



Bharat Heavy Electricals Ltd
Boiler Auxiliaries Plant
Ranipet-632 406

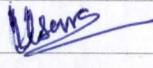
EDC/GATES & DAMPERS
TECHNICAL SPECIFICATION

SPECIFICATION NO: GDQS:038

REV NO:00

PAGE NO 01 OF 03

S/no	Item	Cold Rolled SS Coil	Vendor Acceptance/Comments
01	Scope of supply	Supply of cold rolled stainless steel coils as per the specification GDQS 038	
02	Size & Quantity	Refer Enquiry/Purchase Order	
03	Chemical Composition	Material should be as per ASTM A240 TYP 304 specification	
04	Production Process	Final sheet thickness shall be made by cold drawing with minimum reduction of thickness of about 20% (by Cold Rolling process) for getting required hardness.	
05	Dimensional Tolerances	a)Thickness-As per enquiry/PO. b)Thickness tolerance-As per ASTM B906 Table I. c)Width-Plus 0.5mm, minus 0mm. d)Flatness-1mm/Meter(max), when uncoiled & stretched. e)No.of waves-3 per meter(max). f)Camber-max 3mm for 2meter length. g)Coil ID-200mm(min) to 250mm(max). h)Coil OD-400mm max. i)Coil weight-50kgs, +/- 5kgs.	

00	19-09-16	Fresh Release	 V. Kesavan	 D. AswinDhinakar
REV	DATE	DESCRIPTION	PREPARED	APPROVED

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Sl. No.	Particulars	Description	Vendor Acceptance/Comments
06	Heat Treatment	The sheets will be supplied in cold drawn condition <i>without any heat treatment.</i>	
07	Mechanical Testing	Testing shall be done as per ASTM E8 & acceptance norms are below, a)Ultimate tensile strength (after 20% cold drawn)-779 MPa. (Minimum)	
		b)Yield strength(after 20% cold drawn)-668 MPa. (Minimum)	
		c)Hardness on finished sheet (after 20% cold drawn)- 240 VHN (Minimum)	
08	Freedom from defects	a)All sheets shall be free from harmful defects like cracks, lamination, etc. The surface shall be free from scales, rust, pitting, wrinkles.	
		b)Repair on finished coil is prohibited.	
09	Finish	The edges of coils shall be slit without fish tails and kinks. The coils should not contain any weld seam.	
10	Marking	Each coil shall be identified by Tag & also permanent stickers at ID & OD of the coil, a)Coil number. b)Specification. c)Size (thickness x width). d)Heat number. e)Weight of coil in Kgs. f)Length of coil in Meter. g)PO number. h)Manufacturers Identification.	

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Sl.no.	Item	Description		Vendor Acceptance/Comments/Deviations
11	Packing & Dispatch	a)It is the responsibility of the supplier to ensure that no damage occurs during transit.		
		b)Each coil shall be rigidly wrapped with gum tape so as to cover the entire coil and packed in polythene cover.		
		c)Coils shall be packed in a wooden box as per ASTM A700 Fig.No.78.		
12	Inspection & Certification	i) Inspection by BHEL or its authorized agency.		
		ii)All tests shall be complied as per the specification for each heat and the same shall be submitted along with supply.		
		iii)The test certificates shall furnish the following details legibly in English language only, a)BHEL Purchase Order number. b)Test certificate number. c)Specification & grade with applicable year of code. d)PO quantity & size. e)Melt number. f)Chemistry (melt wise). g)Mechanical test results-I) UTS & II) Hardness. h)Coil number & weight. i)Process of manufacturing with amount of cold reduction.		
13	Material code	SS304 cold rolled Coil 0.15X38	AA1072305011	
		SS 304 cold rolled Coil 0.15X57	AA1072305020	
		SS 304 cold rolled Coil 0.15X76	AA1072305038	
		SS 304 cold rolled Coil 0.15X82	AA1072305046	