



CORPORATE PURCHASE SPECIFICATION

AA 10108

Rev. No. 10

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STRUCTURAL STEEL – STANDARD QUALITY (PLATES, SECTIONS, STRIPS, FLATS & BARS)

(ORDERING DESCRIPTION)

1.0 GENERAL:

This specification governs the quality requirements of structural steel plates, strips, flats, bars and sections such as angles, beams, channels and tees etc. of latest version of IS:2062 Grade E250 (Fe410W) Quality A.

2.0 APPLICATION:

For general engineering purpose.

3.0 CONDITION OF DELIVERY:

Plates, Bars & Sections : Hot rolled in straight lengths without twists & bends.

4.0 COMPLIANCE WITH NATIONAL STANDARDS:

4.1 Material shall comply with the latest requirements of IS:2062 Gr. E250 (Fe410W) Quality A.

4.2 Material offered to DIN EN 10025-1994 Gr. S 275JR is also acceptable. The tolerance on dimensions for plates shall comply with DIN EN 10029.

5.0 DIMENSIONS AND TOLERANCES:

5.1 Dimensions:

5.1.1 **Sizes:** Material shall be supplied to the dimensions specified on BHEL order.

5.1.2 **Length:** Unless otherwise specified, hot rolled bars and sections shall be supplied in 3 to 6 metres length.

5.2 Tolerances:

5.2.1 The tolerances on hot rolled material shall comply with IS:1852. However, no plate shall be under the specified thickness at any point.

Revisions :

CI: 30.4.0 of MOM of MRC_S & GPS

APPROVED :

INTERPLANT MATERIAL RATIONALISATION
COMMITTEE-MRC (S&GPS)

Rev. No. 10

Amd.No.

Reaffirmed

Prepared

Issued

Dt. of 1st Issue

Dt. Nov 2007

Dt :

Year :

HYDERABAD

Corp. R&D

JUL., 1976



5.2.2 Straight for hot rolled bars: Unless otherwise specified, the permissible deviation in straightness shall not exceed 5 mm in any 1000 mm length.

6.0 HARDNESS (BRINELL):

When tested in accordance with IS:1500, the material shall show a brinell hardness in the range of 120-156 HB.

Note: Hardness test shall be conducted only when tensile test cannot be performed.

7.0 TEST CERTIFICATES:

Unless otherwise specified, three copies of test certificates shall be supplied.

In addition, the supplier shall ensure to enclose one copy of the test certificate along with their dispatch documents to facilitate quick clearance of the material.

The test certificate shall bear the following information.

AA10108 Rev.10 / IS:2062 Grade: E250 (Fe410W) Quality A / DIN EN 10025 Gr. S275JR, BHEL order no., Melt no. Size, Results of chemical analysis and Mechanical tests, Supplier's name, Identification no. TC no., Signature of competent authority etc.

8.0 PACKING AND MARKING:

Plates shall be transported suitably to avoid damage during transit.

For plates below 10 mm thick, each pile (preferably of 16 plates) and each plate 10 mm thick & over shall be marked with Melt no. AA10108, BHEL order no., Supplier's name, Identification no., Size & weight on any one corner and encircled with paint preferably of white colour.

9.0 REFERRED STANDARDS (LATEST PUBLICATIONS INCLUDING AMENDMENTS):

- | | |
|-----------------|-----------------|
| 1. IS:2 | 2. IS:1500 |
| 3. IS:1599 | 4. IS:1608 |
| 5. IS:1852 | 6. IS:2062 |
| 7. DIN EN 10025 | 8. DIN EN 10029 |