

BHEL BHOPAL	SPECIFIC CONFIRMATIONS REQUIRED FROM SUPPLIER	CHECK LIST No. CL/CDE/093
STRAIGHT ALUMINUM 'L' FIN TUBE		
S.No.	TECHNICAL REQUIREMENTS	CONFIRMATIONS/COMMENTS OF SUPPLIER (YES/NO)

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| 01 | MATERIAL OF CONSTRUCTION | YES / NO |
| | a. TUBE : Admiralty Brass
to BHEL Spec. AA-12128 Rev.05 | |
| | b. FINS : Mat. to SB 209 Alloy 1100 IN
Φ Condition helically tension wound | |
| 02 | Tube size & winding details as per BHEL Drawing. | YES/NO |
| 03. | HEAT TREATMENT
Base tubes to be annealed (O61) tempered
in calibrated furnace | YES/NO |
| 04. | CONDUCTIVITY TEST
FINS : Check Conductivity Min. 59% IACS | YES/NO |
| 05. | MECHANICAL TEST
Base tube as per AA12128 Rev.05
including Hardness & Expansion Test | YES/NO |
| 06. | EDDY CURRENT TESTING OF BASE TUBE
As per ASTM-E-243
AMMONIA VAPOUR CRACKING TEST | YES/NO |
| 07. | HYDROSTATIC TESTING | YES/NO |
| 7.1 | Base Tubes :AT 70 Kg/sq.cm.(g) | |
| 7.2 | Finished 'L' Fin Tubes :AT 15 Kg/sq.cm.(g) | |
| 08. | Ammonia Vapor Cracking test & Microscopic Examination
on base tubes | YES/NO |
| 09. | TEST CERTIFICATES : Four(04) Copies of all Tests. | YES/NO |
| 10 | INSPECTION
By BHEL appointed inspection agency
as per the BHEL standard QA Plan as attached.
• All certificates to be duly signed & stamped
by the Inspection Agency. | YES/NO |
| 11. | Tube shall be completely free from Oil, Dust, Dirt
from Inside & Outside.
• Finned Tubes shall have to be dipped in suitable chemical solvent (solvent
shall not be detrimental for the base tube & fin material) for certain
duration followed by drying completely before packing finally. | YES/NO |
| 12. | <u>Base tubes to be procured from</u>
M/s Multimetal, M/s ITM, M/s Metal Alloy Corp. & M/s. Mehta Tubes only | YES/NO |
| 13. | CLEARLY SPECIFY ANY DEVIATION FROM BHEL
REQUIREMENTS OTHERWISE IT WILL BE CONSIDERED
THAT THE OFFER IS AS PER BHEL REQUIREMENTS. | |

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