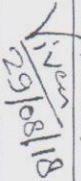
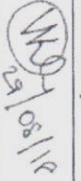

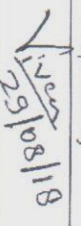
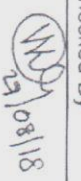

 Maharashtra Gas Pipeline Corporation <small>Established on 01.04.1974</small>		PLANT PURCHASE SPECIFICATION		No.	BHEL/FP/TS/46	
		FABRICATION PLANT		Rev. No.	01	
		DEPARTMENT: PRODUCTION		Rev. Dt.	29.08.18	
CSU & FP, Jagdishpur						
Technical Specification for Fuel Gas for Metal Cutting						
Sr.No.	Description	Requirement	Vendor to Furnish/Confirm	Offered	Deviation	Remark
1	General:					
1.1	Scope	This technical specification covers technical requirement of Fuel Gas for metal cutting.	Vendor to Confirm			
1.2	Application	The gas shall be used for Oxy Fuel Cutting of Carbon steel & low alloy steel of thickness upto 200 MM and preheating of welded assemblies.	Vendor to Confirm			
1.3	Equivalent	The gas shall have the properties equivalent to Bharat Metal Cutting Gas (BMCG) of M/s. BPCL./Indane Nano Cut of M/S IOCL as per below broad specification.	Vendor to Confirm			
1.4	Exclusion	Dissolved Acetylene and LPG Shall not be considered.				
2	Broad Specification					
2.1	Neutral Flame Temp. ($^{\circ}$ C)	2983	Vendor to specify			
2.2	Total heat Value (Kcal/ kg)	12030	Vendor to specify			
2.3	Heat Emission (Kcal/m ³)		Vendor to specify			
2.3.1	a. Primary Flame	4164	Vendor to specify			
2.3.2	b. Secondary Flame	19080	Vendor to specify			
2.4	Back fire Tendency	Low	Vendor to specify			
2.5	Toxicity	Low	Vendor to specify			
2.6	Explosive limit in Oxygen	2.4-57%	Vendor to specify			
2.7	Explosive limit in air	2.3-9.5%	Vendor to specify			
2.8	Normal Pressure in Cylinder	6-7 Kg/CM ²	Vendor to specify			
Signature		Prepared By	Checked By	Approved By		
		 29/08/18	 29/08/18	 29/08/18		
Name		Vivek Srivastava		V K Choudhary		Atul Verma
Designation		Dy. Engineer		Dy. Manager		Dy. Manager
Date of issue						

Sr.No.	Description	Requirement	Vendor to Furnish/Confirm	Offered	Deviation	Remark
3	Other Requirements:					
3.1	Gas Cylinder Manifold	Vendor to provide 2 nos. of gas cylinder manifold each having provision of 5 nos. cylinder connections fitted with regulators, connecting pipes and other fittings. Vendor to also supply 5 nos. spare of Pipe & Fittings for immediate maintenance. However, the regular maintenance of the same shall be also be done by the vendor time to time as per requirement.	Vendor to Confirm			
3.2	Supply Condition	The Gas shall be supplied in suitable size of cylinder as per applicable Gas Cylinder Rules 1981. The size shall be 19 kg/35 kg/50 Kg	Vendor to Confirm			
	Signature	Prepared By  29/08/18	Checked By  29/08/18	Approved By  29/08/18		
	Name	Vivek Srivastava	V K Choudhary	Atul Verma		
	Designation	Dy Engineer	Dy Manager	Dy Manager		
Record of revision: Typographical error in clause 2.6 corrected.						
	Date of issue					