



**PLANT PURCHASING
SPECIFICATION
HYDERABAD**

HY10591

REV. NO: 02

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**HIGH STRENGTH LOW-ALLOY STEELS OF STRUCTURAL QUALITY
(ORDERING DESCRIPTION)**

1.0 GENERAL:

The material shall conform to the latest version of IS 8500 Gr. Fe 490 or EN 10025 Grade S355 JR and comply with the following additional requirements.

2.0 APPLICATION:

These sections, particularly wide flange beams are used in fabricating the mast and sub-structure of Oil Rigs.

3.0 CONDITION OF DELIVERY:

Fully killed and hot rolled.

4.0 DIMENSIONS AND TOLERANCES:

4.1 Sizes: Beams shall be supplied to the dimensions specified on the order. Unless otherwise specified they shall be supplied in lengths of 40 ft.

4.2 Tolerances: Tolerances and general requirements shall be as per IS 8500 or EN 10025.

5.0 TEST CERTIFICATE:

5.1 Five copies of the certificate giving the following details shall be furnished.

- a) BHEL Order No.
- b) HY10591 / Rev.02
- c) Name of supplier
- d) Consignment or identification no.
- e) Results of mechanical tests
- f) Results of chemical tests

5.2 The test certificate shall be signed by the Chief of quality / Chief Metallurgist of the supplier and BHEL representative.

Revisions: Converted to ordering description as per IS 8500 or EN 10025.

Issued :
**STANDARDS ENGINEERING
DEPARTMENT**

Rev.No. 02

Amd No.

Reaffirmed

Prepared:

Approved:

Date:

Dt. AUG. 05

Dt.

Year:

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**AGM
(GENERATION)**

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6.0 MARKING:

The following shall be legibly stamped / marked on each section.

1. HY10591 Rev.02
2. BHEL Order No.
3. Consignment or identification no.
4. Cast no.
5. Size & length (Eg. W8 x 5 1/4 x 18, 40 ft)
6. Weight
7. Supplier's name

7.0 REJECTION & REPLACEMENT:

In the event of the material proving defective in the course of further processing at BHEL, the same shall be rejected notwithstanding any previous acceptance.

The supplier shall replace the material at his own cost and the rejected material shall be returned after all the commercial conditions are satisfied.