

PSGSG201 3-14/31	Product Specifications For ES LT SHIELD		Drg. No.	RDDG 4 35 0517 2316
			Date	25.04.14
			Product	GSM 245
1.0	Application : Switching Contacts for Gas Insulated Switchgear Equipment			
2.0	Configuration : 1. Sintered W-Cu (70-30 %), welded (by electron Beam welding process) to the Mild steel. 2. Machined to drawing dimensions.			
3.0	Quantity : 12 No.s			
4.0	Specifications: 1. Dimension Drawings : Refer Drg No. RDDG 4 35 0517 2516 2. Material: : Tungsten-Copper, Mild steel (a). W-Cu A sintered matrix of W-Cu (70-30 %) shall be produced by PM technique. The sintering shall be carried out in neutral or reducing atmosphere. The ingredient (powders) shall have high purity. (b). Mild steel mild steel (steel containing a small percentage of carbon, strong and tough but not tempered) Mild steel contains approximately 0.05–0.25% carbon ^L			
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5.0	Electron Beam Welding (EBW): The component shall be finished to size before electron beam welding at the interface. The interface will be between High conductivity copper- Cr alloy and W-Cu Tip. The interface shall be welded to full depth. The welding joint between Cu-Cr alloy and W-Cu tip shall exhibit minimum contact resistance. The Component shall be free from dirt, grease and loose particles.		
6.0	Tests: (a). Dimensional : All dimensions shall comply to drawing measures.		
7.0	Packing : The contacts shall be packed in high density cardboard boxes, with a primary wrapped in polyethylene and packed individually in dust free boxes after degreasing. The component shall be guaranteed against all manufacturing defects.		
8.0	General : 1. Surface finish of the components shall be at least RA 1.6. 2. The component shall be free from dirt, grease and loose particles. In case of doubts in drawings or specifications the supplier shall contact BHEL for clarifications.		
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