

**Section VI A**  
**(Special Instructions)**

**C276, C276 clad & Titanium clad raw materials:**

**Machining/Shearing**

- Depth of cut and feed shall be appropriately set so that there are no Black Spots in the C276, C276 clad & titanium clad material. For example, preferably High Depth of cut and Low feed will ensure no black spots
- Shearing shall be done by tool capable of shearing the C276, C276 clad & titanium clad material.

**Heating, Pre heating and Post heating**

- Any kind of heating the C276, C276 clad & titanium clad raw material should not be done.

**Peel Off Operation**

- Manual grinding operation shall be adopted for peeling off the C276 clad & titanium clad from the clad raw material.
- Specialised Carbide tip grinding tool (for Eg Preferably Silicon Carbide Tip/Wheel) may be used.
- After grinding activity, finishing needs to be done using SS Wire Brush.

**Cutting**

- Gas Cutting activity should not be done for the C276, C276 clad & titanium clad raw material.
- Cutting shall be done by plasma cutting.

**Bending**

- Bending operation and Bending related tests are not applicable.

**General Points (if any)**

- Proper cleanliness to be ensured while handling C276, C276 clad & titanium clad. No bare handling, lint free & starch free white hand gloves to be used.
- If any cleaning to be done in C276 & titanium, cleaning with spirit is recommended.
- Wrap the edges or EP if any with lint free white cloth or polythene cover to avoid dust accumulation.
- In case of fine polishing/cleaning Birla emery can be used.

**STORAGE AND HANDLING OF C276-CLAD & TITANIUM CLAD PLATES**

**Shipping Guidelines**

- C276/Titanium side of the casing panel to be protected
- Loading and Unloading has to be done carefully with suitable lifting equipment to avoid damage to the ends
- No part of chain should touch plate ends. Provide soft lined material at corners while lashing during transportation.
- The Consignment is to be protected from Rain/water ingress during transportation
- Good wooden block /Sleepers is to be used to prevent it from disintegrating due to load

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- The Consignment is to be prevented from Sliding/slipping during transportation
- Metallic Rubbing on C276 side is to be avoided

**Fabrication Guidelines**

- Handling of the plates shall be done carefully to avoid any damage to the ends.
- Major scratches on the C276/Titanium Side of the plate shall be avoided
- All clamps/ erection tools to be provided on the CS side of the plates No welding of clamps/erection tools to be carried out on the C276/Titanium Side of the plates.
- Any form of rolling/bending of the plates may be carried out with Soft Lined Roller facing the C276/Titanium side of the plates.
- Cutting of the plates shall be carried out preferably by grinding/ plasma cutting.
- **QP shall be strictly followed.**

**Storage Guidelines**

- The plates shall be stored in dry conditions, preferably in covered sheds to avoid corrosion on the CS Side of the plates.
- In case of Construction locations with limited storage conditions, complete protection shall be ensured from water ingress by using storage at raised platforms.
- Erectors are suggested to ensure that the height of the platforms on which the material is stored is high enough to ensure that water does not come in contact with the plates, as the MS Side of the plates is not corrosion resistant. Use of raised concrete platforms or concrete blocks is recommended for raising the height of the plates.
- Such plates stored in open, are suggested to be covered thoroughly with tarpaulin.
- Wooden blocks for raising the height of the plates is not suggested.
- It is suggested that the plates are segregated with separators to avoid scratches/ damage to the plates during lifting and transportation
- The construction staff shall regularly witness the storage conditions of the plates and ensure that the storage is compliant.