

दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी. - हथियार) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF 06035 Rev 01 पृष्ठ का Page 1 of 3																							
सुपरसेड्स INVENTORY NO	स्वामी युक्ति संख्या को अधिकतम करना	WELDING CABLES – 400, 600 and 900 AMPS.																								
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bharat Heavy Electricals Limited. It must not be used directly, or indirectly, in any way, detrimental to the interest of the company.		1. Scope : This purchase specification specifies the requirements and tests for single core flexible cables used for manual electric arc welding on carbon steel and alloy steel castings.																								
		2. Compliance with National & International Standard : The welding Cables shall be in general as per IS 9857:1990 suitable for manual electric arc welding (current rating specified for 60% duty cycle) with the characteristics as stated under Technical specifications.																								
		3. Technical Specifications: 3.1. The welding cable shall be single core flexible cable suitable for manual electric arc welding. 3.2. The single core flexible welding cable shall be consisting of coaxial placed flexible circular conductor, separator and insulating covering. 3.3. The flexible circular conductor shall be of annealed high conductivity copper or aluminum multi strands wires confirming to IS 8130:1984. The nominal cross-section area of the conductor shall be not less than the nominal value specified in Table 1.																								
स्वतंत्राधिकार एवं गोपनीयता इस प्रलेख में दी गई सूचना भारत के ही इलेक्ट्रिकल्स की सम्पत्ति है। इसका प्रयोग एवं अप्रयोग इस से किसी भी तरह प्रयोग, जो कि कंपनी के हित में हथियारक हो न किया जाए।		TABLE - 1 <table border="1" data-bbox="365 1265 1445 1467"> <thead> <tr> <th>Description of Welding Cable</th> <th>Nominal Cross Sectional Area of Conductor, mm²</th> <th>Nominal Thickness of Covering, mm</th> </tr> </thead> <tbody> <tr> <td>Welding Cable (Copper) - 400Amp.</td> <td>50</td> <td>2.20</td> </tr> <tr> <td>Welding Cable (Copper) - 600Amp</td> <td>95</td> <td>2.60</td> </tr> <tr> <td>Welding Cable (Aluminum)-600Amp</td> <td>120</td> <td>2.80</td> </tr> <tr> <td>Welding Cable (Copper) - 900Amp</td> <td>120</td> <td>2.80</td> </tr> </tbody> </table>		Description of Welding Cable	Nominal Cross Sectional Area of Conductor, mm ²	Nominal Thickness of Covering, mm	Welding Cable (Copper) - 400Amp.	50	2.20	Welding Cable (Copper) - 600Amp	95	2.60	Welding Cable (Aluminum)-600Amp	120	2.80	Welding Cable (Copper) - 900Amp	120	2.80								
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हस्ताक्षर एवं दिनांक		3.4. The single core flexible cable shall be covered coaxial with a separator tap (material dry paper, polyester taps or other suitable material) to give complete covering of the conductor. 3.5. The insulating covering of the welding cable shall be able to with-stand 90°C temperature continuously during usage and shall be made of heat resisting, oil resisting and flame retardant (HOFR) normal duty elastomeric compound Type SE-3 confirming to the requirements of IS 6380:1984.																								
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स्वामी युक्ति संख्या INVENTORY NO		स्वीकृति प्लांट स्टैंडर्ड APPROVED : PLANT STANDARDS COMMITTEE निर्माण : वेल्डिंग टेक्नालॉजी PREPARED : WELDING TECH जारी : वेल्डिंग टेक्नालॉजी ISSUED : WELDING TECHNOLOGY दिनांक DATE : 10.10.06																								

17/10/06

दिनांक एवं हस्ताक्षर SIGN & DATE		संस्थान क्रय विनिर्देश (सी.एफ.एफ.पी - हार्डवयर) PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)	FF 06035 Rev 01 पृष्ठ का Page 2 of 3							
सामग्री सूची संख्या को अधिकतम करना INVENTORY NO	3.6. The covering shall be so applied that it fits closely on the taped conductor. The covering unless applied by extrusion method shall be applied in two or more layers. The colour of covering shall be black. The nominal thickness of the covering for cable shall be not less than the nominal value specified in Table 1. 4. Test Certificate: The vendor shall supply two sets of the test certificates along with dispatch documents at the time of delivery of welding cables to confirm the suitability of the welding cable to pass all the six tests as given below and described under section 10 and section 11 of IS 9857:1990. a) Annealing test b) Conductor resistance test c) Test for thickness of covering (as per section 3.6 above) d) High voltage test (water immersion test) e) Static flexibility test f) Flammability test 5. Welding Cable Identification : Each welding cable shall be marked with the following information throughout the length of the cable at every meter distance as per requirement of section 12 of IS 9857:1990 (a) Manufacturer's identification /trade mark , if any. (b) Cable identification, i.e., "HR 90". 6. Guarantee: The welding cable shall be guaranteed for 24 months from the date of receipt. 7. Packing and Marking: The welding cable shall be either wound on reels or drums or supplied in coils packed and labeled giving the information as per section 13.2 of IS 9857:1990. The packing should be suitable to avoid any damage during handling, transit and storage. 8. Special Requirements: a) The vendor shall send with offer the list of the industries with address to whom welding cables are supplied earlier. b) Final acceptance of welding cable shall be based on satisfactory report/ performance on shop floor.									
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सुपरसिड INVENTORY NO.		RECORD OF CHANGES					
समझी वृत्ति संख्या को अधिकतम करता		REV CODE	NO. OF CHANGES	DOCU. NO.	SHEET NO.	SIGN	DATE
COPYRIGHT AND CONFIDENTIAL The information on this document is the property of Bhaiji Harsidhi Electricals Limited. It must not be used directly or indirectly in any way detrimental to the interest of the company.		01	Title of standard is changed from "Welding cables-400 and 600Amps" to "Welding cables-400, 600 and 900Amp" to include the specification for welding cables for 900 amps also.		1		10.10.06
			Section 3.3 of Technical specifications is modified to include specifications for 900 amps cable also.		1		10.10.06
DISTRIBUTION OF PRINTS							
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		STANDARD SECTION		☒			
		MPIC		☒			
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