



PLANT PURCHASING SPECIFICATION CFFP, BHIL - HARDWAR

FF-06003 / Rev. 01

Page 1 of 3

Date : 22.05.01

IRON POWDER FOR USE IN FOUNDRIES

1.0 General :

This specification governs the requirement of Iron-powder used in Foundry.

2.0 Application :

Used for cutting stainless steel castings and for removal of fused sand in Steel Foundry.

3.0 Compliance with National Standard :

There is no equivalent National Standard available.

4.0 Grain Size :

The grain size of the material shall be as under when determined by sieving using Indian Standard Sieves :

Sieve Size	% of iron powder retained on the sieve
+212 microns	0
+180 microns	2 (Max)
+ 45 microns	Balance
- 45 microns	25 (Max)

5.0 Chemical composition :

The material shall have the following composition :

Iron	-	99.00 % (Min)
Carbon	-	0.25 % (Max)
Phosphorous	-	0.02 % (Max)
Moisture	-	0.50 % (Max)

6.0 Properties :

Flow shall be Maximum 35 sec/ 50 gm.

7.0 Supply Condition :

The material shall be supplied in 20/25 Kg packings.

AGREED DEPT'S			WKD	KB Subramanyam	
RMI	NK Sahu		CHD	N Khan	
MPIC	KB Seed		SUP.	NG Srinivasan	
CHAIRMAN	KK Gupta		APPROVED:		
CPPSC			CFFP PLANT STANDARDS		
			COMMITTEE		
			ISSUED BY: FOUNDRY TECHNOLOGY DEPT.		

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PLANT PURCHASING SPECIFICATION
CFPP, BHEL - HARDWAR

FF-06003 Rev. 01
Page 2 of 3
DATE: 12.05.01



8.0 Sampling :

For each lot of 5 tons of supply, samples shall be taken from 5 different containers to make a composite sample for testing.

9.0 Acceptance Test :

Each consignment shall be accepted on the basis of test carried out as per clauses 4.0, 5.0 and shop trial. Phosphorous shall be checked on surveillance basis.

10.0 Test Certificate :

For every batch/lot the supplier shall give three copies of test certificate with details such as a) Supplier's name and address, b) BHEL P.O. No, c) Chemical composition and d) Grain size.

11.0 Inspection, Deviation and Replacement :

10.1 BHEL reserves the right to inspect the material at site before despatch. The supplier shall intimate BHEL in advance enclosing a copy of test certificate of the material offered for inspection.

10.2 Final tests shall be carried out at BHEL and will be final and binding on supplier.

10.3 If the material received is not found suitable according to the requirements, it shall be replaced free of cost by the supplier.

10.4 In case any deviation is required from this specification, the supplier may request for the same along with his offer. No deviation will be allowed by CFPP after placement of P.O.

12.0 Packing & Marking :

11.1 Packing shall be done in such a way as to prevent moisture pickup and damage during transit and storage.

11.2 Each container shall be clearly marked with the following information:

- | | | | |
|----|------------------------------|----|----------------------|
| a) | Supplier's name & trade mark | b) | BHEL P.O No. |
| c) | Batch No. | d) | Date of manufacture. |

WKD	KB Subramanyam	<i>[Signature]</i>
CRD	N Khan	<i>[Signature]</i>
SUP	NG Srinivasan	<i>[Signature]</i>

APPROVED:

CFPP PLANT STANDARDS
COMMITTEE

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PLANT PURCHASING SPECIFICATION

CFFP, BHEL - HARDWAR

FF-06003 Rev. 01

Page 3 of 3

DATE: 12.05.01



REVISION RECORD SHEET

Sl.NO.	Rev. NO.	Revision Date	Nature of Changes *
1	01	12.05.01	Changes made in Chemical Composition and Properties

*This indicates changes in the last revision only.

SFY

WKD	KB Subramanyam	<i>Subramanyam</i>
CHD	N Khan	<i>N Khan</i>
SUP	NG Srinivasan	<i>N Srinivasan</i>

APPROVED

CFFP PLANT STANDARDS
COMMITTEE

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