



PLANT PURCHASE SPECIFICATION (CFFP - HARDWAR)

FF 05039 Rev02

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COMPRESSED ARGON GAS

1. SCOPE

This specification governs the quality of Compressed Argon Gas.

2. APPLICATION

Used for Vacuum Spectrometer and purging of liquid steel.

3. CONDITION OF DELIVERY

The gas shall be supplied compressed in cylinders.

4. COMPLIANCE WITH NATIONAL STANDARDS

The material should conform to Indian Standard specification
IS : 5760-1998 Grade : 1

5. FREEDOM FROM CONTAMINATION

The Argon gas shall have no extraneous contamination.

6. PROPERTIES :

The argon gas should be of **ultra high purity** grade. The argon gas shall conform to the following characteristics when it is analyzed in accordance with IS: 5760-1998 Grade : 1.

Characteristic	MIN (PPM)	MAX (PPM)
Oxygen	-	0.5
Nitrogen	-	2.0
Hydrogen	-	1.0
Water Vapour	-	0.5
CarbonDioxide	-	0.5
CarbonMonoxide	-	0.5
Hydrocarbon	-	0.2

RMI	S.N.GHOSH	WORKED BY	M.K.SAHU
MPIC	SHYAM BABU	CHECKED BY	RANJAN
CHAIRMAN CPSC	K.B.SUBRAMANYAM	SUPERVISED BY	S.V.S.NARAYANA
APPROVED : PLANT STANDARDS COMMITTEE			
PREPARED : SMS TECH		ISSUED : Steel Melting Shop	DATE : 07-09-09



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7. INSPECTION

- 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.
- CFFP may, at its discretion, test the material after receipt and acceptance of the material will be based on the CFFP's test results.
- For any deviation from this specification prior approval shall be taken by the supplier.
- For result of analysis and properties of material the decision of CFFP shall be final and binding on the supplier.
- If the material is not conforming to this specification, it is liable to be rejected and the supplier shall replace the same.

8. TEST CERTIFICATES

One Original and three copies of Test Certificate from the **original manufacturer** containing following information should be provided.

Manufacturer's Name
Name of the material
Batch/Lot No.
Quantity.

Note:

- A manufacturer supplying directly to BHEL should include BHEL's P.O. No. and Challan No. also in the TC.
- 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

The gas shall be supplied compressed in cylinders. The design of cylinders, pressure of gas in cylinders, packing, marking, painting, labeling and transport of cylinders shall be in accordance with the 'Gas Cylinder Rules - 1981' 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. It should be in the **original manufacturer's packing**.

All cylinders shall be securely tagged with the following information :

Compressed Argon Gas Grade-1

BHEL Order No-

Supplier's/Manufacturer's Name & Grade :

Net & Gross Weight

The cylinders shall also be marked with the BIS certification mark.

WORKED
BY

M.K.SAHU

[Signature]

07/09/09

CHECKED
BY

RANJAN

[Signature]

07-09-09