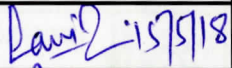
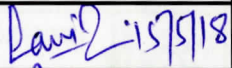
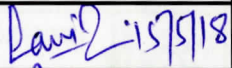
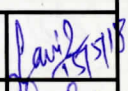


दिनांक एम हस्ताक्षर SIGN & DATE समग्री सूचित संख्या INVENTORY NO	सी एफ ई एल संस्थान क्रय विनिर्देश (सी एफ एफ पी) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF06031 Rev02 पृष्ठ का Page 1 of 3																																		
		समग्री सूचित संख्या को अधिग्रहित करें COPYRIGHT AND CONFIDENTIAL The information on this documents is the property of Bharat Heavy Electrical Limited It must not be used directly or indirectly in any way detrimental to the interest of the company																																		
COBALT ALLOY #6 INGOTS 1.0 General This Specification governs the quality requirements of Cobalt alloy #6 ingots. 2.0 Application The Ingots shall be remelted to make Castings 3.0 Compliance with National & International Standard There is no equivalent known national standard. References has been drawn from Cobalt alloy #6 under SAE AMS 5387 specification. 4.0 Properties 4.1 Chemical composition <table border="1"> <thead> <tr> <th>Element</th> <th>% minimum</th> <th>% maximum</th> </tr> </thead> <tbody> <tr> <td>Carbon</td> <td>1.0</td> <td>1.15</td> </tr> <tr> <td>Chromium</td> <td>26.0</td> <td>30.0</td> </tr> <tr> <td>Tungsten</td> <td>3.5</td> <td>5.5</td> </tr> <tr> <td>Silicon</td> <td>-</td> <td>2.0</td> </tr> <tr> <td>Iron</td> <td>-</td> <td>3.0</td> </tr> <tr> <td>Nickel</td> <td>-</td> <td>3.0</td> </tr> <tr> <td>Manganese</td> <td>-</td> <td>1.0</td> </tr> <tr> <td>Molybdenum</td> <td>-</td> <td>1.0</td> </tr> <tr> <td>Trace Elements</td> <td>-</td> <td>0.1</td> </tr> <tr> <td>Cobalt</td> <td>-</td> <td>Remainder</td> </tr> </tbody> </table> 4.2 Size & Shape The ingots can be in form of cuboids having length 150-250 mm, width 70-100 mm and thickness 70-100 mm. Alternatively, the ingots can also be in form of rounds of Dia 70-100 mm and length 150-250 mm. 4.3 The Ingots should be free from slag, dross, gas holes, pin holes and other harmful defects. 5.0 Acceptance The material shall be accepted on the basis of TC and GC given by the supplier. However BHEL shall check the properties as per Clause No. 4 on surveillance basis.				Element	% minimum	% maximum	Carbon	1.0	1.15	Chromium	26.0	30.0	Tungsten	3.5	5.5	Silicon	-	2.0	Iron	-	3.0	Nickel	-	3.0	Manganese	-	1.0	Molybdenum	-	1.0	Trace Elements	-	0.1	Cobalt	-	Remainder
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दिनांक एम हस्ताक्षर SIGN & DATE समग्री सूचित संख्या INVENTORY NO	Chairman PSC Dr. MS Rawat	RMI S N Ghosh	LF M Javed	अनुवादक TRANSLATED BY	निर्माणकर्ता WORKED BY	जांचकर्ता CHECKED BY	अनुमोदित APPROVED BY	सहमत विभाग Agreed Deptt	नाम Name	दिनांक एवं हस्ताक्षर Date and Signature	स्विकृति APPROVED :	संस्थान मानक समिति PLANT STANDARDS COMMITTEE	निर्माण: PREP: FOUNDRY TECH	जारी: फाउंड्री प्रौद्योगिकी ISSUED : FOUNDRY TECHNOLOGY	दिनांक DATE 15.5.18																					

दिनांक/संकेत SIGN & DATE		संस्थान क्रय विनिर्देश (सी एफ एफ पी) PLANT PURCHASE SPECIFICATION (CFFP - HARDWARE)		FF06031 Rev 02 पृष्ठ का Page 2 of 3							
सुपरसेड INVENTORY NO	6.0 Inspection, Deviation and Replacement 6.1 BHEL reserves the right to inspect the material at site before despatch. The supplier shall intimate in advance, enclosing a copy of Test Certificate of the material offered for inspection. The supplier shall extend all reasonable test facilities to BHEL representative without any charge to satisfy the later, that the material is being furnished in accordance with this specification. If the facilities are not available at supplier's works, he will make necessary arrangement for testing elsewhere without any cost. 6.2 If the material received at CFFP is found not in accordance with the specification, it shall be rejected and supplier will have to replace it free of cost at the earliest. 6.3 For any deviation from the specification demanded by the supplier prior approval of BHEL must be obtained in writing.										
