

BHSL	PLANT PURCHASE SPECIFICATION	FF05025
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REFRACTORY CASTABLE

1. GENERAL

This specification governs the quality requirements of Refractory castable used in Forge and Foundry Furnaces. Vacuum degassing spray limiter and roof etc. of Arc. Furnaces.

2. APPLICATION

Used for repair of Burner blocks, Spray limiter, Arc furnace launders, Delta portion of roof, ladle patching, Reheating Furn. Doors, Bogie repair and Preheater hoods, furnaces.

3. TEST SAMPLES

As per IS : 1528

4. PROPERTIES

When tested in accordance with the relevant clauses of IS-1527 and IS-1528, mentioned against each, the test sample shall show the following values.

4.1. CHEMICAL COMPOSITION

The material when analysed in accordance with IS-1527 shall conform to following composition :-

Elements	Class A	Class K ₁	Class F
Al 203 (%)min.	90	60	55%
Fe 203 (%)max.	0.8	1.0	4.5%

4.2 GRADING

	0to5mm	0to5mm	0to5mm
4.3 C.C.S min. (at 110°C, Kg/cm sq)	600	350	300

4.4 P.L.C. (%)

1.10	1.5	1.0
AT 1500°C	1550°C	1350°C
/3 hrs	/3 hrs	/2 hrs

ISSUED :	SMS TECHNOLOGY	WORKED	<i>R.P. Singh</i>
REVISION	01, DATE: 26.02.01	CHECKED	<i>Singh</i>
AGREED	PLANT PUR. SPEC. COMMITTEE	APPROVED	P.F.S.C.

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	Elements	Class A	Class K	Class F
4.5	Dry Density (Kg/m ³)min.	2800	2200	2100
4.6	Refractoriness (°C)	1820	1683	1620
4.7	Service Temp. (°C)	1750	1600	1350

5. Whenever specified, tests and inspection are to be conducted in presence of BHEL's representatives. The supplier shall notify BHEL in advance about the readiness of the material for inspection and testing.

BHEL reserve the right to test one or all the properties of the material on surveillance basis at BHEL's works and final acceptance of material shall be based on these test results.

6. TEST CERTIFICATES

Unless and otherwise stated, three copies of test certificates shall be supplied along with each consignment giving following information. One copy may be enclosed with despatch documents to facilities quick clearance of the material.

FF 05025

Class

BHEL Order No.

Manufactures Name

Trade Mark, If any

Batch/Lot No.

Quantity Supplied

Tests results of clause 4

REVISION	01	DATE	26.02.01	WORKED	<i>Ref. 05025</i>
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7. PACKING AND MARKING

The material shall be suitably packed in 50 Kgs polythene bags/polythene gunny bags to prevent moisture pick up and to avoid damage during transit. Each consignment shall be legibly marked with following information :-

FF 05025

BHEL Order No.

Manufactures Name

Batch/Lot No.

Trade mark, If any

Qty supplied

REVISION	01	DATE	26.02.01	WORKED	Relapan
				CHECKED	2/11

CHABLES