
 TD219 Rev.00	<b>PLANT PURCHASING                  SPECIFICATION                  HYDERABAD</b>			<b>HY 105 67</b>	
				REV. NO. 03	
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<b>HIGH YIELD STRENGTH QUENCHED AND TEMPERED                  ALLOY STEEL PLATE, SUITABLE FOR WELDING</b>					
<b>( ORDERING DESCRIPTION OF ASTM A 514 OR EN 10025-6 Gr. S690 QL1 )</b>					
<b>1.0 GENERAL:</b>					
This specification governs the quality aspects of alloy steel plates in quenched and tempered condition with the following additional requirements. The supplier has the option of supplying material as per latest version of ASTM A514 or EN 10025-6 Gr. S690 QL1 meeting the requirements of this specification.					
<b>2.0 APPLICATION:</b>					
For Gas Turbine components, like support legs etc.					
<b>3.0 CONDITION OF DELIVERY:</b>					
The plates shall be supplied in hot rolled quenched and tempered condition.					
<b>4.0 COMPLIANCE WITH NATIONAL / INTERNATIONAL STANDARDS:</b>					
This specification is based on ASTM A514 or equivalent German standard EN 10025-6 Gr. S690 QL1.					
Note: (1) The supplier may quote their equivalent grade which shall be capable of meeting the requirements of this specification also.					
(2) In case, the suppliers quote their own equivalent grade, the complete details of the properties (like chemical & mechanical) of their grade with further processing methods like welding, bending and heat treatment characteristics shall also be specified alongwith their technical offer. BHEL reserves the right to accept or reject the offer based on technical suitability for intended applications of the material.					
<b>5.0 DIMENSIONS AND TOLERANCES:</b>					
5.1 Dimensions shall be as per purchase order.					
<b>Revisions:</b> Reference of EN 10137 is deleted and EN 10025-6 is added.			<b>Issued :</b> STANDARDS ENGINEERING & IPR COORDINATION DEPARTMENT		
<b>Rev.No. 03</b>	<b>Amd. No.</b>	<b>Reaffirmed</b>	<b>Prepared:</b> MANAGER, MATLS. ENGG.	<b>Approved:</b> GM (E&CC)	<b>Dt.of 1<sup>st</sup> Issue</b>
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5.2	Tolerances shall be as per ASTM A6 or any other equivalent reputed International standard.		
6.0	<b>ULTRASONIC TESTING:</b>  All plates shall be subjected to 100% ultrasonic testing as per ASTM A435.		
7.0	<b>INSPECTION AT SUPPLIER'S WORKS:</b>  BHEL's representative shall have all reasonable facilities afforded to him to satisfy himself that the material is being furnished in accordance with this specification. Test shall be witnessed at supplier's works by BHEL or consultant's representative and in such cases the supplier shall notify those concerned when the material is available for inspection and testing.		
8.0	<b>TEST CERTIFICATION:</b>  Five copies of the test certificate with the following details shall be furnished.  a) BHEL Order No. b) HY 10567 Rev.03 c) Name of the Mill d) Size and Weight e) Heat No. f) Results of Chemical analysis g) Results of Mechanical properties tests. h) Results of ultrasonic tests. i) Details of heat treatment cycles followed.		
9.0	<b>MARKING AND PACKING:</b>  Shall be as per ASTM A514 or EN 10025.		

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