

EL1070101020



## PURCHASE SPECIFICATION FOR FERRITIC STAINLESS STEEL SHEETS FOR SCR APPLICATION

ISSUE NO : 06

DOC.NO: SCR-D-RM-001

REV : 01 JUN 2022

Page 1 of 2

**1.0 GENERAL:**

The sheet shall typically conform to the latest version of ASTM A 240M, TYPE 430 and equivalent Indian standards to comply with the following additional requirements.

**2.0 APPLICATION:**

Stainless Steel Sheet is intended for using as a base material for coating ceramic mass.

**3.0 CONDITION OF DELIVERY:**

Cold rolled, annealed and descaled (Finish number 2B), Suitable for deep drawing process.

Sheets shall be supplied in coil for as specified in BHEL order.

Sheets shall be flat and the edges cleanly sheared and truly squared to the specified dimensions.

Oils used for anti-corrosion measures should be free from pungent smell and should be non-hazardous in nature.

**4.0 DIMENSION AND TOLERANCES:**

Material to be manufactured with thickness of 0.25mm (as mentioned in BHEL tender) and width of max. 570 mm. Actual width will be specified in BHEL tender. tolerance is as given below

Parameter	Nominal Value (mm)	Tolerance on the nominal value (mm)
Thickness	0.25 mm	+0.015 / - 0.015
Width	570 mm	+1.00 / - 1.00

**Out of the square tolerance:** 1 percent of the width

**Camber:** Camber is the greatest deviation of an edge from a straight line, the measurement being taken on the concave side with a straight line. Camber tolerance is 10 mm in any 5000 mm length

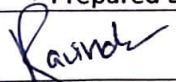
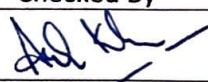
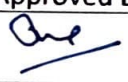
**5.0 CHEMICAL COMPOSITION:**

C	Si	Mn	Ni	Cr	S	P
≤ 0.12	≤ 0.75	≤ 1.0	≤ 0.75	16.0-18.0	≤ 0.03	≤ 0.04

**6.0 MECHANICAL PROPERTIES:**

HARDNESS (HV)	Yield Strength(N/mm <sup>2</sup> )	UTS (N/mm <sup>2</sup> )	% Elongation
≤ 200	≥ 205	≥ 450	≥ 22

**7.0 TEST SAMPLES:** One bend and one hardness test shall be carried out from each lot of 25MT or part there thereof, per melt per consignment. Chemical analysis to be carried out one sample per melt per consignment.

Issued By	Prepared By	Checked By	Approved By
SCR GROUP	 RAVINDER KUMAR	 ANKUR KHARE	 AJAY KUMAR SHARMA

Copyright and Confidential  
The information in this document is the property of Bharat Heavy Electricals Limited. It must not be used directly or indirectly in anyway detrimental to the interest of the company



EL1070101020



# **PURCHASE SPECIFICATION FOR FERRITIC STAINLESS STEEL SHEETS FOR SCR APPLICATION**

ISSUE NO : 06

DOC.NO: SCR-D-RM-001

REV : 01

JUN 2022

Page 2 of 2

## **8.0 TEST CERTIFICATES:**

Three copies of test certificates shall be supplied along with the following information:

### BHEL References:

SCR-D-RM-001, ASTM A 240M (Type 430) and equivalent Indian standards  
BHEL order No.

### Supplier's references:

Name:  
Identification No.  
TC No.  
Delivery Challan details  
Melt No.  
Size and Quantity  
Process of manufacture:  
Details of heat treatment:

### Results of Tests:

Dimensional inspection  
Results of chemical analysis, mechanical tests

## **9.0 Packing and Marking:**

### **PACKING:**

Sheet to be supplied in coiled form with 2000 kg per coil (maximum) and suitably packed to prevent damage during transit. Details of packaging and marking are as given below: However, other better methods of packing may be considered which shall be indicated in the techno-commercial offer for BHEL's acceptance.

- Internal diameter of the coils shall be 500 mm  $\pm$  20 mm.
- Coils shall be protected to prevent damage and rusting during transit. Sheet shall be horizontally packed (The cylindrical axis should be horizontal to the ground).
- Annular protection board shall be placed at both the ends of the coil.
- Coil should also be interleaved with anti-rust waterproof paper in the full length of coil.
- Coil then be covered by polyethylene sheet or anti-rust water-proof paper and the ends sealed properly.
- A galvanized sheet shall be wrapped on the outside of the coil on both ends of the coil. Care shall be taken to ensure that the ends extends sufficiently over the diameter of the coil.

Issued By

SCR GROUP

Prepared By

RAVINDER KUMAR

Checked By

ANKUR KHARE

Approved By

AJAY KUMAR SHARMA

*Copyright and Confidential*  
The information in this document is the property of Bharat Heavy Electricals Limited. It must not be used directly or indirectly in anyway detrimental to the interest of the company