



BHARAT HEAVY ELECTRICALS LIMITED
PIPING CENTRE, MADRAS-600 017

Title : Technical Delivery Condition for ERW/CW/Seamless Pipes
and tubes to IS 1239 (Part I)

Specification No : TDG:03:0

Project : All

Material : As per IS 1239

Equipment : Pipes

Accepted by

Engineering *Nymer*
Materials *M. Palanish*
Management *M. Palanish*
CP&C *R. V. Ravi*

	Date/Initial/Dept. 15.06.93							
	Orig. Issue	Rev. 1	Rev. 2	Rev. 3	Rev. 4	Rev. 5	Rev. 6	
Revised by	<i>M. Palanish</i>							
Approved by	<i>ABD</i>							
Distribution :								
Piping Centre	Quality Assurance Department				Page 1 of 3			

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**TECHNICAL DELIVERY CONDITIONS FOR ERW / CW /
SEAMLESS PIPES AND TUBES TO 1239 (PART-I)**

| TDG:03:0

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 ERW/CW/Seamless pipes and tubes.

1.2 The grade, size and quantity shall be as specified in the purchase order.

1.3 Other applicable standard is 4740.

2.0 MECHANICAL TESTS

2.1 The elongation percentage shall be a minimum of 20%.

3.0 MARKING

3.1 The diameter, wall thickness and length shall be stenciled on each tube.

4.0 CERTIFICATES

4.1 Three original test certificates typed in English shall be given along with the tubes.

4.2 The test certificate shall furnish the following details :

- a. Purchase Order reference.
- b. Test Certificate number.
- c. Specification and grade.
- d. Size.
- e. Cast/melt number.
- f. Chemical composition.
- g. Mechanical test results.
- h. Hydraulic test pressure and results.

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

5.0 PROTECTION AND PACKING

5.1 External surface of the tubes shall normally be coated with resin type translucent rust preventive. Prior approval from BHEL shall be obtained for any other surface coating.

TECHNICAL DELIVERY CONDITIONS FOR ERW / CW / : TDG:03:0
SEAMLESS PIPES AND TUBES TO 1239 (PART-I) :

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- 5.2 All quantities of tube shall be packed as per IS:4740 and
metallic plate giving particulars of the bundle shall be
tied at each end of the bundle.