
		TD219 Rev. 00	PLANT PURCHASING SPECIFICATION HYDERABAD		HY 106 98	
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CHROMIUM - MOLYBDENUM ALLOY STEEL PLATES, Gr.: 12, CLASS 2, FOR PRESSURE VESSELS						
ORDERING DESCRIPTION FOR ASME SA 387, Gr.: 12, CLASS 2						
1.0 GENERAL:						
The plates shall conform to the latest version for ASME SA 387, Gr.: 12 Cl. 2.						
2.0 APPLICATION:						
For high temperature service at stress levels and temperatures allowed by ASME Boiler and Pressure Vessel Code, Section I and Indian Boiler Regulations for steam and water application. This material is also used for steam turbines components subjected to high temperatures during service						
3.0 DIMENSIONS:						
Plates shall be supplied as per dimensions specified in the order.						
4.0 HEAT TREATMENT:						
Plates shall be supplied in heat treated condition as per SA 387 - Gr. 12 Class 2.						
5.0 ULTRASONIC TEST:						
Ultrasonic examination and acceptance standards shall be as per ASME SA 578, level B or as per ASME SA 435.						
6.0 INSPECTION AT SUPPLIER WORKS:						
The representative of BHEL shall have free access to the supplier works at all times during the execution of the order, to satisfy himself that the material is procured as per the quality requirements of this specification. All reasonable facilities shall be extended to him, free of charge. He may also witness the sampling, testing and marking called for in this specification.						
Revisions:			Issued : STANDARDS ENGINEERING & IPR COORDINATION DEPARTMENT			
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7.0 MARKING:

7.1 Hard stamping of melt number, specification and grade, plate number and the inspection authority stamp on the plates along rolling direction and bordered by white paint.

7.2 Painting of purchase order number, melt number, specification number, size, net weight and BHEL on the plates and protected by transparent varnish coating.

7.3 Rust preventive coating for plates less than 20 mm thickness.

8.0 REPAIRS:

Fusion welding is prohibited.

When done by mechanical means, the specified thickness is to be met with and the surfaces to be smoothly dressed up from any sharp edges.

9.0 CERTIFICATION:

As per SA 387 Gr. 12 Class 2.

10.0 REJECTION AND REPLACEMENT:

In the event of any material proving defective during the course of preparation, machining, testing or erection such material shall be rejected notwithstanding any previous certification of satisfactory testing and / or inspection.