



# PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)

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## FERRO MOLYBDENUM

### 1. SCOPE

This specification governs the quality of Ferro Molybdenum with the following requirements.

### 2. APPLICATION

The material shall be used as alloying addition for manufacturing of alloy steel

### 3. CONDITION OF DELIVERY

The size should be in the range of 10-50 mm. However oversized material should not exceed 10% by weight and undersize material should not exceed 5% by weight.

### 4. COMPLIANCE WITH NATIONAL STANDARDS

The specification in general is based on Indian standards specification IS 1469-1993 (Reaffirmed 1999); Grade: FeMo63C10.

### 5. FREEDOM FROM CONTAMINATION

The material shall be free from extraneous contamination such as slag.

### 6. CHEMICAL COMPOSTION

The material shall conform to the following chemical composition when it is analyzed in accordance with IS: 12614. The sampling shall be done as per IS: 1472.

ELEMENT	% MIN	%MAX
Carbon	-	0.10
Molybdenum	60	65
Silicon	-	2.0
Sulphur	-	0.10
Phosphorus	-	0.05

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			APPROVED : <b>PLANT STANDARDS COMMITTEE</b>		
			PREPARED : SMS TECH	ISSUED : Steel Melting Shop	DATE : 30.07.10

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## 7. INSPECTION AT SUPPLIER'S WORKS:

- CFFP reserves the right to witness the testing of the material at supplier works and therefore the supplier shall notify the readiness of the material in advance.
- CFFP may, at its discretion, test the material after receipt and acceptance of the material will be based on the CFFP'S test results.
- For result of analysis and properties of material the decision of CFFP shall be final and binding on the supplier.

## 8. TEST CERTIFICATES

One Original and three copies of Test Certificate from the **Manufacturer** containing the following information **along with test result of clause 3,5 and the chemical composition as per clause 6** should be provided.

Manufacturer's Name

Name of the material

Batch/Lot No.

Quantity.

Note:

- a) A manufacturer supplying directly to BHEL should include BHEL's P.O. No. and Challan No. also in the TC.
- b) Any other supplier should provide a covering letter along with original Manufacturer's TC as above mentioning BHEL's P.O. No. and Challan No.

## 9. PACKING AND MARKING

The material shall be packed in **Tamper proof metallic drum** such as to prevent loss / deterioration in quality during handling, transport and storage. It should be in the manufacturer's packing. Each package should be marked with the following details.

Name of the material

Manufacturer's Name / Trade mark

Batch/Lot No.

Net weight.

## 10. REFFERED STANDARDS

IS: 1469 -1993, IS : 12614 , IS: 1472 and AA 11311 (Corporate specification BHEL)

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## REVISION RECORD SHEET

SN	Revision No.	Revision date	Nature of Changes
01.	04	07.09.2009	-Clauses 8 and 9 revised incorporating requirement of manufacturer's packing and Test certificate.
02	05	30.07.2010	<ul style="list-style-type: none"><li>- Clause 3: Size range redefined.</li><li>- Clause 6: Testing and sampling shall be done as per IS 12614 &amp; 1472. Limit for sulphur content has been increased from 0.05% to 0.10%.</li><li>- Clause 8: Clause 5 included in the T.C.</li><li>- Clause 9: Size of the pack and tamper proof metallic drum incorporated as per SP-0612 dated 11.03.2010.</li></ul>

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