> <td data-bbox="784 2004 1587 2063">  </td> </tr> </table> </td> </tr> </table>		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हरिद्वार) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF 77185 Rev 05 पृष्ठ 3 का 4 Page 3 of 4	8 Test Certificates:			<p>8.1 Unless otherwise specified, one original and three copies of original manufacturer's test certificates shall be supplied with each consignment bearing the following information. In order to facilitate quick clearance of material, the supplier shall ensure to send a copy of test certificate along with despatch document.</p> <ul style="list-style-type: none"> a. BHEL PO No. with Date b. Specification No. c. Supplier reference / trade mark d. Identification No. / Batch No. e. Properties as per Clause 4 f. Date of manufacture g. Any other specific information which the supplier would like to convey. <p>8.2 Suppliers other than the original manufacturer shall ensure providing original manufacturer's test certificates with linkage to supplier's invoice stating the batch No., lot No., etc of the supply.</p>			9 Packing and Marking:			<p>The electrodes should be supplied in original manufacturer's packing, suitably in paperboard box after encased in polythene sheet. These paper board boxes should be housed in cardboard carton to avoid any damage during handling, transit and storage.</p>						<table border="1"> <tr> <td data-bbox="183 1945 457 2004"> निर्माणकर्ता WORKED BY </td> <td data-bbox="457 1945 784 2004"> T DAVE </td> <td data-bbox="784 1945 1587 2004">  </td> </tr> <tr> <td data-bbox="183 2004 457 2063"> जांचकर्ता CHECKED BY </td> <td data-bbox="457 2004 784 2063"> VKA </td> <td data-bbox="784 2004 1587 2063">  </td> </tr> </table>			निर्माणकर्ता WORKED BY	T DAVE		जांचकर्ता CHECKED BY	VKA	
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		PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)		पृष्ठ का Page 4 of 4	
SUPERSEDES INVENTORY NO	RECORD OF CHANGES <i>CONTROLLED COPY</i>				
सामग्री विवरण	REV CODE	NO. OF CHANGES	Nature of change	SIGN	DATE
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electricals Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.	02	1	Format changed. Technical details introduced.		15.3.01
	03	1	Technical details modified		25.06.01
	04	1	Tolerance on diameter of rod was ± 0.2 mm		19.5.09
	05	2	Clauses 8 & 9 modified to introduce original manufacturer's TC and packing conditions.		31.8.09
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	STANDARD SECTION		✓		
	MPIC		✓		
सामग्री वृत्ति विवरण				निर्माणकर्ता WORKED BY	T DAVE
				जांचकर्ता CHECKED BY	VKA