सामग्री सूचित संख्या को अधिलिखित कर्ता	7.0 Test Certificate 7.1 Unless otherwise specified, one original and three copies of original manufacturer's test certificates shall be supplied with each consignment bearing the following information. In order to facilitate quick clearance of material, the supplier shall ensure to send a copy of test certificate along with despatch document: a) BHEL PO No. with Date b) Specification No. c) Supplier reference d) Identification No. / Batch No. e) Date of manufacture f) Properties as per Clause 4 g) Any other specific information which the supplier would like to convey. 7.2 Suppliers other than the original manufacturer shall ensure providing original manufacturer's test certificates with linkage to supplier's invoice stating the batch No., lot No., etc of the supply.										
COPYRIGHT AND CONFIDENTIAL The information on this documents is the property of Bharat Heavy Electrical Limited It must not be used directly or indirectly in any way detrimental to the interest of the company	8.0 Packing The material should be packed in 50 Kg. wooden crate to avoid damage during transport and storage. The packing should be that of original manufacturer. Each consignment should bear: i) Name of the product with supplier's name and Monogram ii) Gross weight and Net weight iii) Date of Manufacturing and Batch No. iv) BHEL PO NO.										
दिनांक/संकेत SIGN & DATE	इस प्रालेख में दी गयी सूचना भारत हेवी इलेक्ट्रिकल्स की संपत्ति है। इसका प्रत्यक्ष एवं अप्रत्यक्ष रूप में किसी भी तरह प्रयोग, जो की कंपनी के हित में नहीं है, न किया जाये										
सामग्री सूचित संख्या INVENTORY NO	<table border="1"> <tr> <td data-bbox="925 2038 1077 2105"> निर्माणकर्ता WORKED BY </td> <td data-bbox="1077 2038 1284 2105"> Lavin Agrawal </td> <td data-bbox="1284 2038 1538 2105">  </td> </tr> <tr> <td data-bbox="925 2105 1077 2172"> जांचकर्ता CHECKED BY </td> <td data-bbox="1077 2105 1284 2172"> R Lakra </td> <td data-bbox="1284 2105 1538 2172">  </td> </tr> </table>					निर्माणकर्ता WORKED BY	Lavin Agrawal		जांचकर्ता CHECKED BY	R Lakra	
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				पृष्ठ Page	का 3 of 3		
सामग्री सूचित संख्या को अधिगृहित कर्ता INVENTORY NO.	RECORD OF CHANGES						
SUPERSEDES INVENTORY NO.							
COPYRIGHT AND CONFIDENTIAL The information on this documents is the property of Bharat Heavy Electrical Limited It must not be used directly or indirectly in any way detrimental to the interest of the company	REV CODE	NO. OF CHANGES	Nature of change	SHEET NO.	SIGN	DATE	
	01	2	Clause 7 and 8 modified to incorporate original manufacturer's test certificate and packing condition	2		4.9.2009	
	02	2	Description of material modified to generic name. Equivalent international standard mentioned in Clause 3 Option of cylindrical shape of ingots added in Clause 4.2	1		15.5.2018	
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							RMI
							STANDARD SECTION MPIC
दिनांक एवं हस्ताक्षर SIGN &				निर्माणकर्ता WORKED BY	Lavin Agrawal		
सामग्री सूचित संख्या INVENTORY NO.				जांचकर्ता CHECKED BY	R Lakra	