



BHARATH HEAVY ELECTRICALS LIMITED
TIRUCHIRAPALLI-620 014
WELDING TECHNOLOGY CENTRE

Doc. Number:
WCPI - 113

Revision:
05

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Welding Consumable Purchase Instruction

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**WELDING CONSUMABLE PURCHASE INSTRUCTION FOR STRAIGHT
LENGTH COBALT BASE WELDING RODS FOR HARD SURFACING
(HAYNESS ALLOY - 25)**

1.0 SCOPE:

- 1.1 The rod shall confirm to the requirement of this specification and shall be supplied in quantities and sizes mentioned in the purchase order.

2.0 CHEMICAL COMPOSITION:

- 2.1 Specified chemical composition of the rod shall be as below:

Chemical Compound	Percentage (in %)
C	0.09-0.15
Mn	1.2 Max
Cr	18.00 - 21.00
Ni	9.00 -12.00
W	14.00 - 16.00
Fe	3.00 Max
Co	Balance

Other intentional additions shall be reported.

3.0 FINISH:

- 3.1 The rod shall be uniform quality and free from segregation, oxides, silvers, seams or other irregularities which would impair their usefulness.
- 3.2 Diameter shall not vary from the specified size by more than +/- 0.8mm.
- 3.3 The Wire shall be supplied in straight length of 1000mm +/- 20mm.

PREPARED:


(JIJO JOHNSON)
DY. MANAGER / WTC

APPROVED:


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4.0 PACKAGING AND IDENTIFICATION:

- 4.1 The rod shall be packed in cardboard tube or cartons.
- 4.2 Each carton shall not contain more than 5Kgs.
- 4.3 Each straight rod shall have at least one imprint of "Hayness Alloy-25".
- 4.4 Four cartons, the net weight not exceeding 20Kgs, shall be packed in a thick card board box facilitating easy transportation.

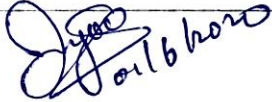
5.0 LABELLING AND NUMBERING:

- 5.1 All packages of filler metal or all individually packaged units enclosed with in a larger package shall carry labels containing the following information.
- a) Brand Name
 - b) Size
 - c) Batch Number
 - d) Net weight

6.0 TEST CERTIFICATE:

- 6.1 Test certificate shall be on standard format giving details of weld metal chemistry.
- 6.2 Individual Test Certificate shall be supplied for every batch of rods supplied.
- 6.3 Three copies of Test Certificate shall be mailed as specified in the purchase contract. An additional copy of this test report shall be supplied for each shipment of material.
- 6.4 Prior approval shall be obtained for any deviation to this purchase specification.

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