



BHARAT HEAVY ELECTRICALS LIMITED
PIPING CENTRE, MADRAS-600017

Title : Technical Delivery Condition for screwed and socketed
ERW/CW/Seamless Galvanised pipes to IS 1239 (Part I)

Specification No : TDG:02:0

Project : All

Material : As per IS 1239

Equipment : Pipes

Accepted by:

Engineering *N. M.*
Materials *M. M.*
Management *M. M.*
OP&C *R. V.*

	Date/Initial/Dept.	Rev. 1	Rev. 2	Rev. 3	Rev. 4	Rev. 5	Rev. 6
	15.06.93						
Revised by	<i>m. j. m.</i>						
Approved by	<i>A. S. S.</i>						
Distribution :.							
Piping Centre	Quality Assurance Department			Page 1 of 3			

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**TECHNICAL DELIVERY CONDITIONS FOR SCREWED AND
SOCKETED ERW / CW / SEAMLESS GALVANISED
PIPES TO IS:1239 (PART-I)**

TDG:02:0

Dt.15.06.93

1.0 SCOPE

- 1.1 This Technical Delivery Condition specifies requirements in addition to IS:1239 (Part-I) for the supply of mild steel galvanised, screwed and socketed ERW/CW/Seamless pipes.
- 1.2 The grade, size and quantity shall be as specified in the purchase order.
- 1.3 Other applicable standards are IS:4736 and 4740.

2.0 DIMENSIONAL TOLERANCES

- 2.1 The length specified in the purchase order is the length of the tube excluding the socket.
- 2.2 The pipe and socket shall comply with dimensional tolerances specified in IS 1239 (Part-I).

3.0 MECHANICAL TEST

- 3.1 The elongation percentage shall be a minimum of 20%.

4.0 ZINC COATING

- 4.1 Quality of zinc, weight of the zinc coating and uniformity of galvanised coating shall be as per IS 4736.

5.0 MARKING

- 5.1 Tube diameter, thickness and length shall be stenciled on all the tubes.

6.0 CERTIFICATES

- 6.1 Three original test certificates typed in English shall be given along with tubes.
- 6.2 The test certificate shall furnish the following details :
- a. Purchase Order reference.
 - b. Test Certificate number.
 - c. Specification and grade.
 - d. Size.

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- e. Cast/melt number.
- f. Chemical analysis.
- g. Mechanical test results.
- h. Hydraulic test pressure and results.
- i. Galvanised tube test results as per coating requirements of IS:4736.

6.3 The tubes shall be subjected to inspection by BHEL or authorities nominated by BHEL and the test certificates shall be countersigned by them.

7.0 PACKING

7.1 All quantities of tubes shall be packed as per IS:4740. A metallic plate giving particulars of the bundle shall be tied at each end of the bundle.