



PLANT PURCHASE SPECIFICATION

(CFFP - HARDWAR)

FF 05040 Rev01

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HIGH ALUMINA LADLE BRICKS

1. SCOPE

This specification governs the quality requirements of Bauxite based high Alumina bricks used for lining of ladle.

2. APPLICATION

Used for making bottom and side lining of the ladle to hold liquid metal at max temperature of 1700 degree centigrade.

3. CONDITION OF DELIVERY

As per drawing attached in page no 3.

4. COMPLIANCE WITH NATIONAL STANDARDS

There is no national standard covering this type of materials.

5. FREEDOM FROM CONTAMINATION

The material shall be free from extraneous contamination such as slag.

6. PROPERTIES:

The material when analyzed in accordance with IS-1528 shall conform to following composition and values.

6.1 CHEMICAL COMPOSITION:

Al₂O₃ 69-72% minimum

Fe₂O₃ 1.5% maximum

6.2: Refractoriness : P.C.E 36 Orton minimum.

6.3: Bulk Density: 2.5 (gm/cc) minimum.

6.4: Apparent porosity: 23 % maximum.

6.5: CCS: 400(Kg/cm²) minimum.

6.6: PLC at 1500 °C for two hours: + 3.0 % maximum.

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

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7. 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, at its discretion, 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.

8. 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.

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.

9. PACKING AND MARKING

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

Name of the material

Manufacturer's Name / Trade mark

Batch/Lot No.

Net weight.

WORKED
BY

M.K.SAHU

CHECKED
BY

B K BEDI

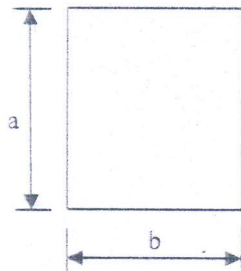


PLANT PURCHASE SPECIFICATION

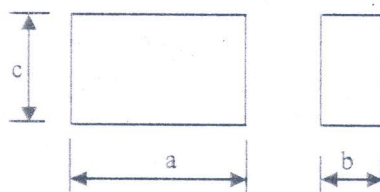
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MARK	a	b	c	d
I P 18	250	90	134	116
I P 8	250	90	129	121
2 P 24	250	123	137	113
2 P 10	250	123	130	120



MARK	a	b	c	d
P 40	230	40	114	-
S	230	113	125	-

TOLERANCE $\pm 2\%$ OR ± 2 mm, WHICHEVER IS GREATER.
ALL DIMENSIONS ARE IN mm.
DRG. NO. 23271013- Rev. 00

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REVISION RECORD SHEET

SN	Revision No.	Revision date	Nature of Changes
01.	01	14/08/2017	- Clauses 8 and 9 revised incorporating requirement of manufacturer's packing and Test certificate. - Clause no 6: Fe₂O₃ content revised from 3.5% max to 1.5 % max.

ISSUED BY:	SMS	WORKED	M.K.SAHU
REVISION	01	CHECKED	B K BEDI
DATE:		APPROVED	P.P.S.C.
AGREED	PLANT PUR. SPEC.COMMTTEE		