

 CSU & FP, Jagdishpur		PLANT PURCHASE SPECIFICATION			No.	BHEL/FP/TS/46
		FABRICATION PLANT			Rev. No.	00
		DEPARTMENT: PRODUCTION			Rev. Dt.	
Technical Specification for Fuel Gas for Metal Cutting						
Sr.No.	Description	Requirement	Vednor to Furnish/Confirm	Offered	Deviation	Remark
1	General:					
1.1	Scope	This technical specification covers technical requirement of Fuel Gas for metal cutting.	Vendor to Confirm			
1.2	Application	The gas shall be used for Oxy Fuel Cutting of Carbon steel & low alloy steel of thickness upto 200 MM and preheating of welded assemblies.	Vendor to Confirm			
1.3	Equivalent	The gas shall have the properties equivalent to Bharat Metal Cutting Gas (BMCG) of M/s. BPCL.	Vendor to Confirm			
1.4	Exclusion	Dissolved Acetylene and LPG Shall not be considered.				
2	Broad Specification					
2.1	Neutral Flame Temp. (°C)	2983	Vendor to specify			
2.2	Total heat Value (Kcal/ kg)	12030	Vendor to specify			
2.3	Heat Emission (Kcal/m3)		Vendor to specify			
2.3.1	a. Primary Flame	4164	Vendor to specify			
2.3.2	b. Secondary Flame	19080	Vendor to specify			
2.4	Back fire Tendency	Low	Vendor to specify			
2.5	Toxicity	Low	Vendor to specify			
2.6	Explosive limit in Oxygen	24-57%	Vendor to specify			
2.7	Explosive limit in air	2.3-9.5%	Vendor to specify			
2.8	Normal Pressure in Cylinder	6-7 Kg/CM ²	Vendor to specify			
		Prepared By	Checked By	Approved By		
Signature		Vivek	WON		27.07.17	
Name		Vivek Srivastava	V K Choudhary		Raghvendra Singh	
Designation		Dy. Engineer	Dy. Manager		Sr. Manager	
Date of issue		27.07.17				

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3	Other Requirements:					
3.1	Gas Cylinder Manifold	Vendor to provide 2 nos. of gas cylinder manifold each having provision of 5 nos. cylinder connections fitted with regulators, connecting pipes and other fittings. Vendor to also supply 5 nos. spare of Pipe & Fittings for immediate maintenance. However, the regular maintenance of the same shall be also be done by the vendor time to time as per requirement.	Vendor to Confirm			
3.2	Supply Condition	The Gas shall be supplied in suitable size of cylinder as per applicable Gas Cylinder Rules 1981. The size shall be 19 kg/35 kg/50 Kg	Vendor to Confirm			
	Signature	Prepared By 	Checked By 	Approved By 		
	Name	Vivek Srivastava	V K Choudhary	Raghvendra Singh		
	Designation	Dy. Engineer	Dy. Manager	Sr. Manager		
	Date of issue	27.07.17				