



PLANT PURCHASE SPECIFICATION

(CFFP - HARDWAR)

FF 05005 Rev 06

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HIGH CARBON FERRO MANGANESE

1. SCOPE

This specification governs the quality of High carbon Ferro Manganese 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 50-150 mm. However oversized material should not exceed 10% by weight and undersized material should not exceed 15% by weight.

4. COMPLIANCE WITH NATIONAL STANDARDS

The specification in general is based on Indian standards specification IS 1171-1996; Grade: FeMn76.

5. FREEDOM FROM CONTAMINATION

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

6. CHEMICAL COMPOSITION

The material shall conform to the following chemical composition when it is analyzed in accordance with IS: 1559 or equivalent international standard/instrumental analysis traceable to International standard. Composite sample shall be prepared by drawing samples from each consignment of 1000Kg or part thereof.

ELEMENT	% MIN	%MAX
Carbon	6.00	8.00
Manganese	74	78
Silicon	-	1.5
Sulphur	-	0.05
Phosphorus	-	0.35

Trace elements are for information purpose only.

The test results are to be rounded off as per IS 2-1960 (reaffirmed 2000).

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PREPARED : SMS TECH				ISSUED : Steel Melting Shop	DATE



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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 at CFFP on random basis 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.

• TEST CERTIFICATES

One Original and three copies of Test Certificate from the **Manufacturer in English** 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

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.
Supplier shall give the packing detail of material in the guarantee certificate.

9. PACKING AND MARKING

The material shall be packed such as to prevent loss / deterioration in quality during handling, transport and storage. It should be in the manufacturer's packing. Each package should be marked with the following details.

Name of the material

Manufacturer's Name / Trade mark

Net weight.

10. REFFERED STANDARDS

IS: 1171, IS: 1559

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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	24.12.2010	- Clause 3: Redefined. - Clause 6: Sampling for testing of material for chemical analysis will be done as per this specification. - Clause 8 & 9: Batch no and lot no removed.
03	06	14.08.2017	- Clause 6: equivalent international standard/instrumental analysis traceable to international standard added.

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