



CORPORATE PURCHASING SPECIFICATION

AA 107 25

Rev. No. 07

PREFACE SHEET

STAINLESS STEEL BARS (AUSTENITIC, Ti STABILIZED) SOLUTION ANNEALED (ASTM A 276M, TYPE 321)

FOR INTERNAL USE ONLY
REMOVE THIS PREFACE SHEET BEFORE ISSUE TO SUPPLIERS

Comparable Standards:

- | | |
|-------------|--|
| 1. AMERICAN | : ASTM A 276M,
Type: 321, Solution annealed |
| 2. INDIAN | : IS : 6603
Gr: 04Cr18Ni10Ti20, Solution annealed |
| 3. EUROPEAN | : EN 10088-3, Gr:X6CrNiTi18-10 |

Suggested/Probable Suppliers And Grades:

Refer Plant Vendors list

User Plant References:

- | | |
|-------------------|--------------------|
| 1. BHOPAL | : PS 105 06 - Bars |
| 2. HEEP - HARDWAR | : HW 021 02 99 |
| 3. HYDERABAD | : -- |

Revisions :

Cl. 32.6.5 of MOM of MRC-S&GPS

**APPROVED : Interplant Material
Rationalization Committee-MRC (S&GPS)**

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HARDWAR

Corp. R&D

June, '78



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STAINLESS STEEL BARS (AUSTENITIC, Ti STABILIZED) SOLUTION ANNEALED (ASTM A 276M, TYPE 321)

ORDERING DESCRIPTION

1.0 GENERAL :

This specification governs the quality requirements of Stainless Steel Bars (Austenitic, Ti Stabilized), Solution Annealed to the latest version of ASTM A 276M, Type 321 and comply with the following additional requirements.

2.0 APPLICATION :

For application requiring acid, corrosion and heat resistance and weldability.

3.0 CONDITION OF DELIVERY:

Cold / Hot rolled and solution annealed . Above 100 mm size, forged bars are acceptable. The ends of bars shall be square and true. The bars shall be supplied in straight lengths.

4.0 DIMENSIONS AND TOLERANCES

Bars shall be supplied to the dimensions specified on BHEL order. The tolerances on length, twist and straightness shall be as per ASTM A484M

5.0 CHEMICAL COMPOSITION :

As per ASTM A 276M, Type 321.

6.0 TEST CERTIFICATES :

Three copies of test certificates shall be supplied, unless otherwise stated on the order. In addition, the supplier shall ensure to enclose one copy of the test certificate along with their despatch documents to facilitate quick clearance of the material.

The test certificate shall bear the following information :

BHEL References :

AA 107 25-Rev. No.07 (ASTM A 276M, Type 321)
BHEL order No,

Revisions :

Cl. 32.6.5 of MOM of MRC-S&GPS

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Supplier's References :

Name

Identification No.

Melt No.

Details of heat treatment.

Result of Tests:

Dimensional inspection.

Results of chemical analysis, mechanical tests

7.0 PACKING AND MARKING :

Bars shall be suitably oiled and packed in boxes to prevent corrosion and damage during transit.

Each bar and flat over 50 mm in diameter or width across flats shall be stamped with 'AA 107 25 Rev 07(ASTM A 276M, Type 321)', melt No., BHEL order No., at one end or on the end face.

Bars bar/flat upto and including 50 mm in dia./width across flats shall be bundled together and tied with wire at 3 to 4 places along the length of the bars.

A metal label shall be securely attached to each bundle and shall bear the following information :

AA107 25 Rev 07 - Solution Annealed.(ASTM A 276M, Type 321)

BHEL Order No.

Consignment/Identification No.

Melt No.

Size and Weight.

Supplier's Name.

FOR INFORMATION ONLY**CHEMICAL COMPOSITION**

C	Si	Mn	Ni	Cr	S	P	Ti
≤ 0.08	≤ 1.0	≤ 2.0	9.0-12.0	17.0-19.0	≤ 0.030	≤ 0.045	5X(C+N)-0.70

Nitrogen content is to be reported for this grade.

MECHANICAL PROPERTIES

Hardness Max		0.2% PS min	UTS min	% El min	% Ra
HBS	HRC	N/mm ²	N/mm ²		
----	----	205	515	40	50