



## CORPORATE PURCHASING SPECIFICATION

AA 101 19

Rev. No. 11

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### STRUCTURAL STEEL - WELDABLE QUALITY (PLATES, SECTIONS, STRIPS, FLATS AND BARS)

#### ORDERING DESCRIPTION

#### 1.0 GENERAL:

The material shall conform to the latest version of IS 2062, Grade. B or DIN EN 10025, Gr.: S275J2G3 and comply with following additional requirements. .

#### 2.0 APPLICATION:

For general engineering purposes, suitable for welding.

#### 3.0 CONDITION OF DELIVERY:

##### 3.1 Bars & Sections: Hot rolled in straight lengths without twists and bends.

##### 3.2 Plates:

Plates upto 12 mm thickness shall be supplied in as rolled condition. Plates above 12mm thickness shall be supplied in hot rolled, normalized or an equivalent condition obtained by normalizing rolling or controlled rolling.

All the plates shall be free from mill scales and suitably protected with rust preventative coatings at the time of supplies.

#### 4.0 DIMENSIONS AND TOLERANCES:

##### 4.1 Sizes:

Material shall be supplied to the dimensions specified in BHEL Order.

##### 4.2 Tolerances:

The tolerances on hot rolled material shall comply with IS:1852 or any other equivalent National standard.

##### 4.3 Straightness for hot rolled bars:

Unless otherwise specified, the permissible deviation in straightness shall not exceed 5 mm in any 1000 mm length.

#### 5.0 TEST SAMPLES :

##### 5.1 Tensile Test Pieces :

One tensile test sample shall be made from finished steel of each melt per size for each class of product viz. plates, sections, strips, flats and bars size of the product.

##### 5.2 Bend Test Pieces :

Bend test piece shall be made from finished steel of each melt per size of the product.

#### Revisions :

Cl: 27.3.g of MOM of MRC-S&GPS

#### APPROVED :

INTERPLANT MATERIAL RATIONALISATION  
COMMITTEE-MRC (S&GPS)

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Corp. R&D

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**6.0 ULTRASONIC EXAMINATION :**

Plates shall be ultrasonically examined in accordance with BHEL standard AA 085 01 20 (or ASTM-A 435) as detailed below and shall comply with the acceptance standards specified therein.

**6.1 For plates above 25mm and upto & including 63mm :**

Shall be ultrasonically tested when specially called for in order.

**6.2 For plates above 63mm thick :**

Shall be ultrasonically examined, unless otherwise specified in order.

**7.0 TEST CERTIFICATES:**

Unless otherwise specified, three copies of test certificates shall be supplied.

In addition, the supplier shall ensure to enclose one copy of the test certificate along with their dispatch documents to facilitate quick clearance of the material.

The test certificate shall bear the following information:

AA 101 19-Rev. No.11 / IS : 2062-Gr:B or DIN EN 100 25 Gr. S275J2G3, BHEL order No, Melt No, Size & Quantity, Batch No with heat treatment details, Results of Chemical analysis, Mechanical tests & NDT, Supplier's name, Identification No, TC No, Signature of Competent authority, etc.

**8.0. RUST PREVENTION:**

All the plates shall be protected with rust preventative coatings suitable for providing resistance from atmospheric corrosion during outside storage for at least six months.

**9.0. PACKING AND MARKING :**

Plates shall be transported suitably to avoid damage during transit.

Each plate shall be marked with Melt No. Material grade and specification, BHEL Order No, Supplier's Name Identification No, Size & weight, on any one corner and encircled with paint preferably of white colour.

**10.0 REJECTION AND REPLACEMENT**

If the material does not comply with the requirements of this specification during receipt inspection at BHEL or if any defect is found during further processing of material, BHEL reserves the right to reject the whole consignment and the supplier shall replace the material free of cost. The rejected material shall be taken back by the supplier after fulfilling the commercial terms and conditions.