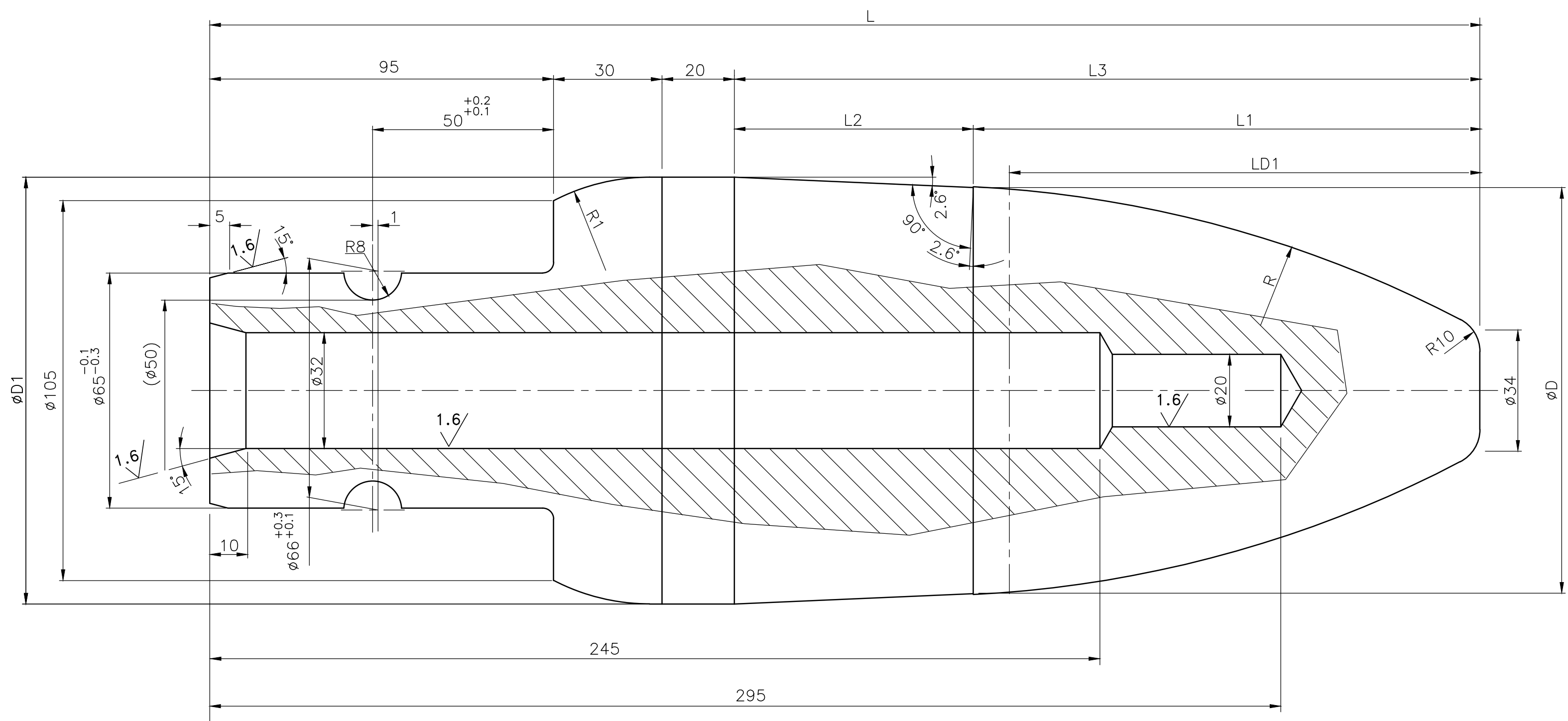


DEVIATIONS OF UNTOLERANCED
DIMENSIONS TO BE AS PER
IS:2102-1969 MEDIUM



Mechanical Properties

Room temperature properties (longitudinal direction)
Guaranteed values (ASTM A693 hot rolled plates).

Table 1

HEAT TREATMENT		Y.S. 0.2%		UTS		Elongation %
		MPa	ksi	MPa	ksi	
Hardening 496 °C (925 °F) 4 hours — air cooling	Min.	1070	155	1170	170	8
	Typ.	1207	175	1310	190	14
Hardening 593 °C (1100 °F) 4 hours — air cooling	Min.	790	115	965	140	10
	Typ.	931	135	1034	150	17

Chemical Analysis

Weight % (all values are maximum unless a range is otherwise indicated)

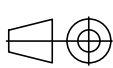
Chromium	15.0 min.–17.5 max.	Phosphorus	0.04
Nickel	3.0 min.–5.0 max.	Sulfur	0.03
Copper	3.0 min.–5.0 max.	Silicon	1.0
Carbon	0.07	Niobium plus Tantalum	0.15 min.–0.45 max.
Manganese	1.0	Iron	Balance

CHAMFER THE SHARP EDGES TO 0.3X45°

SL No.	øD	øD1	L	L1	L2	L3	R	R1	Wt(Kg)	MATERIAL CODE No.
01	112.01	118	351.19	140.19	66	206.19	324.73	114.50	16.8	6905123201
02	109.55	115	355.89	150.89	60	210.89	391.58	181.25	16.1	6905123202
03	109.55	112	371.72	166.72	60	226.72	507.64	46.41	15.9	6905123203

REV 01	DATE	ALTERED
		APPROVED

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ITEM NO	DESCRIPTION	DRAWING NO	17-4PH		UNIT WT
			MATL CODE		QTY
			MATL SPEC		
EQPT:					
 Bharat Heavy Electricals Ltd SEAMLESS STEEL TUBE PLANT TIRUCHIRAPALLI - 620014		DRN	NAME R.KUMAR	SIGNATURE <i>R. Kumar</i>	DATE 24.09.11
		CHD	N ARUMUGANAINAR	<i>N. A. Nainar</i>	
		APPD	S KARUPPASAMY	<i>S Karupphasamy</i>	
		REF TO ASSY DWG NO 10-ST-123-00-170(01)			
DEPT SSPT TE CODE 456	GRADE OF UNTOL. DIM $\phi / M / F$ IS: 2102		SCALE 1:1	WEIGHT (Kg) 15.9 TO 16.8	ITEM 01
TITLE MANDREL HEAD		CARD CODE	REF TO OLD DWG NO 20-ST-123-02-226		
			D101056-06.620-623		
			DRAWING NO : 20-ST-123-02-228B		REV 00

SN	PRE-QUALIFICATION CRITERIA	Vendor's confirmation
	The vendor should be a manufacturer/trader and should have completed supply of Piercer Plugs to any of steel rolling mills in Central/State/Govt organisation/PSU Company/ Public Listed company. The following Documental Evidence to be provided to qualify for the tender	
1	For Manufacturer the required facilities at his works as per drawing for carrying out the job	Submitted/Not Submitted
2	For Trader valid technical tie up with the sub-vendor and the required facilities as per drawing available with the sub-vendor for carrying out the job	Submitted/Not Submitted
3	Purchase order copy for Supply of Piercer Plugs to any of steel rolling mills in Central/State/Govt organisation/PSU Company/ Public Listed company after March 2017.	Submitted/Not Submitted
4	Supply completion proof (Delivery Challan/Tax Invoice/Payment Proof /Performance certificate) for the above Purchase order.	Submitted/Not Submitted
5	Test certificate for chemical analysis of the supplied plugs from Central Govt/ State Govt/ NABL/ILAC accredited lab for the above Purchase order.	Submitted/Not Submitted

Abhighna D

Digitally signed
by Abhighna D
Date: 2024.02.03
16:53:40 +05'30'