

	CORPORATE PURCHASING SPECIFICATION	AA10647 Rev No.06 PREFACE SHEET			
CHROMIUM – MOLYBDENUM ALLOY STEEL PLATES, Gr.: 12, CLASS 2, FOR PRESSURE VESSELS FOR INTERNAL USE ONLY REMOVE THIS PREFACE BEFORE ISSUE TO SUPPLIERS Equivalent / Comparable Standards: 1) AMERICAN : ASME SA387, Gr.: 12, CLASS 2 Suggested/Probable Suppliers and Grades Refer plant vendor list User Plants and Replaced Plant Specifications/References: 1) HEEP, HARDWAR : 2) HEP, BHOPAL : 3) HPEP, HYDERABAD : HY10698, HY10699					
Revisions: As per Clause No.39.7.7 of MOM of MRC-FCF+HTM		APPROVED: INTERPLANT MATERIAL RATIONALISATION COMMITTEE – MRC(FCF+HTM)			
Rev No.06	Amd No.	Reaffirmed	Prepared	Issued	Dt. of 1 st Issue
Dt:05-01-2015	Dt:	Year:	HPBP, Trichy	Corp.R&D	March, 1979

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CHROMIUM – MOLYBDENUM ALLOY STEEL PLATES, Gr.: 12, CLASS 2, FOR PRESSURE VESSELS ORDERING DESCRIPTION FOR ASME SA387, Gr.: 12, CLASS 2		
1.0 GENERAL: The plates shall conform to the latest version for ASME SA387, Gr.: 12 Clause 2 and comply with the following additional requirements. 2.0 APPLICATION: For high temperature service at stress levels and temperatures allowed by ASME Boiler and Pressure Vessel Code, Section I and Indian Boiler Regulations for steam and water application. 3.0 MANUFACTURE: Steel shall be killed and vacuum degassed (S1). 4.0 HEAT TREATMENT: As per ASME SA387. 5.0 TEST SAMPLES: As per ASME SA387. 6.0 MECHANICAL PROPERTIES: Bend test as per S 14 of ASME SA20 shall be conducted. 7.0 ULTRASONIC TEST: Ultrasonic examination and acceptance standards shall be as per ASME SA578, level B. 8.0 INSPECTION: All the plates must be inspected at works by an Inspecting Authority and the test certificates must be countersigned by an Inspecting Authority recognised by Indian Boiler Regulations like Lloyds register of Shipping. 9.0 EDGE PROCESSING: Edge processing shall be accomplished by procedures which will not result in edge cracking.		
Revisions: As per Clause No.39.7.7 of MOM of MRC-FCF+HTM		APPROVED: INTERPLANT MATERIAL RATIONALISATION COMMITTEE – MRC(FCF+HTM)
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CORPORATE PURCHASING SPECIFICATION



10.0 MARKING:

- 10.1 Hard stamping of melt number, specification and grade, plate number and the inspection authority's stamp on the plates along rolling direction and bordered by white paint.
- 10.2 Painting of purchase order number, melt number specification number, size, net weight and BHEL on the plates and protected by transparent varnish coating.
- 10.3 Rust preventive coating for plates less than 20 mm thickness.

11.0 REPAIRS

Fusion welding is prohibited.

When done by mechanical means, the specified thickness is to be met with and the surfaces to be smoothly dressed up from any sharp edges.

12.0 CERTIFICATION

- 12.1 As per IBR form IV
- 12.2 In addition to the above, the following details shall be furnished with the test certificates:
 - a) Heat treatment status of the plate.
 - b) Heat treatment temperature, soaking time and cooling medium for mill test samples.

13.0 REJECTION AND REPLACEMENT

In the event of any material proving defective during the course of preparation, machining, testing or erection such material shall be rejected notwithstanding any previous certification of satisfactory testing and /or inspection.

14.0 REFERRED STANDARDS (Latest Publications Including Amendments):

- 1) ASME SA387
- 2) ASME SA578
- 3) ASME SA20

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CHROMIUM – MOLYBDENUM ALLOY STEEL PLATES, Gr.: 22, CLASS 2, FOR PRESSURE VESSELS					
ORDERING DESCRIPTION FOR ASME SA 387, Gr.: 22, CLASS 2					
1.0 GENERAL: The plates shall conform to the latest version for ASME SA 387, Gr.: 22 Cl. 2 and comply with the following additional requirements.					
2.0 APPLICATION: For high temperature service at stress levels and temperatures allowed by ASME Boiler and Pressure Vessel Code, Section I and Indian Boiler Regulations for steam and water application..					
3.0 MANUFACTURE: Steel shall be killed and vacuum degassed. (S 1).					
4.0 HEAT TREATMENT: As per ASME SA 387.					
5.0 TEST SAMPLES: As per ASME SA 387.					
6.0 MECHANICAL PROPERTIES: Bend test as per S 14 of ASME SA 20 shall be conducted.					
7.0 ULTRASONIC TEST: Ultrasonic examination shall be carried out as per ASME SA 578 (Supplementary requirements S 12 of SA 20) with acceptance level B.					
8.0 INSPECTION: All the plates must be inspected at works by an Inspecting Authority and the test certificates must be countersigned by an Inspecting Authority recognized by Indian Boiler Regulations like Lloyds Register of Shipping.					
Revisions: Cl: 29.6.14 of MOM of MRC-FCF+HTM			APPROVED : INTERPLANT MATERIAL RATIONALISATION COMMITTEE-MRC (FCF+HTM)		
Rev. No. 04	Amd.No.	Reaffirmed	Prepared	Issued	Dt. of 1st Issue
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**9.0 EDGE PROCESSING:**

Edge processing shall be accomplished by procedures which will not result in edge cracking.

10.0 MARKING:

- 10.1 Hard stamping of melt number, specification and grade, plate number and the inspection authority's stamp on the plates along rolling direction and bordered by white paint.
- 10.2 Painting of purchase order number, melt number specification number, size, net weight and BHEL on the plates and protected by transparent varnish coating.
- 10.3 Rust preventive coating for plates less than 20 mm thickness.

11.0 REPAIRS

Fusion welding is prohibited.

When done by mechanical means, the specified thickness is to be met with and the surfaces to be smoothly dressed up from any sharp edges.

12.0 CERTIFICATION

- 12.1 As per IBR form IV.
- 12.2 In addition to the above, the following details shall be furnished with the test certificates:
 - a) Heat treatment status of the plate.
 - b) Heat treatment temperature, soaking time and cooling medium for mill test samples.

13.0 REJECTION AND REPLACEMENT

In the event of any material proving defective during the course of preparation, machining, testing or erection such material shall be rejected notwithstanding any previous certification of satisfactory testing and /or inspection.