



PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)

FF 05059 Rev01

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HIGH ALUMINA BOTTOM POURING SETS

1. SCOPE

This specification governs the quality requirement of **High Alumina Bottom Pouring Sets**.

2. APPLICATION

These are used as hollow refractory sleeves for gating system in pouring of ingot molds.

3. FREEDOM FROM CONTAMINATION

The material shall be compact and of homogenous texture. It should be free from cracks, voids, surface roughness and low melting spots. It should be free from extraneous contamination such as slag.

4. PROPERTIES:

4.1 CHEMICAL COMPOSITION:

The material shall conform to the following chemical composition when it is analyzed in
Accordance with IS: 1527:

ELEMENT	% MIN	%MAX
Al ₂ O ₃	60.0	
Fe ₂ O ₃	-	1.0

4.2. Apparent porosity: (% by Volume) 24-26

4.3. Pyrometric cone equivalent: 35 (Orton) min

4.4. Refractory sleeves are to be manufactured by wet process using grain size 2mm max.

5. SAMPLING AND METHOD FOR CHEMICAL ANALYSIS:

Each batch of the material shall be sampled in accordance with IS 1528 :

RMI	ARUN AGARWAL		WORKED BY	M.K.SAHU	
MPIC	ROHIT VARSHNEY		CHECKED BY	SUNIL KUMAR	
CHAIRMAN CPSC	V K AGARWAL		SUPERVISED BY	P.K ROY	
			APPROVED : PLANT STANDARDS COMMITTEE		
			PREPARED : SMS TECH	ISSUED : Steel Melting Shop	DATE : 14.08.2017



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6. INSPECTION AT SUPPLIER'S WORK

- CFFP reserves the right to witness the testing of the material at supplier works and therefore the supplier shall notify the readiness of the material in advance.
- If any specific inspection requirements are written in purchase order, the same shall be applicable.
- CFFP may test the material after receipt at CFFP on random basis and acceptance of the material will be based on the CFFP's test results.
- For result of analysis and properties of material the decision of CFFP shall be final and binding on the supplier.

7. TEST CERTIFICATES

One Original and three copies of Test Certificate from the Manufacturer in English containing the following information should be provided.

Manufacturer's Name

Name of the material

Batch/Lot No.

Lot Quantity.

Date of manufacturing.

Note:

- a) A manufacturer supplying directly to BHEL should include BHEL's P.O. No. and Challan No. also in the TC.
- b) Any other supplier should provide a covering letter along with original Manufacturer's TC as above mentioning BHEL's P.O. No. and Challan No.

8. PACKING AND MARKING

Packing should be such as to prevent loss / deterioration in quality during handling, transport and storage and should be by the manufacturer. Each package should be marked with the following details.

Name of the material

Manufacturer's Name / Trade mark

Batch/Lot No.

Net weight.

Date of manufacturing.

WORKED BY

M.K.SAHU

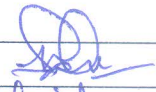
CHECKED BY

SUNIL KUMAR

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REVISION RECORD SHEET

SN	Revision No.	Revision date	Nature of Changes
1	01	14.08.2017	Clause 4: 4.1. Fe₂O₃ content decreased from 2% max.to 1%max.

ISSUED BY:	SMS	WORKED	M.K.SAHU	
REVISION	DATE:	CHECKED	SUNIL KUMAR	
AGREED	PLANT PUR. SPEC.COMMTTEE	APPROVED	P.P.S.C.	