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	CORPORATE PURCHASING SPECIFICATION	AA54410 Rev No. 01 PAGE 1 of 2																		
HELIUM GAS – 99.995% PURE																				
1 GENERAL This specification governs the quality requirements of Helium gas of 99.995% purity. 2 APPLICATION For creating inert atmosphere during welding, fusion, leak proof test, etc. 3 COMPLIANCE WITH NATIONAL STANDARDS There is no national standard covering this type of gas. 4 FREEDOM FROM DEFECTS The gas shall be free from moisture and oxygen. 5 TEST SAMPLES Test samples shall be taken from one cylinder at random from each consignment for testing and approval. 6 PROPERTIES The gas shall show the following properties: Helium : 99.995%, min. Moisture : 5 ppm, max. Oxygen : 5 ppm, max. 7 TEST CERTIFICATES Three copies of test certificates shall be supplied along with each consignment, giving the following information: In addition, the supplier shall ensure to enclose one copy of the test certificate along with the despatch documents to facilitate quick clearance of the material. AA54410, Rev. 01: HELIUM GAS – 99.995% PURE BHEL Order No. Batch / Lot No. Supplier's/ Manufacturer's Name and Grade Test results of clause 6																				
<table border="1" style="width: 100%; border-collapse: collapse;"> <tr> <td colspan="3" style="padding: 2px;"> Revisions: As per clause 44.5.a) of MOM of MRC-CPO+NM </td> <td colspan="3" style="padding: 2px; text-align: center;"> APPROVED: INTERPLANT MATERIAL RATIONALISATION COMMITTEE – MRC(CPO+NM) </td> </tr> <tr> <td style="width: 16.6%; padding: 2px;">Rev No.01</td> <td style="width: 16.6%; padding: 2px;">Amd No.</td> <td style="width: 16.6%; padding: 2px;">Reaffirmed</td> <td style="width: 16.6%; padding: 2px;">Prepared</td> <td style="width: 16.6%; padding: 2px;">Issued</td> <td style="width: 16.6%; padding: 2px;">Dt. of 1st Issue</td> </tr> <tr> <td style="padding: 2px;">Dt:15-02-2004</td> <td style="padding: 2px;">Dt:</td> <td style="padding: 2px;">Year:2015</td> <td style="padding: 2px;">EDN, Bangalore</td> <td style="padding: 2px;">Corp.R&D</td> <td style="padding: 2px;">01-01-1990</td> </tr> </table>			Revisions: As per clause 44.5.a) of MOM of MRC-CPO+NM			APPROVED: INTERPLANT MATERIAL RATIONALISATION COMMITTEE – MRC(CPO+NM)			Rev No.01	Amd No.	Reaffirmed	Prepared	Issued	Dt. of 1 st Issue	Dt:15-02-2004	Dt:	Year:2015	EDN, Bangalore	Corp.R&D	01-01-1990
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8 PACKING & MARKING

The gas shall be supplied compressed in steel cylinders of suitable capacity provided with guard ring and duly painted. The design of cylinders, pressure of gas cylinders, painting labelling and transport of cylinders shall be in accordance with the 'Gas Cylinder Rules - 1940' of the Government of India with such modifications as may be ordered from time to time by the Chief Inspector of Explosives, Government of India or other duly constituted authority.

The cylinders shall also be marked with BIS certification mark.

The cylinders shall be painted with middle brown colour (colour code No. 411 of IS 5).

All cylinders shall be securely tagged with the following information:

AA54410: HELIUM GAS – 99.995% PURE

BHEL Order No.

Supplier's / Manufacturer's Name & Grade

Cylinder No.

Date packed

Quantity

Safety precautions/Marking: High pressure, ASPHYXIAN and other details, if any.

9 ENVIRONMENTAL REQUIREMENTS

The supplier shall furnish Material Safety Data Sheet (MSDS) covering all information relating to human safety and environmental impacts of the hazardous materials particularly during their transportation, storage, handling and disposal along with each supply.

Each container shall be marked with corresponding symbol and minimum worded cautionary notice for flammable / corrosive / toxic / harmful / irritant and oxidizing etc. as applicable.

10 REFERRED STANDARDS (Latest Publications Including Amendments)

- 1) IS 5